

SELECTION & SPECIFICATION DATA

Type	Structural vinyl ester grout												
Description	Acrocast Grout is a versatile 3-component structural vinyl ester grout designed with low shrinkage and low exotherm for grouting and casting applications. It may be placed in thicknesses as little as 3/4 inch (18 mm).												
Uses	<p>Concrete resurfacing</p> <p>Grouting heavy reciprocating equipment where heavy loads, chemical exposure or vibration may be a factor including:</p> <table border="0" style="margin-left: 40px;"> <tr> <td>Compressors</td> <td>Mixers</td> </tr> <tr> <td>Generators</td> <td>Fans</td> </tr> <tr> <td>Pumps</td> <td>Stamping machines</td> </tr> <tr> <td>Ball mills</td> <td>Paper mill machines</td> </tr> <tr> <td>Centrifuges</td> <td>Packaging machines</td> </tr> <tr> <td>Pedestals</td> <td>Piles</td> </tr> </table>	Compressors	Mixers	Generators	Fans	Pumps	Stamping machines	Ball mills	Paper mill machines	Centrifuges	Packaging machines	Pedestals	Piles
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Features	<ul style="list-style-type: none"> • Resistant to strong oxidizing agents and bleach solutions • Excellent vibration resistance • Good resistance to a broad range of chemicals and oils • High physical strength • Good bond to concrete and metal surfaces • Rapid strength gain 												
Limitations	<ul style="list-style-type: none"> • Requires use of forming for vertical applications • Not for use beyond its chemical resistance or thermal capabilities. Consult ErgonArmor with specific questions. 												

INSTALLATION GUIDANCE

Reference Specifications	CES-360 Installation of ErgonArmor Resinous Polymer Concretes	
Installation Conditions	<p>Acrocast Grout is formulated for ideal handling at 70°F (21°C). Materials and substrate should be acclimated to the air temperature prior to installation, and the air temperature should be between 50°F (10°C) and 90°F (32°C) during installation and cure.</p> <p>Substrate must be clean, dry and neutral pH.</p>	
Ratio	<p>1 gallon resin: 2-3 fl. oz. hardener by volume. 1 part catalyzed resin: 8.2 parts filler by weight.</p> <p>Filler loading may be adjusted slightly to suit flow preferences. Where higher flow characteristics are required, reduce filler loading by holding back up to 0.7 parts filler.</p>	
Mixing	Pour measured quantity of resin into clean, dry mixing vessel. Slowly add measured quantity of hardener to resin and mix thoroughly. Add filler and mix until filler is thoroughly wetted.	
Work Life	<p>1 hour at 70°F (21°C)</p> <p>Work life estimates are based on use of 2 fl. oz. CHP Hardener per 1 gallon resin. Increased hardener dosage will reduce work life. Work life is shorter at higher temperatures. A larger volume of mixed material will have a shorter work life than a smaller volume.</p>	
Cleanup	Xylene or MEK	
<u>CURE TIME</u>		
Temperature	Initial Set	Full Cure
70°F (21°C)	2 hours	3 days
<u>SAFETY</u>		
Safety	Mixes and applications of this product present a number of hazards. Read and follow the hazard information, precautions and first aid directions on the individual product labels and safety data sheets before using.	
Ventilation	Provide thorough air circulation during and after application until the material has cured when used in enclosed areas.	

PACKAGING, ESTIMATING & HANDLING

Product	Code	Packaging
Acrocast Resin Grey	19510	43 lb (5 gal or 19 l) pail
Acrocast Resin Clear	29646	43 lb (5 gal or 19 l) pail
CHP Hardener	19552	11.2 fl. oz. (0.7 lb) bottle
Tufchem™ Grout Filler	21931	60 lb (27 kg) bag

A 404 lb (3.04 cu ft) unit consists of 1 pail of resin, 1 bottle of hardener and 6 bags of filler. To enhance flow characteristics, it is permissible to hold back up to one half-bag of filler.

Theoretical Coverage

A 404 lb unit will yield approximately 3.04 cubic feet of grout. Yield will be reduced when filler loading is reduced.

Storage & Shelf Life

Maintain products in original packaging and sealed until ready for use. Estimated shelf life is 4-6 months for Acrocast Resin, 1 year for CHP Hardener, and 3 years for Tufchem Grout Filler. Actual shelf life may vary with storage conditions.

If there is any question with respect to the quality of the components check reactivity prior to use. For assistance consult with ErgonArmor.

TYPICAL PHYSICAL PROPERTIES

Property	Typical Value
Color	Gray, sand if using clear resin
Density, ASTM C138	135 lb/ft ³ (2,162 kg/m ³)
Compressive strength, ASTM C579	>13,500 psi (93 MPa)
Tensile strength, ASTM C190	>1,800 psi (12.4 MPa)
Flexural strength	>3,300 psi, (23 MPa)
Linear shrinkage, ASTM C531	0.12%
Absorption, ASTM C413	0.4%
Coefficient of thermal expansion, 75°F-210°F ASTM C531	16 x 10 ⁻⁶ /°F (28.8 x 10 ⁻⁶ /°C)
Modulus of elasticity, ASTM C580	1.34 x 10 ⁶
Minimum application thickness	0.75 inches (19 mm)
Slump using 8.2 filler: 1.0 mixed resin and hardener mix ratio	Approximately 3-5 inches (75-125 mm) with full filler loading.
	Flow characteristics of resinous polymer grouts are different from Portland cement grouts. Use caution when comparing flow values.

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