

## TECHNICAL BULLETIN

# SikaFlow®-647 Repair Grout

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

SikaFlow®-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 Sika 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 SIKAFLOW 647 REPAIR GROUT

1. One 2.5 gallon (575 in3) unit of SikaFlow®-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 Sikadur®-31 Hi-Mod Gel, Sikadur 33, or Sika AnchorFix-1.



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 SikaFlow®-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

Read, understand and follow all Safety Data Sheets and product label information for this product prior to use. The SDS can be obtained by visiting [usa.sika.com](http://usa.sika.com), e-mailing your request to technical service or calling 1(800)433-9517. Use only as directed. **IN CASE OF EMERGENCY: Call CHEMTEL +1 (800) 255-3924 or if outside the US or Canada, +1 (813) 248-0585.**

### LIMITED WARRANTY NOTICE

Sika Corporation warrants this product to be free from manufacturing defects and to meet the technical properties on the current Technical Data Guide, if used as directed within shelf life. Satisfactory results depend not only on quality products but also upon many factors beyond our control. SIKa MAKES NO OTHER WARRANTY OR GUARANTEE, EXPRESS OR IMPLIED, INCLUDING WARRANTIES OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE WITH RESPECT TO ITS PRODUCTS. The sole and exclusive remedy of Purchaser for any claim concerning this product, including but not limited to, claims alleging breach of warranty, negligence, strict liability or otherwise, is shipment to purchaser of product equal to the amount of product that fails to meet this warranty or refund of the original purchase price of product that fails to meet this warranty, at the sole option of Sika. Any claims concerning this product must be received in writing within one (1) year from the date of shipment and any claims not presented within that period are waived by Purchaser. SIKa WILL NOT BE RESPONSIBLE FOR ANY SPECIAL, INCIDENTAL, CONSEQUENTIAL (INCLUDING LOST PROFITS) OR PUNITIVE DAMAGES OF ANY KIND.

Purchaser must determine the suitability of the products for the intended use and assumes all risks and liabilities in connection therewith. This information and all further technical advice are based on Sika's present knowledge and experience. However, Sika assumes no liability for providing such information and advice including the extent to which such information and advice may relate to existing third party intellectual property rights, especially patent rights, nor shall any legal relationship be created by or arise from the provision of such information and advice. Sika reserves the right to make any changes according to technological progress or further developments. The Purchaser of the Product(s) must test the product(s) for suitability for the intended application and purpose before proceeding with a full application of the product(s). Performance of the product described herein should be verified by testing and carried out by qualified experts.

Sika Corporation  
201 Polito Ave  
Lyndhurst, NJ 07071  
Phone: +1 800-933-7452  
Fax +1 201-933-6225  
[usa.sika.com](http://usa.sika.com)

**BUILDING TRUST**

