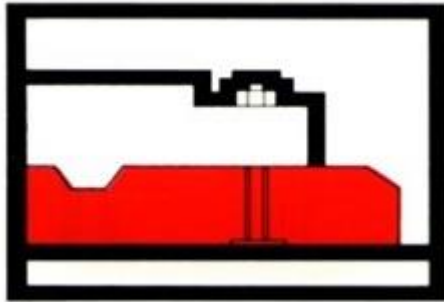
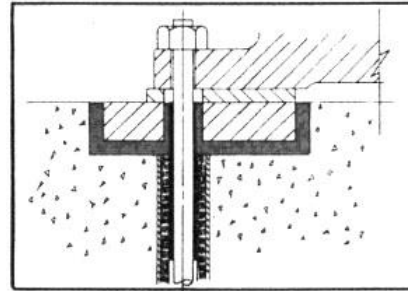


20kg PART NUMBER 9505-9550



FOR TOP ECONOMY IN GROUTING MACHINERY

PROOF OF STRENGTH: GROUTING 72 TONNE ENGINE-GENERATOR SET.



TECHNICAL DATA

Components	Resin, hardener and aggregate
Appearance (Resin)	Colourless to yellow
Appearance (Hardener)	Amber
Kit sizes	20kg

NORDBAK® Deep Pour Grout was used successfully to grout a 12 cylinder, 3700-hp diesel engine and 2650-kw generator. The engine weighs 52 t, and the generator with its outboard weighs 20 t. Before moving the engine into position, levelling shims were placed along the bottom of the foundation. The engine with its 18 support shims and six lengthwise rails was lowered into place and levelled by rail levelling screws. Then the complete foundation was grouted. The same procedure was followed for the generator.

NORDBAK® DEEP POUR GROUT: WHERE TO USE IT.

TYPICAL USES INCLUDE:

Diesel or gas engines	Gear cutting machines
Compressors	Engine test stands
Generators	Pulverizers
Blowers	Hammermills
Air conditioner units	Large pumps
Outboard bearings	Bridge seals, rail approaches
Punch presses	Structural columns
Jolt machines	

PHYSICAL PROPERTIES

Compressive Strength (ASTM D695)	131 MPa
Tensile Strength (ASTM D638)	17 MPa
Impact (Double Hammer)	52
Working Time at 21°C	30 minutes
Gel Time at 24°C.	60 minutes
Time to reach Operating Strength at 24°C	24 Hours

DESCRIPTION:

NORDBAK® Deep Pour Grout is a 100% solids co-polymer grout that offers unique advantages in its combination of strength and economy. It incorporates graded aggregate filler that greatly extends the volume of the mixed grout, with no significant loss of strength.

NORDBAK® Deep Pour Grout is designed for pours as deep as 150mm. Because of its semifluid consistency, it flows well under rails and sole plates, and is self-levelling. It firmly maintains critical alignments. Withstands high torque loading and vibration. Bonds securely to steel and concrete and is unaffected by operating temperatures up to 71°C. It sets up quickly, machinery is ready for use in 24 hours at 21°C.

For convenience, all components are packed in one container, which also serves as a mixing vessel. Mixing and application is a simple two-man job that requires no costly mixers or vibrators. Time consuming cleanup has been virtually eliminated.

APPLICATION SUGGESTIONS

TEMPERATURE

This material affects the working life of **NORDBAK® Deep Pour Grout**, that is, the length of time it remains relatively fluid after mixing the components. The lower the temperature, the longer the working life. The grout is formulated for fast and easy pouring at temperatures between 13°C and 21°C and has a working life at approximately 30 minutes. When temperature is above 35°C, immerse unopened containers in cold water for a few hours before mixing. In cold weather, store grout kits in a warm area and warm to at least 15°C before mixing. If possible, after pouring maintain temperature of at least 13°C for 24 hours or longer.

PREPARING FOUNDATION

Follow manufacturer's print. For best results provide a pouring area of 50mm or more between foundation and rail or sole plate. It may be advisable to chisel out pockets

NORDBAK® has a wide variety of resin systems now available. **Crusher:** NORDBAK® Fast-set and Deep Pour Grouts, NORDBAK® Trowel mix, NORDBAK® Primary, High Performance and Standard **Backing Compounds:** Wearing compounds include NORDBAK® **High Temperature Wearing Compound:** NORDBAK® High Temperature Pneu Wear, NORDBAK® Regular Wearing Compound, NORDBAK® Nordwear 5, Nordwear 8 and Nordtile wearing compounds and the Nordcoat Acid resistant coating range.

if access is restricted. The larger the access area, the greater the head pressure, and the better the grout will flow.

Pour grout as soon as possible after mixing. If the cavity is well vented, grout may be poured from one side provided all air is forced out from under rails or sole plates. A trough fashioned of tin or cardboard may be helpful in directing flow into restricted areas. Although the grout has excellent flow characteristics, you may wish to help it along with push rods or rebar. If desired, exposed surfaces may be finished with a thin layer of the resin and hardener only, without the aggregate, or a layer of **NORDBAK® Fast Set Grout**.

HOW TO MIX NORDBAK DEEP POUR GROUT:

All components – resin, hardener and aggregate – are packed in a sealed 20kg pail for ease of handling and mixing. Since all ingredients are pre-measured, mixing in batches less than kit size is not recommended. Normally, in fact, several kits will be mixed at once.

MIXING EQUIPMENT:

The only equipment needed is a 13mm electric drill and a triangular mixing paddle 100mm on each side, constructed of 12mm rebar or steel rod, with a finished overall length of 350mm to 400mm, to reach the bottom of the pail without immersing the drill chuck.

MIXING INSTRUCTIONS:

- After opening container, remove plastic bucket and plastic bottle.
- Mix aggregate by hand or with trowel until stone and powder are mixed.
- Pour contents of plastic bucket over aggregate and using a slow speed drill (400rpm) mix until a paste mixture is achieved.
- Add contents of plastic bottle and mix thoroughly to a uniform consistency.
- Pour contents directly into areas where Grout is required with a minimum of delay – maximum 10 minutes.

CURING SCHEDULE:

Temperature	12,8°C	21,1°C	26,7°C	32,2°C
Working time after mixing (min)	45	30	20	15
Cure time (hours)	36	24	20	18

KIT CONTAINS:

Resin, hardener, graded aggregate, all in sealed 20kg container.

VOLUME OF MATERIAL:

10,4 litre after mixing.

TECHNICAL TIPS FOR WORKING WITH DEEP POUR GROUT:

Working time and cure depends on temperature and mass:

- The higher the temperature, the faster the cure.
- The larger the mass of material the faster the cure.

To speed up the curing time at low temperatures:

- The lower the temperature, the longer the cure.
- In cold weather, store kits in a warm area and warm the resin between 15 -25°C before mixing.
- Pre-heat surface until warm to the touch.

To slow the curing time at high temperatures:

- Mix kit in small masses to prevent rapid curing.

DO NOT MIX RESIN AND HARDENER UNTIL READY TO COMMENCE.

PROTECTION:

- All work is to be done in a well-ventilated area.
- Overalls, rubber gloves and eye protection required.
- Refer to Material Safety Data Sheet.

STORAGE:

Store indoors on pallets at temperatures between 10°C and 35°C. Keep container tightly closed and away from acids and oxidizers. If product is removed from container do not return it to original container as contamination may have occurred.

DISCLAIMER:

The information provided in this data sheet including the recommendations for use and application of this product are based on our knowledge and practical experience and laboratory tests of the product as at the date hereof. This data sheet shall be used as a guide to the user's application.

This product has been designed for specific applications based on normal working and operating conditions, and although it may be used in different applications and working conditions such instances are beyond our control. Therefore Nordbak shall not be liable for the suitability/merchantability of our product in your application unless we have specifically advised so in writing. Accordingly, we advise that you conduct your own investigations to confirm the suitability of our product, as it ultimately remains the user's responsibility to protect property and persons against hazards emanating from the handling and use thereof. Accordingly, any civil liability as a result of damages, injury, or death, in respect of the information in this data sheet, or any other written or oral recommendation(s) regarding the suitability of this product, are hereby excluded. Furthermore Nordbak shall not be liable under any circumstances for any consequential or incidental damages of any kind, including but not limited to loss of profits.

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