



FIVE STAR[®] DP HIGH FLOW EPOXY GROUT

Dual-Purpose, Deep Pour Precision Grout

PRODUCT DESCRIPTION

Five Star DP High Flow Epoxy Grout is the only expansive, nonshrink, low exotherm epoxy system for machinery grouting. This versatile, dual-purpose product is both formulated and packaged for single, smaller volume placements and may be used as thin as 1 inch (25 mm) in depth. Five Star DP High Flow 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 High Flow 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
- Expansive, nonshrink, ASTM C 827
- Superior creep resistance
- Chemically resistant
- 95% Effective Bearing Area (EBA)
- Adhesion to steel

USES

- Inverted pump grouting
- Small 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
- Installation of anchors and dowels

PACKAGING AND YIELD

Five Star DP High Flow Epoxy Grout is a three component system consisting of partially filled containers of resin, hardener and one bag of aggregate. Available in a unit yielding approximately 0.44 cubic feet (12.5 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)		
Aggregate Content	1 Bags / Unit	
Clearances	1 to 9 inches (25 - 229 mm)	
Height Change, ASTM C 827, at 90°F (32°C)	Positive Expansion	
Effective Bearing Area	95%	
Creep, ASTM C 1181, 1 year 400 psi (2.8 MPa) 140°F (60°C)	4.3 x 10 ⁻³ in/in (mm/mm)	
Tensile Strength, ASTM C 307	2000 psi (13.8 MPa)	
Flexural Strength, ASTM C 580	4000 psi (27.6 MPa)	
Coefficient of Expansion, ASTM C 531	18 x 10 ⁻⁶ in/in/°F (32 x 10 ⁻⁶ mm/mm/°C)	
Bond to Concrete, ASTM C 882	Concrete Failure	
Compressive Strength, ASTM C 579 B*	Compressive Strength psi (MPa)	Compressive Modulus psi (MPa)
1 Day	9000 (62.1)	1.4 x 10 ⁶ (9.7 x 10 ³)
7 Days	13000 (89.7)	1.9 x 10 ⁶ (13.1 x 10 ³)
Post cured at 140°F (60°C)	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 High Flow 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.

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 seven gallon container or mortar mixer. If mixing in the seven gallon container, use a large Jiffy type mixer blade with a 3/4" drill. Slowly add approximately 1/3 of Component C (aggregate) and begin mixing. Continue adding the remainder of aggregate and mix only until it is completely wetted out. Add Component C (aggregate) immediately after mixing Component A (resin) and Component B (hardener). Working time is approximately 75 minutes when temperatures are at 73°F (23°C).

METHODS OF PLACEMENT: Five Star DP High Flow 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 nine inches (228 mm) and or more than 50 cubic feet (1.4 cu m), 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 or solvent solution before material hardens. Sand may be used as an abrasive.

NOTE: PRIOR TO APPLICATION, READ ALL PRODUCT PACKAGING THOROUGHLY. For more detailed placement procedures, call the Five Star Products 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), 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 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.



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