

Procedure for Installing Heavy Equipment

Technical Bulletin # 1600B

Bulletin Description

The following grout installation instructions apply to standard ESCOWELD Epoxy Grout applications on concrete foundations where the grout thickness is within the specified range. Outside this range, please consult your CHOCKFAST distributor for guidance.

Material Check List

The following materials are required to effectively install ESCOWELD epoxy grout. Assemble all materials prior to starting any work.

1. Adequate supply of ESCOWELD 7505E/7530 Epoxy Grout. We recommend ordering 10% to 15% extra to account for spillage, waste, etc. depending on location of distributor.
2. Protective covering for floors and equipment.
3. Air compressor, hoses, chipping gun and auxiliary lighting.
4. Dust masks, goggles, hard hats, rubber gloves and ear protection. Also check with on-site safety personnel for safety equipment requirements.
5. Industrial vacuum cleaner.
6. Replacement anchor bolts if needed.
7. Sandblasting equipment, ventilation equipment if necessary.
8. Tape or split hoses for isolating anchor bolts from grout.
9. Forming materials: lumber, Styrofoam, chamfer strips, nails, putty, weather stripping, paste wax and carpenters tools.
10. Grout mixing equipment: Wheelbarrows, mortar hoes and buckets or mechanical mortar mixer if required.
11. Warm soapy water or clean-up solvent and rags for clean up only.
12. An adequate number of people to help mix and install the grout.

Surface Preparation

For the foundation to successfully absorb vibration from the equipment there must be a solid connection from the equipment down through the baseplate and foundation and into the soil underneath. This requires a solid connection between the epoxy grout and the baseplate as well as the epoxy grout and the concrete foundation. The recommendations below are provided to help ensure this connection exists.

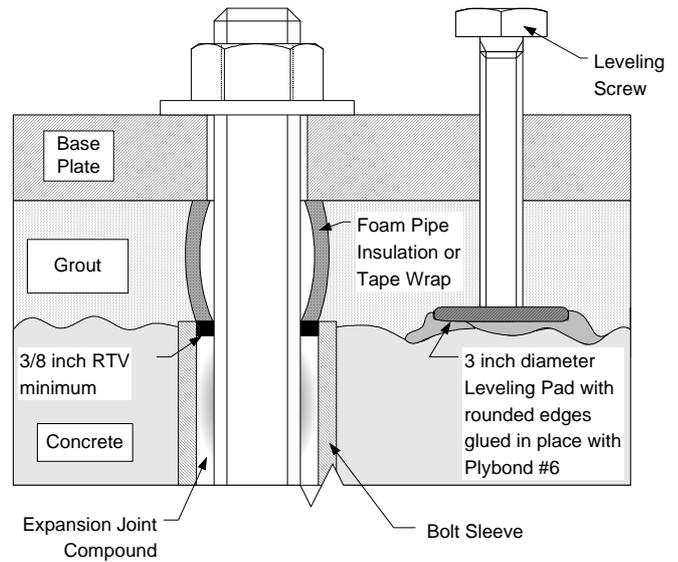
1. Metal surfaces to be in contact with the ESCOWELD 7505E/7530 Epoxy Grout should be dry and free of grease, paint and rust for optimum bonding. A bright metal surface can be obtained by sandblasting or grinding. In high humidity areas, equipment should be grouted immediately after sandblasting or grinding. If immediate grouting is not practical, these surfaces should be protected with a thin coat of ITW Rust Inhibitive Primer.
2. Concrete on which the grout will bear should have attained its design strength and shrinkage before grouting. The design strength, curing information and shrinkage information is available from the concrete supplier. All concrete surfaces that are to come into contact with ESCOWELD 7505E/7530 Epoxy Grout should be chipped approximately 1 inch in depth to remove laitance and provide a rough surface for good bonding and shear strength. If concrete is oil soaked, chip away concrete until oil or contaminants are removed. Only sound concrete is acceptable.
3. All shims, leveling screws, wedges and blocks that will eventually be removed from the installation should be covered with putty or wax prior to pouring ESCOWELD 7505E/7530 Epoxy Grout.

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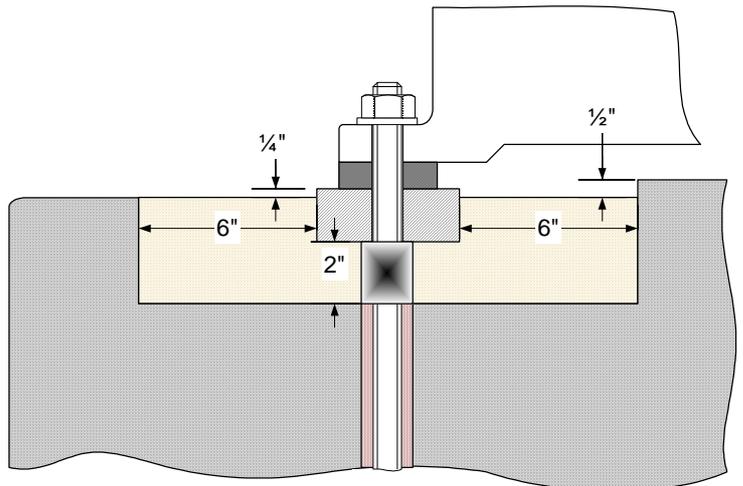
4. Pouring around anchor bolts completely with ESCOWELD 7505E/7530 Epoxy Grout restricts the spring effect capabilities of the full length of the bolt and should be avoided as follows:
 - a. Anchor bolt sleeves should be packed with foam rubber, spray urethane foam, asphalt or other non-bonding material.
 - b. Anchor bolts should be wrapped to provide a barrier between the ESCOWELD 7505E/7530 Epoxy Grout and the anchor bolts.



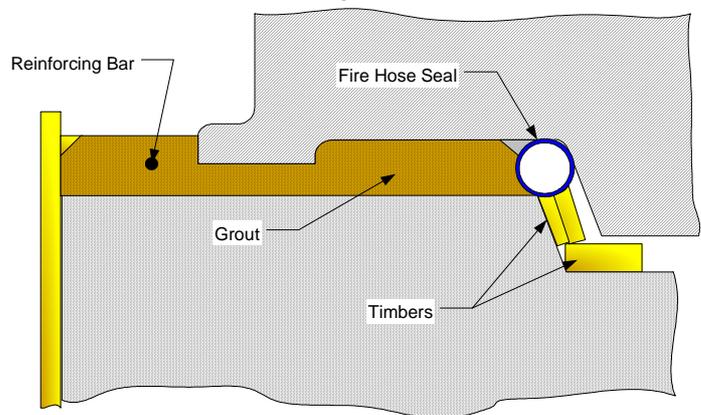
Forming Instructions

Forms to contain the epoxy grout are typically made from 3/4 inch plywood and 2x4's and 2x6's. The following are some recommendations to improve the quality of the formwork.

1. For embedded machines, forms to contain ESCOWELD 7505E/7530 Epoxy Grout should be designed to provide a grout level of one-inch minimum above the engine frame bottom and to chamfer the outside edge of the grout. For rail or soleplate mounted machines, forms shall be designed to provide a grout level of 1/4 inch minimum below the top of the rails or soleplates.
2. Forms should be liquid tight to prevent loss of epoxy grout materials. Any open spaces or cracks in forms at the joints or between forms and the foundation block should be sealed off using putty or duct seal.
3. All form material should be coated with 3 coats of heavy paste wax on all areas that will come into contact with ESCOWELD 7505E/7530 Epoxy Grout to prevent bonding.
4. For engines having a V-shaped oil pan, a seal may be made using a waxed or polyethylene wrapped fire hose to prevent the grout from leaking under the crankcase. The hose should be inflated with water not to exceed 10 psi.

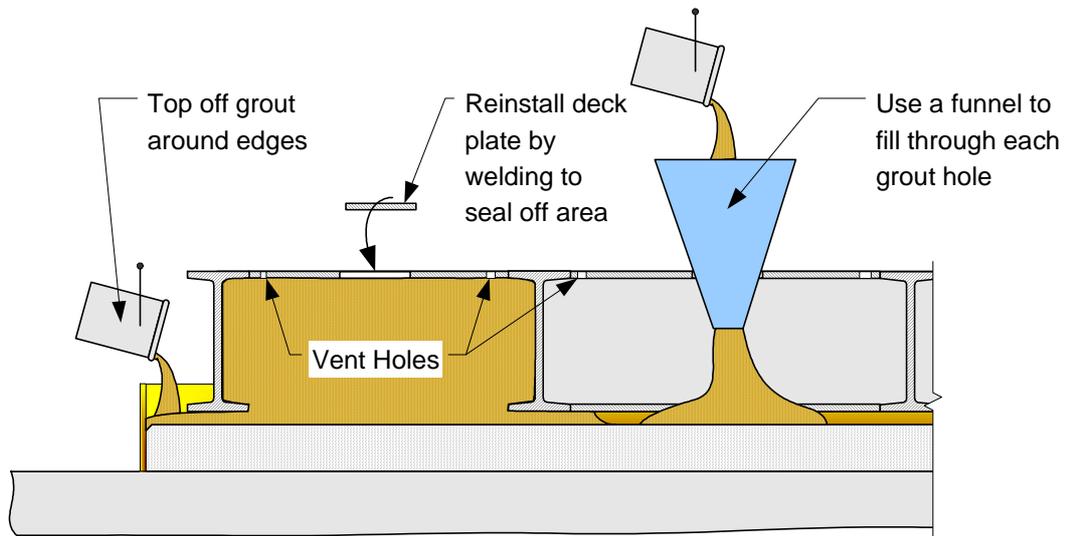
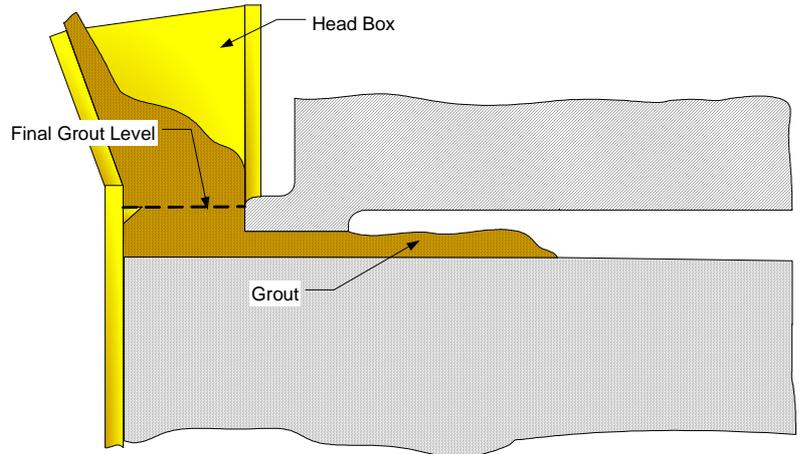


Rail / Soleplate Installation



A typical embedded installation where the grouted surface is narrow and grout does not have to flow a great distance.

5. Any sand, dust or other foreign material shall be removed from the foundation top after forming and sealing are complete.
6. Surfaces of machine-base rails or soleplates that are to be embedded in grout should be cleaned using a wiping cloth dampened with IMPAX IXT-59 Cleaning Solvent
7. Leveling screws should be coated with non-melt grease or a heavy wax film prior to pouring grout.



A typical I-Beam skid for heavy compressor equipment. Hand holes and vent holes should be strategically located between stages, etc., to facilitate grout placement under center longitudinal & transverse beams.

Expansion Joints

When expansion joints are required, the following procedures are suggested:

1. Expansion joints are normally placed in the non-load bearing shoulders. The expansion joint should be 1/2" to 1" thick. It is very important that the expansion joint material bonds to the grout so that it does not provide a path to the concrete for oil, water and other contaminants. In deeper pours closed cell foam can be bonded to thin wooden bracing material and tacked into the base of the form. The top of the foam expansion joint should be level with the finished surface of the grout. Care should be taken that this foam type expansion joint is not moved out of place during the pouring of the grout

2. Another procedure for placing expansion joints: a polyurethane foam strip or a waxed or polyethylene wrapped plywood form is fit firmly in place at pre-selected expansion joint locations. After the epoxy grout cures the foam strip or plywood Form can be removed. The gaps then may be filled with ITW Expansion Joint Compound. This will prevent oil penetration to the concrete. It is suggested that expansion joints be placed so that they isolate each soleplate or rail. In full bed applications, expansion joints should be placed every 4-6 Feet.

Reinforcing Bars

Rebar or reinforcing bars or rods can improve the overall strength and soundness of a grouted foundation. The following recommendations will improve the effectiveness of the rebar.

1. When pouring deep or long pours, steel-reinforcing bars may be used to minimize stress cracking. To distribute the stresses under these conditions, #4, or #5 rebar should be placed at 12-18' centers parallel to the equipment.
2. The rebar should be placed approximately 2" below the grout surface and if the rebar is tiered, the bottom rebar should be located 2" above the foundation surface.

Grout Mixing

1. Instructions on the ESCOWELD packaging labels relating to safety precautions in handling ESCOWELD 7505E/7530 material components should be closely followed.
2. Each unit consists of:
 - One pail containing 25.5 lb. (11.5 kg) of resin (Part A) in lower compartment and 10.2 lb. (4.55 kg) of converter (Part B) in top tray.
 - ESCOWELD® 7530 Aggregate (Part C): Five - 53 lb. bags
3. Always mix complete units. Do not vary the ratio of resin and converter or add solvent or water to change the consistency.
4. Pour the entire contents of ESCOWELD Part B Converter into Part A Epoxy Resins container. Mix thoroughly with a power drill at approximately 200-250 RPM using a Jiffy-type mixing blade. Mixing should be completed in 3 minutes. The net weight of the combined Part A and Part B is 35.7 lb. (16.2 kg). Over mixing or violent agitation will result in excessive air entrapment and should be avoided.
5. ESCOWELD 7505E/7530 Epoxy Grout is mixed using a motorized mortar mixer. Pour the mixture of resin and converter into the mortar mixer then blend the aggregate in slowly until the recommended aggregate ratio has been added. When using a mortar mixer, the maximum mixer blade speed should not exceed 15 RPM. Mix the grout only long enough to uniformly wet all the aggregate particles. Do not over-mix.
6. The first mixing batch will be stiffer in consistency due to some of the liquid wetting the sides of the mixer and blades. Withholding one-half bag of ESCOWELD® 7530 Aggregate from the First batch will compensate for loss of the liquid.
7. Working life of ESCOWELD 7505E/7530 Epoxy Grout

ESCOWELD 7505E/7530 Epoxy Grout will exhibit the following approximate working time:

<u>Temperature °F</u>	<u>Working Time - Minutes</u>
90	50
77	120
60	150

Grout Placement

1. Cold Weather Considerations
 - a. Storage Conditions - All ESCOWELD 7505E/7530 Epoxy Grout components should be stored at a temperature between 70°F-80°F. Since aggregate is the major component portion of the mix; its temperature will be the most critical in determining the final mix temperature.
 - b. Surface Conditions - All surfaces that will come into contact with the grout should be maintained at a temperature of at least 50°F for 48 hours prior to and at least 48 hours after grouting
 - c. Curing Conditions - For best results, fabricate temporary shelter around the equipment to be grouted and pre-condition the equipment and foundation. Typical materials for this shelter are canvas or polyethylene. Use conventional heating equipment and be careful not to overheat localized areas.
2. Hot Weather Considerations
 - a. Storage Conditions - All ESCOWELDC 7505E/7530 Epoxy Grout components should be stored at temperatures between 70°F-80°F. Since aggregate is the major component portion of the mix, its temperature will be the most critical in determining the final mix temperature.
 - b. Surface Conditions - Shading or other cooling methods such as fans should be used to cool the concrete and steel to below 90°F.
 - c. Curing Conditions - Concrete and the equipment should be shaded 48 hours prior to grouting and 48 hours after placement of grout. It is suggested to proceed with the grouting operation in the early morning or at night after the equipment and foundation temperature drops. This allows heat development to take place during the coolest part of the day or evening.
3. Placing ESCOWELD 7505E/7530 Epoxy Grout
 - a. Prior to the grouting operation, the work area adjacent to the equipment to be grouted should be protected to facilitate clean-up after pouring is completed.
 - b. Proceed with grouting within a few hours after machinery leveling and alignment because castings have a tendency to creep or sag over a period of time when supported only by jack bolts. If a day or more elapses after leveling and alignment, re-check to confirm before grouting.
 - c. Grout placement should proceed in a manner that will assure the filling of all spaces and complete contact of grout with the surface to be grouted. ESCOWELD 7505E/7530 Epoxy Grout should be poured starting at one end of the equipment and working toward the other end to prevent air pockets and voids.
 - d. ESCOWELD~ 7505E/7530 Epoxy Grout has excellent placement consistency, but flow is enhanced using hydraulic head pressure. Construct a head box or funnel 1-2 feet deep to place the grout in these hard to reach places. Never allow the level of grout to fall beneath that of the baseplate because this will result in trapped air and voids. Do not vibrate as this will induce excessive air entrapment and result in a poor bearing area upon curing.
 - e. Forms must be constantly checked for leaks. All leaks must be sealed immediately or voids will develop. Putty or duct sealing materials should be available to repair leaks.
 - f. A smooth finish can be obtained by troweling the surface of ESCOWELD 7505E/7530 Epoxy Grout with a trowel wetted with IMPAX IXT-59 immediately after completing the pour. Care should be exercised to prevent blending solvent into the surface of the grout. This can result in a soft surface, which may take several days to harden.
 - g. Upon completion of the grouting operation, all tools and mixing equipment should be immediately cleaned using water or IMPAX IXT-59 Clean-up Solvent.

Grout Curing

The following is a cure chart which can be used as a guide for determining final cure times. The temperatures shown are of the baseplate and foundation, not ambient temperatures.

<u>Temperature - °F</u>	<u>Cure Time - Hours</u>
90	12
80	24
70	36

Reference

For details on the ESCOWELD 7505E/7530 Epoxy Grout, please request Bulletin No. 1612 or contact ITW Polymer Technologies' Engineering Services Department.

Date

09/2005

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