

REDBAC ACID RESISTANT GROUT

K-011

EPOXY GROUT FOR ACIDIC AND HIGHLY CORROSIVE ENVIRONMENTS

- Grouting machine bases
- Setting anchor bolts
- Setting leveling wedges
- Setting sole plates
- Repairing deteriorated foundations
- Enhancing concrete surfaces

GENERAL PRODUCT INFORMATION

REDBAC Acid-Resistant Grout is a three component, 100 % solids epoxy resin system combining high mechanical strength with resistance to sulfuric acid, most fuels, oils, and water. REDBAC Acid-Resistant Grout mixes easily, self-levels, and cures quickly to minimize downtime and production loss. K-011 is an ideal grout for mining, oil field, and chemical plant applications.

WORKING TIME

The working time (the time you have before the grout sets) will vary according to the air temperature. The average working time at 70 °F (21 °C) will be about 20 minutes. In cooler weather you will have more time to pour, in hotter weather you will have less time.

CURE TIME

The average cure time from the last pour to machinery start-up will be 24 hours at 70 °F (21 °C). In cool weather, the grout will cure and develop strength more slowly than in hot weather.

HANDLING PROPERTIES @ 72 °F or 22 °C

SPECIFIC WEIGHT, g/cm ³	2.07	ASTM D-792
MIXED VISCOSITY, cP or mPa.s	20,000	ASTM D 2196
WORKING TIME, min	20	
GEL TIME, min	50-60	ASTM D 2471
MAXIMUM DEPTH OF POUR, in. (cm)	8 (20.3)	

PHYSICAL PROPERTIES (Cure Schedule: 7 days @ 72 °F or 22 °C)

COMPRESSIVE STRENGTH, psi (MPa)		ASTM D 695
after 6 h	11,200 (77)	
3 days	16,700 (115)	
7 days	17,500 (120)	
TENSILE STRENGTH, psi (MPa)	3,000 (21)	ASTM D 638
FLEXURAL STRENGTH, psi (MPa)	6,000 (41)	ASTM D 790
HEAT DISTORTION TEMPERATURE, °F (°C)	227 (108)	ASTM D-648
MAXIMUM CONTINUOUS SERVICE TEMPERATURE, °F (°C) (for non load-bearing applications)	325 (163)	
HARDNESS, Shore D	90	ASTM D 2240
Barcol	50	ASTM D 2583
WATER ABSORPTION (30 days @ 72 °F or 22 °C), %	0.12	
CREEP (24 hours @ 600 psi or 4 MPa load @ 150 °F (66 °C), in./in. or cm/cm)	5.59 x 10 ⁻³	ASTM C 181

CHEMICAL RESISTANCE

REDBAC Acid-Resistant Grout is resistant to these chemicals:

70 % Sulfuric Acid	50 % Phosphoric Acid	Motor Oil	Mineral Spirits
10 % Hydrochloric Acid	Ammonium Hydroxide	Leaded Gas	Trichloroethane
10 % Nitric Acid	50 % Sodium Hydroxide	Unleaded Gas	15% Sodium Hypochlorite
Xylene	Methanol	Acetone	
Diesel Fuel	Kerosene	Water	

APPLICATION INSTRUCTIONS

CONCRETE PREPARATION: Remove all oil, grease, or contaminated concrete. Chip the surface down to sound aggregate. The concrete must be **dry** and have no water in the anchor bolt holes. Light sand blasting or acid etching surface preparation procedures may result in poor bond and should be avoided. Do not prime or seal concrete surfaces.

FORMING: Standard wood or metal forming may be used. The forms should be protected with heavy coats of paste wax, grease, or form release agent. Wrapping the forms with heavy plastic is acceptable. The forms must be caulked and sealed to a liquid-tight condition.

When placing forms for grouting, it is absolutely necessary that the top of the forms be at least half way up the sides of the base plate or machine base. Placing the grout just to the bottom of the base plate will result in an improper grout job. If the forms cannot be placed half way up the side of the machine base, the minimum distance is 3/4 inch (1.9 cm) above the bottom of the machine base.

The forms should be placed between 2 and 6 inches (between 5 and 15 cm) away from the perimeter of the machine base to allow for the air to escape and to provide for a grout shoulder around the base plate.

PREPARATION OF METAL SURFACES: Base plates or sole plates to be grouted should be sand blasted to a "white metal" condition. If it is impossible to grout within 24 hours of sand blasting, the surfaces should be primed with a high-quality primer. Do not use porch and deck enamel or red-lead primer.

MIXING THE GROUT

3 Component Grouts (Resin, Hardener & Filler) - Open the pail or box and remove all the cans. Remove the filler (if present) from the pail. Pour the entire contents of the resin can into a pail or mortar mixer. Add 1/2 of the filler and mix for 1 minute. Pour the entire contents of the hardener can into the resin. Add the remaining filler and mix until uniform in color, usually 3 to 4 minutes. **DO NOT ADD ANY WATER.**

POURING/TEMPERATURE PRECAUTIONS: Always sweep (pour) from one side of the base toward the other to eliminate entrapped air. The storage temperature of the unmixed kits of REDBAC will greatly affect both the ease of pouring and the cure time. For best results, REDBAC kits should be stored in a warm room for at least 24 hours before use. Do not pour if the grout is below 50 °F (10 °C).

During cold weather (below 50 °F or 10 °C), it is important that the foundation be enclosed and maintained above 50 °F (10 °C). The cure time of the grout will be longer during cold weather and it is important that the grouted area be kept warm (above 50 °F or 10 °C) until the grout has cured completely.

CLEAN-UP: Uncured REDBAC grout can be removed from tools and equipment with Copps Enviro Kleen or isopropyl alcohol.

SAFETY PRECAUTIONS

Avoid breathing of vapors. Forced local exhaust is recommended to effectively minimize exposure. NIOSH approved, organic vapor respirators and forced exhaust are recommended in confined areas, or when conditions (such as heated polymers, sanding) may cause high vapor concentrations. **DO NOT WELD ON, BURN OR TORCH NEAR OR ON, ANY EPOXY MATERIAL. HAZARDOUS VAPOR IS RELEASED WHEN AN EPOXY IS BURNED.** Avoid skin or eye contact. Wash skin with soap and water if contact occurs. If eye contact occurs flush with water for 15 minutes and obtain medical attention. Read and understand all cautions on can labels and material safety data sheets before using this material.

PACKAGING/YIELD

K-011-63: 5 Gallon = 860 in.³ = 0.5 ft.³ = 8.93 l
K-011-125: Bulk = 1700 in.³ = 1.0 ft.³ = 0.03 m³

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