

RESIN GROUTING COMPOUND

**LOW VISCOSITY FOR EASY POURING
QUICK STRENGTH DEVELOPMENT
GENERAL PURPOSE LIQUID ADHESIVE**

PRINCIPAL USES

Grouting reinforcing bars, holding down bolts, etc. Refer to Pro-Struct 618LV for injection of cracked structures. When mixed with Graded aggregate # 622, a versatile grouting compound is produced. Refer to Pro-Struct 618/22 data.

RESISTANCE

Resists most common aggressive chemicals, aliphatic solvents and petroleum products.

TYPICAL MECHANICAL PROPERTIES

Steel to steel bond strength (Shear)	8 MPa
Compressive strength	50-60 MPa
Concrete to concrete bond strength	Concrete fails

SPECIFICATION

Apply Pro-Struct 618 Grouting Compound in accordance with manufacturers detailed instructions. Refer to Pro-Struct 618LV Crack Injection specification under adhesive section.

INSTRUCTIONS

Prior to application, the surface must be clean, dry and sound and surfaces should be prepared in accordance with method 1 or 3 of Surface Preparation Specification and primed with Pro-Struct 618R if necessary. Pro-Struct 618R is supplied in two attached containers which are separated by prising off the upper tin. The contents of the small container should then be poured into the larger container and stirred thoroughly for 4 to 5 minutes. After mixing, use material within 60-90 minutes, applying into wet primer if required. Should less than the complete kit be used, two parts by volume of the base should be mixed with one part by volume of the activator. Clean equipment immediately after use with Pro-Struct 105 Brush Cleaner and rinse off in clean water.

CAUTION

Under no circumstances should Pro-Struct 105 Brush Cleaner be mixed with any Pro-Struct Epoxy Compound as this will inhibit the curing of the material. To avoid confusion, Pro-Struct 105 Brush cleaner is coloured blue. Remove spots of Pro-Struct Epoxy on hands with cotton waste dipped in water.

Always wash well with soap and water after using this material.

See also Instruction Sheet "Handling of Epoxy Products"

TYPICAL PROPERTIES AT 25°C

Finish	Gloss
Colour	Dark Amber
Consistency	Liquid
Volume Solids	100%
Theoretical Coverage	1lt/m ² at 1mm thick
No. of Components	2
Mix Ratio by Volume	2:1
Pot Life	60 – 90 Minutes
Apply Over	Clean concrete or steel
Apply By	Pouring / Trowelling
Curing Time	24 Hours at 25°C
Thinner	Nil
Shelf Life	12 Months
Max Service Temperature	60°C
Application Temperature Range	15°C to 35°C

APPLICATION INSTRUCTIONS

These instructions are not intended to show product recommendations for specific service. They are issued as an aid in determining correct surface preparation, mixing instructions and application procedure. It is assumed that the proper product recommendations have been made. These instructions should be followed closely to obtain the maximum service from the materials.

FORMULA FOR CALCULATING MATERIAL USAGE

METHOD FOR CALCULATING RESIN USAGE IN LITRES FOR GROUTING REINFORCING BARS, HOLDING DOWN BOLTS, ETC.

$$\text{No. OF LITRES} = \frac{0,8 (D - d) (D + d) ht}{1\ 000\ 000} \times \text{No. OF HOLES}$$

WHERE
D = Diameter of hole
d = Diameter of bar or rod
ht = Depth of hole

NB: Take ALL dimensions in mm

Note: Diameter of hole should be 1,25 – 1,5 times diameter of bar or rod.

Depth of hole should be 10 times diameter of bar or rod for reinforced concrete and 15 times for mass concrete.

ALLOWABLE SPACING AND EDGE DISTANCE (D = ANCHOR DIAMETER)

	Distance for full anchor capacity (Critical Distance) ¹	Distance for reduced anchor capacity
Edge Distance – Tensile Load	12D	4D
Spacing Between Anchors	24D	8D
Edge Distance – Shear Load	12D	4D

CAUTION: MAY CONTAIN FLAMMABLE SOLVENTS. KEEP AWAY FROM SPARKS AND OPEN FLAMES. IN CONFINED AREAS WORKMEN MUST WEAR FRESH AIRLINE RESPIRATORS. HYPERSENSITIVE PERSONS SHOULD WEAR GLOVES OR USE PROTECTIVE CREAM. ALL ELECTRONIC EQUIPMENT AND INSTALLATIONS SHOULD BE MADE AND GROUNDED IN ACCORDANCE WITH THE NATIONAL ELECTRICAL CODE. IN AREAS WHERE EXPLOSION HAZARDS EXIST, WORKMEN SHOULD BE REQUIRED TO USE NONFERROUS TOOLS AND TO WEAR CONDUCTIVE AND NONSPARKING SHOES



StonCor Africa (Pty) Ltd

Co. Reg. No. 1996/001848/07

Tel: +27 (0)11 254 5500

Website: www.stoncor.co.za

E-mail: stoncorsa@stoncor.com