



## CEMENTITIOUS Grouts Equipment/Baseplate Preparation

Five Star® cementitious grouts will not bond to grease, oil, paint, primers, or epoxy coatings that are sometimes found on the underside (the contact surface) of the equipment/baseplate. All metal surfaces of equipment/baseplates which are in direct contact with the grout shall be thoroughly cleaned. Surfaces where bond is not desired (jack bolts, anchor bolts, finish surfaces, etc.) must be adequately protected with “bond break materials” to ensure grout does not adhere/bond to them.

Prior to grouting, the equipment/baseplate needs to be properly aligned and secured. A 2 inch (50 mm) minimum clearance for grouting under the equipment/baseplate is recommended. The configuration of shear keys, stiffeners, channels, etc. needs to be known to plan proper grouting. Air relief holes, ½ inch (13 mm) diameter minimum, should be installed at high spots and “air trap locations”. When utilizing a headbox does not provide adequate flowability, minimum 6 inch (152 mm) grout fill holes should be installed in the equipment/baseplate.

Shims/jack screw landing plates should have radiused corners and should be a minimum of 2 inches (50 mm) from the edge of the baseplate. For more details refer to Five Star® Technical Bulletin 400 *Shim Shape Recommendation*.

**For information 1-800-243-2206 ▪ FiveStarProducts.com**

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**FIVE STAR PRODUCTS, INC.**  
2 Enterprise Drive ▪ Suite 303  
Shelton, CT 06484 USA  
Phone: +1 203-336-7900