

## PRODUCT DATA SHEET

# Sikadur<sup>®</sup>-42 Grout Pak LE

### PRE-PROPORTIONED, PRECISION EPOXY GROUTING SYSTEM

#### PRODUCT DESCRIPTION

Sikadur<sup>®</sup>-42 Grout Pak LE, is a high strength, multi purpose, three-component, low exotherm, low dusting, solvent-free, moisture-insensitive, epoxy grouting system designed to seat and support high demand equipment.

#### USES

Sikadur<sup>®</sup>-42 Grout Pak LE may only be used by experienced professionals.

- Precision seating of baseplates
- Grouting under equipment, including heavy impact and vibratory machinery, reciprocating engines, compressors, pumps, presses, etc.
- Grouting under crane rails

#### CHARACTERISTICS / ADVANTAGES

- Meets API Standard 686.
- Low peak exotherm.
- Low dusting, ready-to-mix, pre-proportioned kits.
- Moisture insensitive.
- Corrosion and impact resistant.
- Stress and chemical resistant.
- High compressive, tensile and shear strengths.
- High vibration resistance.
- Low coefficient of thermal expansion; compatible with concrete.
- Material does not require heated transportation.

#### PRODUCT INFORMATION

<b>Packaging</b>	2.0 cu. ft. Unit = Component A: 22.6 lbs. (10.28 kg) Component B: 7.5 lbs. (3.42 kg) Component C: 4 x 64 lbs. (29.03 kg)
<b>Color</b>	Dark Brown
<b>Shelf Life</b>	24 months from date of production
<b>Storage Conditions</b>	Store dry between 41 °F and 89 °F (5 °C and 32 °C). Condition material between 73 °F and 86 °F (23 °C and 30 °C) for 48 hours prior to using. For temperatures outside of this range, please contact our technical department.
<b>Density</b>	144 lb/ft <sup>3</sup> (2300 kg/m <sup>3</sup> )

#### TECHNICAL INFORMATION

<b>Compressive Strength</b>	24 h	5,000 psi (34.5 MPa)	
	2 days	9,000 psi (62.1 MPa)	(ASTM C-579)
	3 days	10,000 psi (69.0 MPa)	73 °F (23 °C)
	7 days	11,000 psi (75.8 MPa)	50 % R.H.
	28 days	13,300 psi (91.7 MPa)	
* Material cured and tested at the temperatures indicated.			
<b>Effective Bearing Area</b>	~90 % (High)		(ASTM C-1339)
<b>Flexural Strength</b>	6,400 psi (44.1 MPa)		(ASTM C-580) 73 °F (23 °C) 50 % R.H.
<b>Modulus of Elasticity in Flexure</b>	5.24 x 10 <sup>6</sup> psi (36 MPa)		(ASTM C-580) 73 °F (23 °C) 50 % R.H.
<b>Tensile Strength</b>	5,000 psi (34.5 MPa)		(ASTM D-638) 73 °F (23 °C) 50 % R.H.
<b>Shrinkage</b>	0.045 %		(ASTM C-531) 73 °F (23 °C) 50 % R.H.
<b>Creep</b>	600 psi, 140 °F (4.1 MPa, 60 °C)	7.2 x 10 <sup>-3</sup>	(ASTM C-1181) 73 °F (23 °C)
	400 psi, 140 °F (2.7 MPa, 60 °C)	5.3 x 10 <sup>-3</sup>	50 % R.H.
<b>Thermal Compatibility</b>	No delamination/pass		(ASTM C-884)
<b>Coefficient of Thermal Expansion</b>	-22–86 °F (-30–30 °C)	1.6 x 10 <sup>-5</sup> /°F (2.8 x 10 <sup>-5</sup> /°C)	(ASTM C-531)
	75–212 °F (24–100 °C)	2.1 x 10 <sup>-5</sup> /°F (3.8 x 10 <sup>-5</sup> /°C)	

## APPLICATION INFORMATION

<b>Mixing Ratio</b>	Ratio A:B:C by weight	3:1:34
	Ratio solid/liquid by weight	8.5:1
<b>Coverage</b>	2 ft <sup>3</sup> (56,640 cm <sup>3</sup> ), 15 gallons (56.6 liters)	
<b>Peak Exotherm</b>	94.3 °F (34.6 °C)	(ASTM D-2471)
<b>Pot Life</b>	Mix 3:1 (A:B 300 g)	2 h 20 min

## APPLICATION INSTRUCTIONS

### SUBSTRATE PREPARATION

**Note:** For optimum results when grouting in critical items of equipment, it is recommended that the surface preparation requirements of the latest edition of Chapter 5, API Recommended Practice 686 be followed. This document is the “Recommended Practices for Machinery Installation and Installation Design” published by the American Petroleum Institute. Surface and base plate contact area must be clean and sound. For best results, the substrate should be dry.

Remove dust, laitance, oils, grease, curing compounds, impregnations, waxes, foreign particles, coatings, and disintegrated materials by mechanical means, i.e. chipping with a chisel, sandblasting. All anchor pockets or sleeves must be void of water. Sandblast metal base plates to a commercial white finish (SP-10) for maximum adhesion. Apply grout immediately to prevent re-oxidizing.

**Forming:** The consistency of the epoxy grout system requires the use of forms to contain the material around the base plates. In order to prevent leakage or seepage, all forms must be sealed. Apply polyethylene film or wax

to all forms to prevent adhesion of the grout. Prepare form work to maintain more than 4 in. (100 mm) liquid head to facilitate placement. A grout box equipped with an inclined trough attached to the form will enhance the grout's flowability and minimize air encapsulation.

## MIXING

Thoroughly stir both Component A and Component B, distributing any settled solids and achieving an even consistency throughout each component. Mix the entire contents of components A and B in the component A pail for 3 minutes with a paddle attached to a low speed drill (300–450 rpm). During the mixing operation, scrape down the sides and bottom of the mixing pail with a flat or straight edge trowel at least once, to ensure complete mixing of A and B components. Empty entire contents of mixed A and B components into an appropriate mortar mixer ensuring that walls and bottom of mixing pail are scraped clean and all of mixed epoxy resin is added to mortar mixer. Slowly add the entire content of component C and mix until uniformly blended (approx. 5 minutes). Add all component C unless a reduction is directed by the Sika Representative. Mixed grout should be kept agitated prior to placement.

## APPLICATION METHOD / TOOLS

Pour the mixed grout into the prepared forms from one or two adjacent sides only, to eliminate air entrapment. Maintain the liquid head to ensure intimate contact to the base plate. Place sufficient epoxy grout in the forms to rise slightly above the underside [1/8 in. (3 mm)] of the base plate. The minimum void depth beneath the base-plate should be 1 in. (25 mm), but 1.5 in. (38 mm) is preferred. Where the void beneath the base plate is greater than 18 in. (450 mm), place the epoxy grout in successive 18 in. (450 mm) lifts or less, once the preceding lift has cooled.

## CLEANING OF TOOLS

Sweep into appropriate containers. Dispose of in accordance with applicable local regulations. Uncured material can be removed with Sika® Equipment Cleaner. Cured material can only be removed mechanically.

## LIMITATIONS

- If material is subject to cold or freezing temperatures during transportation to or storage on a job site, care must be taken to properly precondition A, B, and C components prior to beginning grouting operations.
- Cold ambient, substrate or material temperatures will inhibit the flow and curing characteristics of Sikadur® 42 Grout Pak LECA. For temperatures below 73 °F (23 °C), call Sika Technical Services”.
- Grouting material must be stored in an area with an ambient temperature between 73 and 86 °F (23 and 30 °C) for a minimum of 48 hours before use.
- Should ambient, substrate or material temperatures

exceed 30 °C (86 °F) contact Sika Technical Services for guidance as excessive heat can influence the properties of epoxy polymer grouts.

- Do not thin with solvents. Solvents will prevent proper cure.
- Material is a vapor barrier after cure.
- Minimum grout thickness: 1 in. (25 mm).
- Maximum grout thickness: 18 in. (450 mm) per lift. For grout thickness between 12–18 in. (300–450 mm), contact Sika Canada Technical Service.
- Component C must be kept dry.
- For bolt grouting applications contact Sika Technical Service.
- For proper seating, allow grout to rise above the bottom [1/8 in. (3 mm)] of the base plate.
- Do not batch. Mix complete units only.
- Do not subject cured epoxy grout to sudden temperature changes especially during early curing stages.
- Contact our technical department for control joint spacing on large base plate grouting projects.

## BASIS OF PRODUCT DATA

Results may differ based upon statistical variations depending upon mixing methods and equipment, temperature, application methods, test methods, actual site conditions and curing conditions.

## OTHER RESTRICTIONS

See Legal Disclaimer.

## ENVIRONMENTAL, HEALTH AND SAFETY

For further information and advice regarding transportation, handling, storage and disposal of chemical products, user should refer to the actual Safety Data Sheets containing physical, environmental, toxicological and other safety related data. User must read the current actual Safety Data Sheets before using any products. In case of an emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887. Keep out of reach of children  
For industrial use only

## LEGAL DISCLAIMER

- KEEP CONTAINER TIGHTLY CLOSED
- KEEP OUT OF REACH OF CHILDREN
- NOT FOR INTERNAL CONSUMPTION
- FOR INDUSTRIAL USE ONLY
- FOR PROFESSIONAL USE ONLY

Prior to each use of any product of Sika Corporation, its subsidiaries or affiliates ("SIKA"), the user must always read and follow the warnings and instructions on the product's most current product label, Product Data Sheet and Safety Data Sheet which are available at [usa.sika.com](http://usa.sika.com) or by calling SIKA's Technical Service Department at 1-800-933-7452. Nothing contained in any SIKA literature or materials relieves the user of the obligation to read and follow the warnings and instructions for each SIKA product as set forth in the current product label, Product Data Sheet and Safety Data Sheet prior to use of the SIKA product.

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