

MasterFlow® 647 Repair Grout

Installation Procedures, Pressure grouting of sole plates, compressors and pump bases

FORMERLY MASTERFLOW 647 R REPAIR GROUT INSTALLATION PROCEDURES

Masterflow 647 Grout is a two-component epoxy liquid specifically formulated for grouting cracks in concrete machinery foundations and for filling voids in grouted baseplates, structural members, and soleplates. This bulletin is as specific as possible but cannot address all applications and variables experienced under field conditions. Experienced field personal may find it necessary to deviate from our suggested procedures due to field, environmental, or application conditions, Contact BASF Technical Support for assistance. Proper application is the responsibility of the user. This product is intended for use by professionals only. It is not for sale to the general public.

A. MIXING MASTERFLOW 647 REPAIR GROUT

1. One 2.5 gallon (575 in3) unit of Masterflow 647 consists of 1.5 gallons of Part A and 1.0 gallon of Part B. Part A is packaged in a 3.5 gallon can, in which the product is mixed.
2. Mixing full units only is recommended.
3. Do not add thinners, solvents or water.
4. Add Part B to Part A in the Part A container, and stir manually with a paint stirrer, until a uniform gray color is obtained. This typically takes about 3 minutes.

NOTE: If using a two-component side by side injection pump (in which the two components are mixed at the point of discharge), pre-test mixed ratio at the pump hose inlets.

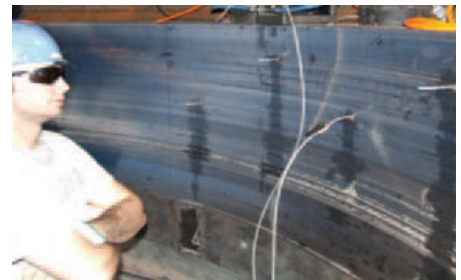
B. PRESSURE GROUTING OF BASE PLATES AT EDGES.

This method is used to fill voids under machinery base plates.

1. If the crack or seam at the edge of the base plate is open more than 0.010 inches (0.25 mm) seal edge with MasterEmaco® ADH 328RS or MasterEmaco ADH 1420 epoxy paste



2. Drill holes in the exposed edges or the structural member or sole plate.
 - a. If using injection pump (preferred), install pump manufacturer's preferred ports.
 - b. If using grease gun, ream out the holes to accommodate 1/8" or 1/4" pipe taps and install grease fittings (zerks).



3. Inject MasterFlow 647 Grout through the fittings/ports into the void until any water or oil has been flushed out and the grout is discharged from the crack.
4. Remove the grease fittings before the grout has set to bleed off any remaining pressure.
5. If grout is not visible or does not flow out of the open fitting hole, repeat the process.
6. If this process does not result in bonding the steel and in place grout, it is possible that the steel surface was not adequately prepared for grouting prior to the original grout placement.

C. PRESSURE GROUTING OF HOLLOW BASE PLATES

1. If sounding reveals the presence of voids between the baseplate and installed machinery grout (polymer or cementitious), use this method to grout the voids.
2. Drill holes for ports or zerk fittings and as vents. Typical tapped hole sizes are 1/8" or 1/4". Locate holes within 12 inches of one another, on center.
3. Start injection at one end of void and pump until grout is discharged from adjacent tap holes.



- a. Move to the nearest hole where grout has appeared. Continue to inject grout using the new location.
- b. Continue this process until all air is vented and all voids filled.
- c. Remove ports or fittings and check to assure that no settlement or seepage occurred.
- d. If settlement or seepage has occurred, repeat previous steps.

HEALTH , SAFETY AND ENVIRONMENTAL

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