



FIVE STAR[®] DP EPOXY GROUT

Dual-Purpose, Deep Pour Precision Grout

PRODUCT DESCRIPTION

Five Star DP Epoxy Grout is the only expansive, nonshrink, low exotherm epoxy system for machinery grouting. This versatile, dual-purpose product is formulated for single, large volume placements and may be used as thin as 1 inch (25 mm) in depth. Five Star DP Epoxy Grout is a three component, 100% solids, solvent-free system formulated to provide high strength and superior creep resistance combined with the highest effective bearing area. Five Star DP Epoxy Grout exhibits positive expansion when tested in accordance with ASTM C 827.

ADVANTAGES

- Permanent support for machinery requiring precision alignment
- Low exotherm with early strength development
- Long working time
- Solvent-free clean up
- Adjustable flow for various conditions
- Expansive, nonshrink, ASTM C 827
- Superior creep resistance
- Chemically resistant
- 95% Effective Bearing Area (EBA)
- Adhesion to steel

USES

- Large volume applications
- Foundation rebuilds and skid mounted equipment
- Precision alignment under dynamic load conditions
- Vibration dampening for rotating equipment
- Support of chemical tanks, vessels and rotating equipment
- Aggressive chemical environments
- Installation of anchors and dowels

PACKAGING AND YIELD

Five Star DP Epoxy Grout is a three component system consisting of partially filled containers of resin, hardener and bags of aggregate. Available in units yielding approximately two cubic feet (56.6 liters) of hardened material when using five bags of aggregate (Standard). When maximum flow is required, up to one bag of aggregate can be withheld to enhance flow (High Flow) which reduces yield to approximately 1.75 cubic feet (49.6 liters) of hardened material.

SHELF LIFE

Two years in original unopened packaging when stored in dry conditions. Before use and for optimum performance, condition material to between 70°F and 90°F (21°C and 32°C).

TYPICAL PROPERTIES AT 73°F (23°C)

	DP Epoxy Grout (Standard)	DP Epoxy Grout (High Flow)
Aggregate Content	5 Bags / Unit	4 Bags / Unit
Clearances	1 -18 inches (25 - 457 mm)	1 to 9 inches (25 - 229 mm)
Height Change, ASTM C 827, at 90°F (32°C)	Positive Expansion	Positive Expansion
Effective Bearing Area	95%	95%
Creep, ASTM C 1181, 1 year 400 psi (2.8 MPa) 140°F (60°C)	3.7 x 10 ⁻³ in/in (mm/mm)	4.3 x 10 ⁻³ in/in (mm/mm)
Tensile Strength, ASTM C 307	2100 psi (14.5 MPa)	2000 psi (13.8 MPa)
Flexural Strength, ASTM C 580	3800 psi (26.2 MPa)	4000 psi (27.6 MPa)
Coefficient of Expansion, ASTM C 531	17 x 10 ⁻⁶ in/in/°F (30 x 10 ⁻⁶ mm/mm/°C)	18 x 10 ⁻⁶ in/in/°F (32 x 10 ⁻⁶ mm/mm/°C)
Bond to Concrete, ASTM C 882	Concrete Failure	Concrete Failure

Compressive Strength ASTM C 579 B*	Standard Compressive Strength psi (MPa)	Standard Compressive Modulus psi (MPa)	High Flow Compressive Strength psi (MPa)	High Flow Compressive Modulus psi (MPa)
1 Day	11000 (75.9)	1.5 x 10 ⁶ (10.4 x 10 ³)	9000 (62.1)	1.4 x 10 ⁶ (9.7 x 10 ³)
7 Days	14000 (96.6)	2.0 x 10 ⁶ (13.8 x 10 ³)	13000 (89.7)	1.9 x 10 ⁶ (13.1 x 10 ³)
Post cured at 140°F (60°C)	17000 (117.2)	2.2 x 10 ⁶ (15.2 x 10 ³)	16000 (110.3)	2.0 x 10 ⁶ (13.8 x 10 ³)

*Materials tested per ASTM C 579 B. Rate of loading 0.25 inches per minute. The data shown above reflect typical results based on laboratory testing under controlled conditions. Reasonable variations from the data shown above may result. Test methods are modified where applicable.



PLACEMENT GUIDELINES

SURFACE PREPARATION: All surfaces to be in contact with Five Star® DP Epoxy Grout shall be free of oil, grease, laitance and other contaminants. Concrete must be clean, sound, dry and roughened to ensure a good bond. An SSPC-SP6 commercial finish on all metal surfaces will optimize bond development to steel.

FORMS AND ISOLATION JOINTS: Formwork shall be constructed of rigid nonabsorbent materials, securely anchored, liquid tight and strong enough to resist forces developed during grout placement. The clearance between formwork and baseplate shall be three to five inches (75 to 125 mm) to allow for headbox. The clearance for remaining sides shall be one to two inches (25 to 50 mm). Areas where bond is not desired must be treated with paste wax or polyethylene. Isolation joints may be necessary depending on pour dimensions.

AGGREGATE CONTENT: Maximum aggregate content of Five Star DP Epoxy Grout should be used whenever possible. For increased flowability in cold temperatures, tight clearances or long flow distances, aggregate content may be reduced to four bags per unit.

MIXING: For optimum performance, all components should be conditioned to between 70°F and 80°F (21°C and 27°C) prior to use. Pour all Component B (hardener) into pail containing Component A (resin). Mix thoroughly by hand with paddle or slow speed mixer to avoid air entrapment. Pour mixed liquids into mortar mixer. While mixing, slowly add Component C (aggregate) and mix only until aggregate is completely wet. Add Component C (aggregate) immediately after mixing Component A (resin) and Component B (hardener). Working time is approximately 90 minutes when temperatures are at 73°F (23°C).

METHODS OF PLACEMENT: Five Star DP Epoxy Grout may be poured into place. All grouting shall be placed from one side to the other, maintaining contact with the bottom of the baseplate at all times. For clearances greater than eighteen inches (457 mm) and or more than 100 cubic feet (2.8 cubic meter), call the Five Star Products Technical Center at (800) 243-2206.

POST-PLACEMENT PROCEDURES: Final finishing of exposed surfaces is aided by using a solvent wiped trowel just before material becomes unworkable. In-service operation may begin immediately after minimum required grout strength and modulus have been achieved.

CLEAN UP: All tools and equipment may be cleaned with a water and strong detergent solution before material hardens. Sand may be used as an abrasive. A suitable solvent is required for clean up of material after hardening.

NOTE: PRIOR TO APPLICATION, READ ALL PRODUCT PACKAGING THOROUGHLY. For more detailed placement procedures, refer to Design-A-Spec™ or call the Five Star Products Engineering and Technical Center at (800) 243-2206.

LIMITATIONS

- Flowability and strength gain are adversely affected by lower temperatures.
- For placement temperatures between 50°F and 70°F (10°C and 21°C) or above 90°F (32°C), or contact the Five Star Technical Center.
- To obtain bond, concrete shall be visibly free of surface moisture.
- When clearances are outside the recommended range or when exceeding maximum placement volumes, contact the Five Star Products Technical Center.
- Do not add solvents to increase flowability.
- For continuous operating temperatures exceeding 180°F (82°C), contact the Five Star Products Technical Center.
- Construction practices dictate concrete foundation should achieve its design strength before grouting.

CAUTION

Irritant, toxic, strong sensitizer. Contains epoxy resin and amine. This product may cause skin irritation. Do not inhale vapors. Provide adequate ventilation. Protect against contact with skin and eyes. Wear rubber gloves, long sleeve shirt, goggles with side shields. In case of contact with eyes, flush repeatedly with water and contact a physician. Areas of skin contact should be promptly washed with soap and water. Do not take internally. Keep product out of reach of children. PRIOR TO USE, REFER TO MATERIAL SAFETY DATA SHEET.

For worldwide availability, additional product information and technical support, contact your local Five Star distributor, local sales representative, or you may call Five Star's Technical Center at (800) 243-2206.



Five Star Products, Inc.
Corporate Headquarters
750 Commerce Drive
Fairfield, CT 06825
Tel: 203-336-7900
Fax: 203-336-7930
<http://www.fivestarprouducts.com>

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