



## SELECTION & SPECIFICATION DATA

<b>Type</b>	Structural vinyl ester grout												
<b>Description</b>	Acrocast Grout is a 3-component vinyl ester structural grout designed with low shrinkage for casting applications 3/4 inch (18 mm) thick or more.												
<b>Uses</b>	<p>Concrete resurfacing</p> <p>Grouting heavy reciprocating or rotating equipment where heavy loads, chemical exposure or vibration may be a factor including:</p> <table><tr><td>Compressors</td><td>Mixers</td></tr><tr><td>Generators</td><td>Fans</td></tr><tr><td>Pumps</td><td>Stamping machines</td></tr><tr><td>Ball mills</td><td>Paper mill machines</td></tr><tr><td>Centrifuges</td><td>Packaging machines</td></tr><tr><td>Pedestals</td><td>Piles</td></tr></table>	Compressors	Mixers	Generators	Fans	Pumps	Stamping machines	Ball mills	Paper mill machines	Centrifuges	Packaging machines	Pedestals	Piles
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<b>Features</b>	<ul style="list-style-type: none"><li>Minimal shrinkage</li><li>Resistant to strong oxidizers, bleach solutions, and alkalis</li><li>Excellent vibration resistance</li><li>High physical strength</li><li>Good bond to concrete and metal surfaces</li><li>Rapid strength gain</li></ul>												
<b>Limitations</b>	<ul style="list-style-type: none"><li>Requires formwork.</li><li>When using as an overlay in large surface areas, pour in a checkerboard fashion to reduce curing shrinkage stresses.</li><li>Not for use beyond its chemical resistance or thermal capabilities. Consult Armor with specific questions.</li></ul>												

## INSTALLATION GUIDANCE

<b>Reference Specifications</b>	CES-360 Installation of Armor Resinous Polymer Concretes
<b>Installation Conditions</b>	<p>Acrocast Grout is formulated for ideal handling at 70°F (21°C). Materials and substrate should be acclimated to the air temperature prior to installation, and the air temperature should be between 50°F (10°C) and 90°F (32°C) during installation and cure.</p> <p>Substrate must be clean, dry and neutral pH.</p>
<b>Ratio</b>	<p>1 gallon resin: 2-3 fl. oz. hardener by volume. 1.0-part catalyzed resin: 8.2 parts filler by weight.</p> <p>Filler loading may be adjusted slightly to suit flow preferences. Where higher flow characteristics are required, reduce filler loading by holding back up to 0.7 parts filler.</p>
<b>Mixing</b>	Pour measured quantity of resin into clean, dry mixing vessel. Slowly add measured quantity of hardener to resin and mix thoroughly. Add filler and mix until filler is thoroughly wetted.
<b>Work Life</b>	<p>30-45 minutes at 70°F (21°C)</p> <p>Work life estimates are based on use of 2 fl. oz. CHP Hardener per 1 gallon resin. Increased hardener dosage will reduce work life.</p> <p>Work life is shorter at higher temperatures. A larger volume of mixed material will have a shorter work life than a smaller volume.</p>
<b>Cleanup</b>	Xylene or MEK

## CURE TIME

Temperature	Initial Set	Full Cure
70°F (21°C)	2-3 hours	3 days

## SAFETY

<b>Safety</b>	Mixes and applications of this product present a number of hazards. Read and follow the hazard information, precautions and first aid directions on the individual product labels and safety data sheets before using.
<b>Ventilation</b>	Provide thorough air circulation during and after application until the material has cured when used in enclosed areas.

**PACKAGING, ESTIMATING & HANDLING**

Product	Code	Packaging
Acrocast Resin, Gray	19510	43 lb (5 gal or 19 L) pail
Acrocast Resin, Clear	29646	43 lb (5 gal or 19 L) pail
CHP Hardener	19552	11.2 fl. oz. (0.7 lb) bottle
Tufchem™ Grout Filler	21931	60 lb (27 kg) bag

A 404 lb (2.99 cu ft) unit consists of 1 pail of resin, 1 bottle of hardener and 6 bags of filler. To enhance flow characteristics, it is permissible to hold back up to one half-bag of filler.

**Theoretical Coverage**

A 404 lb (183 kg) unit will yield approximately 2.99 cubic feet (0.085 m<sup>3</sup>) of grout. Yield will be reduced when filler loading is reduced.

**Storage & Shelf Life**

Maintain products in original packaging and sealed until ready for use. Estimated shelf life of resin is 6 months, and hardener is 1 year when stored in a dry area at 70°F (21°C). Warmer resin storage conditions will dramatically reduce shelf life. Store resin between 55°F (13°C) and 65°F (18°C) for maximum shelf life. Fillers do not degrade with age when stored in a dry area and packaging is intact. Actual shelf life may vary with storage conditions.

If there is any question with respect to the quality of the components, check reactivity prior to use. For assistance consult with Armor.

**TYPICAL PHYSICAL PROPERTIES**

Property	Typical Value
Color	Gray Sand, if using clear resin
Density, ASTM C138	135 lb/ft <sup>3</sup> (2,162 kg/m <sup>3</sup> )
Compressive strength, ASTM C579	>10,000 psi (69 MPa)
Tensile strength, ASTM C307	>1,800 psi (12.4 MPa)
Flexural strength	>3,000 psi, (20.7 MPa)
Linear shrinkage, ASTM C531	0.12%
Absorption, ASTM C413	0.4%
Coefficient of thermal expansion, 75°F-210°F ASTM C531	16 x 10 <sup>-6</sup> /°F (28.8 x 10 <sup>-6</sup> /°C)
Minimum application thickness	0.75 inches (19 mm)
Slump using 8.2 filler: 1.0 mixed resin and hardener mix ratio	Approximately 3-5 inches (75-125 mm) with full filler loading.  Flow characteristics of resinous polymer grouts are different from Portland cement grouts. Use caution when comparing slump values.

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**TERMS AND CONDITIONS OF SALE**

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