

Megapoxy®

Application Guide for Flowable Epoxy Grouting





The Megapoxy Difference

Megapoxy is proud to support the performance, safety and longevity of structures, products and equipment across the globe. We are high-strength epoxy adhesive specialists, crafting solutions to solve real industry challenges. We work with clients to achieve the perfect result, smoothly and efficiently.

We develop, produce and manufacture advanced formulas to bond, strengthen, repair, preserve and protect. Backed by the highest quality standards and certifications, our clients enjoy reliable supply, fast turnaround, expert advice and support worldwide. Trusted for 50 years, we constantly innovate for today and tomorrow.

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Performance and Reliability

Industrial and structural grouting demands solutions that are engineered for the job. From shallow precision pours to deep installations and rapid shutdown works, we have a match for your project and needs.



Our flowable grout formulations are built to handle loads, vibration, corrosion, and long-term demands – all rigorously tested and proven when the pressure is on.

Like all our solutions, they are specifically designed for onsite ease and efficiency. Of course, our team is always here to help: see the back page for support close to you.

Industries

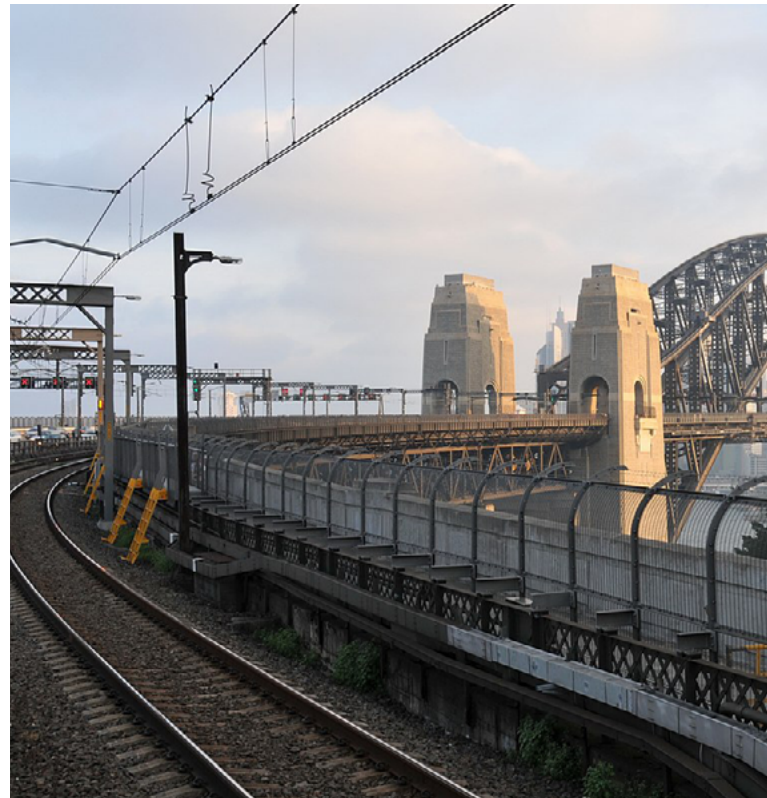
- Mining & resources
- Construction & civil infrastructure
- Transport & rail
- Energy & utilities
- Water & wastewater
- Manufacturing

Equipment

- Pumps & compressors
- Crushers & mills
- Generators & turbines
- Conveyors
- Crane and rail systems

Structures

- Machinery baseplates
- Rail and crane rail foundations
- Bridge bearing pads
- Anchor bolt and truncation pockets
- Structural bearing plates
- Core holes and voids

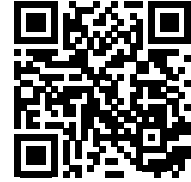


The Right Products for the Job

Megapoxy offers a complete range of flowable epoxy grouts tailored for different depths, temperatures and site conditions.

Explore megapoxy.com for more information and how-to videos.

Scan the QR code to link to our Technical Data Sheets.



206 Ultra

Heavy Duty Epoxy Grout (5–50 mm depth)

- High compressive strength & impact resistance.
- Superior adhesion to concrete & steel.
- Excellent flow.
- Safe for potable water applications.
- Solvent free.



206 Accelerated

Fast-Curing, Heavy Duty Epoxy Grout (5–50mm depth)

- Same performance as 206 Ultra, with faster strength development.
- Quicker turnaround in shutdowns
- Excellent for use in cooler conditions.
- Ideal for time-critical structural, mining & anchoring applications



Deep Pour Grout

Heavy Duty Epoxy Grout (50–300 mm depth)

- Controls heat generation without aggregate.
- Simple two-component system.
- Excellent tensile & compressive strengths.
- Outstanding chemical resistance.
- Suitable for hot & demanding sites.

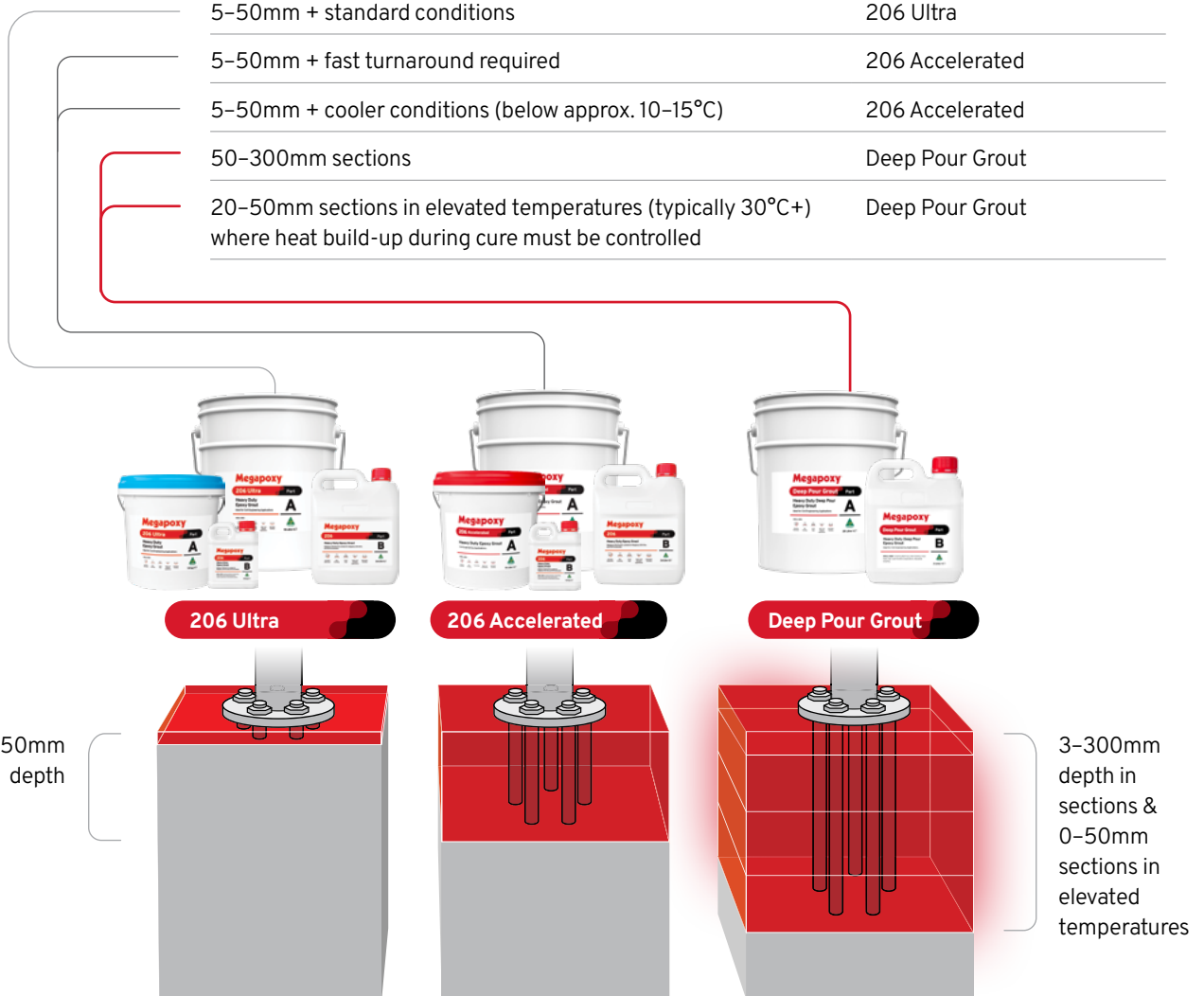


Product comparison

	Megapoxy 206 Ultra	Megapoxy 206 Accelerated	Megapoxy Deep Pour Grout
Recommended Depth	5–50mm	5–50mm	50–300mm
Work Time @25°C	30 min	10 min	60 min
Minimum Cure @25°C	24 hrs	6 hrs	24 hrs
Compressive Strength	115MPa (ASTM C579)	105MPa (ASTM C579)	125MPa (ASTM C579)
Designed For	General structural grouting	Fast turnaround / cooler conditions	Deep/large volume sections & critical heat control

Choosing your Solution

Project depth + conditions	Recommended choice
5–50mm + standard conditions	206 Ultra
5–50mm + fast turnaround required	206 Accelerated
5–50mm + cooler conditions (below approx. 10–15°C)	206 Accelerated
50–300mm sections	Deep Pour Grout
20–50mm sections in elevated temperatures (typically 30°C+) where heat build-up during cure must be controlled	Deep Pour Grout



The Deep Pour **Difference**

Until now, deep epoxy grouting has typically required staged pours and added aggregate to manage heat build-up. Megapoxy Deep Pour Grout is engineered to control heat development – allowing deep sections to be completed in a single continuous pour, saving time and labour.



Megapoxy Deep Pour Grout

- ✓ 50–300 mm in one pour
- ✓ Engineered to control heat
- ✓ 2-part system
- ✓ High compressive strength: 125 MPa (7 days).



Most other grouts for deep, large pours

- ✗ Multiple pours for similar depth
- ✗ Added sand/gravel + staged pours to manage heat
- ✗ 3-part systems
- ✗ Often ≤ 100 MPa.

A Snapshot: Megapoxy Deep Pour Benefits and Savings

Compared to traditional multi-pour grout systems



Smoother sites & projects

- ✓ Can halve project time
- ✓ No aggregate to deliver or store
- ✓ No need for disposal of packaging
- ✓ Less site congestion
- ✓ Less manual handling of bags/aggregate
- ✓ Less mixing steps.



\$1.5K+ estimated savings

- ✓ Less crew time
- ✓ Fewer mixer hire days
- ✓ No aggregate needed
- ✓ No aggregate measuring equipment
- ✓ Larger projects = more savings.



Less time onsite

- ✓ Get equipment online sooner
- ✓ Less contractor time
- ✓ Keep projects moving
- ✓ Avoid unnecessary delays.



Based on scenario modelling of 220 mm deep machinery foundation in hot conditions, using typical Australian labour and equipment assumptions. Savings increase with project size. Actual results will vary. Excludes grout material cost.

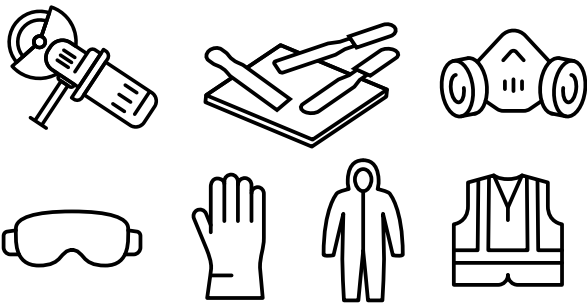
Grouting Preparation & Application



Grouting Preparation & Application

What you will need:

- Grinder with diamond grinding wheel and crack chasing blade.
- Efficient mixing paddle.
- Spatulas and flat, hard mixing board.
- Megapoxy Thinners.
- Disposable rag.
- Personal protective equipment (including appropriate clothing, gloves and eyewear).



Surface Preparation

Correct surface preparation is essential to ensure bond strength and long-term performance.

All surfaces must be clean, sound and free of contaminants before grouting begins.

Concrete



- Concrete surfaces should be free from grease and oil. If necessary, use industrial heavy-duty degreaser.
- Remove surface laitance by mechanical abrasion – such as scabbling, grit blasting or grinding.
- If mechanical preparation is not possible, acid etching may be used (*see breakout below*).
- After preparation, wash thoroughly and allow to dry for 24 hours. For maximum adhesion, the concrete should be surface dry at the time of application.

Metal



- Metal surfaces must be prepared to clean, bright metal.
- For Megapoxy 206 Ultra and Deep Pour Grout, grit blast to AS 1627.2.2002.
- For Megapoxy 206 Accelerated, grit blast to AS CK 9.4 – 1964 Class 3 finish
- When grit blasting isn't possible, mechanically abrade to clean, bright metal.
- Degrease by flooding using an industrial-grade degreaser.
- Wire brushing alone is not recommended.

Coated Surfaces



- Remove all coatings before bonding for superior adhesion.
- For concrete, flame-clean or mechanically treat with a scutching tool to remove all traces of paint. Complete by diamond grinding or scabbling.
- For metals, remove all paint and/or galvanizing using good quality paint stripper, followed by grit blasting or grinding.

Acid etching

- Mix concentrated hydrochloric acid with equal volume of water.
- Spread at rate of 0.5 litre per square meter of concrete surface.
- Allow to react for 10 minutes.
- Wash the area thoroughly & scrub with a stiff bristled broom to remove loose sand.



Mixing

- All products are supplied in pre-measured kits.
- For 206 Accelerated, working time is short: ensure formwork and placement are ready before mixing.
- For all products, thorough mixing is essential to maximum product performance.



206 Ultra + 206 Accelerated

- Stir Part A and Part B separately before mixing together, to disperse any settlement.
- Add the entire contents of Part B into the Part A pail.
- Mix manually or using a mechanical mixer at low speed (200 rpm or lower) for **2 minutes**, making sure to scrape the base and corners of the pail. Avoid up-and-down movement of the mixer.
- After 2 minutes, scrape the sides of the pail with a straight-edge tool to remove any unmixed material. Do not use the mixer head to scrape the sides.
- Mix for another **1 minute**. If a ring of unmixed Part B remains around the edge of the pail, slightly lift and tilt the mixer (approximately 30°) to draw the material into the mix.
- Apply immediately after mixing.

Deep Pour Grout

- Stir Part A and Part B separately before mixing together, to disperse any settlement.
- Add the entire contents of Part B into the Part A pail.
- Mix using a mechanical mixer at low speed of 200–400 rpm for **3 minutes**, making sure to scrape the base and corners of the pail. Avoid up-and-down movement of the mixer.
- After 3 minutes, scrape the sides of the pail with a straight-edge tool to remove any unmixed material. Do not use the mixer head to scrape the sides.
- Mix for another **2 minutes**. If a ring of unmixed Part B remains around the edge of the pail, slightly lift and tilt the mixer (approximately 30°) to draw the material into the mix.
- Apply immediately after mixing.

Important

- In higher temperatures, store in a cool place before use (to maintain usable life). Topping up can be carried out at a later stage if required.
- Only mix quantities that can be placed within the available working time as shown here...

Product	Approx. Working Time
Megapoxy 206 Ultra	30 minutes
Megapoxy 206 Accelerated	10 minutes
Megapoxy Deep Pour Grout	60 minutes



Typical Baseplate Grouting Method

The following is a typical baseplate grouting method using Megapoxy 206 Ultra, 206 Accelerated and Deep Pour Grout – subject to the depth limits and working times outlined in this guide.

1. Before mixing, position and level the baseplate.
2. Construct formwork around the baseplate with appropriate clearance.
3. Coat the formwork with a thin film of grease, wax or suitable release agent to prevent permanent bonding.
4. Take care to prevent release agent contacting the concrete foundation or baseplate surfaces.
5. Forms must be liquid-tight to prevent grout leakage.
6. Seal all cracks and openings using a suitable sealant.
7. Provide a pouring head at least 150 mm above baseplate level.
8. Provide a 50 mm off-side opening opposite the pouring head to allow air and grout to escape. Alternatively, install 5 mm clear vinyl tubing at each corner to allow air to escape and confirm grout flow.
9. Mix the epoxy grout in accordance with the Mixing Instructions (see page 10).
10. Pour the epoxy grout into the pouring hopper.
11. Continue pouring until grout rises in the off-side opening or travels into the clear vinyl tubing. Once grout appears in the tubing, tie off or crimp to stop flow.
12. Allow Epoxy Grout to cure before stripping formwork.
13. Formwork must remain in place until the grout has reached its minimum cure time.

Minimum Cure Time at 25°C

- Megapoxy 206 Ultra = 24 hours
- Megapoxy 206 Accelerated = 6 hours
- Megapoxy Deep Pour Grout = 24 hours

Important

Cure times will vary depending on ambient and substrate temperature. Refer to the relevant Technical Data Sheet (on following pages) for full temperature-based cure data.

The grout surface should be firm and non-tacky before removing formwork.

Finishing

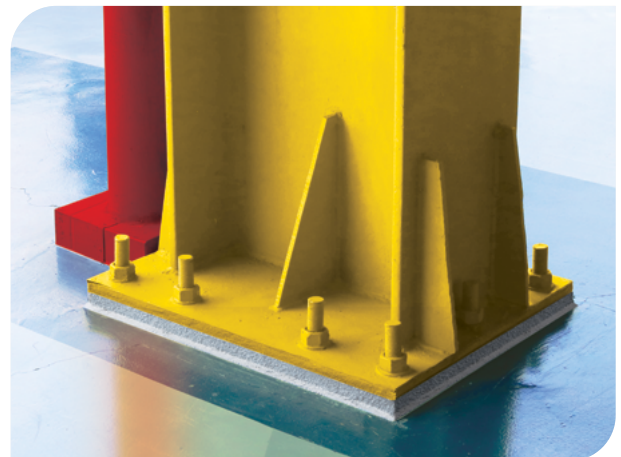
Once formwork is removed:

- Inspect the top of the baseplate grout for voids.
- If voids are detected, drill holes at either end of the void (opposite corners)
- Bond over, or into, the drilled holes to allow an appropriate low viscosity Megapoxy resin to be injected into the void at low pressure. (Megapoxy H or Megapoxy HX).
- Take care not to lift or deform the baseplate during injection.
- Remove any sharp edges on grout by light sanding or grinding.



Clean-Up

- Immediately after finishing grouting, clean tools and mixing equipment with Megapoxy Thinners or approved solvent.
- Cured epoxy grout must be removed mechanically.
- Allow any unused mixed material to fully cure before disposal.
- Dispose of waste according to site and local regulations, and manufacturer recommendations.



Appendix

Technical Bulletins

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Megapoxy®

206 Ultra

Heavy Duty Epoxy Grout



Technical Data Sheet

DESCRIPTION	<p>Megapoxy 206 Ultra is a two component, 100% solids, resin based, solvent-free, hydrophilic water displacing, flowable epoxy grout, designed specifically for use in civil engineering applications, where development of high compressive and impact strength is required.</p> <p>Megapoxy 206 Ultra complies with AS/NZS 4020:2005 "Testing of Products For Use In Contact with Drinking Water".</p>	
RECOMMENDED APPLICATIONS	<ul style="list-style-type: none"> • Pile Splicing • Pile Repair & Restoration • Locking Bearings • Rail Track Grouting • Core Hole Filling • Locking PT Cables 	<ul style="list-style-type: none"> • Grouting Machinery • Setting Anchor Bolts • Machinery Grouting • Bridge Bearing Pads • Floor Repairs • Filling Truncation Pockets
PROPERTIES	<p>Mixing Ratio by Volume</p> <p>Work Time at 25°C:</p> <p>Minimum Cure Time at 15°C</p> <p>Minimum Cure Time at 25°C</p> <p>Minimum Cure Time at 35°C</p> <p>Minimum Application Temperature</p> <p>Viscosity Part A at 25°C</p> <p>Viscosity Part B at 25°C</p> <p>Mixed Viscosity at 25°C</p> <p>S.G. Part A at 25°C</p> <p>S.G. Part B at 25°C</p> <p>Mixed S.G. at 25°C</p> <p>Colour Part A</p> <p>Colour Part B</p> <p>Appearance Mixed</p>	<p>5 Part A to 1 Part B</p> <p>30 minutes</p> <p>48 hours</p> <p>24 hours</p> <p>12 hours</p> <p>10°C</p> <p>45000 - 55000cps</p> <p>75-90cps</p> <p>10000cps</p> <p>1.60 - 1.70</p> <p>0.97 - 0.99</p> <p>1.54</p> <p>Grey</p> <p>Black</p> <p>Grey</p>

Technical Data Sheet

CURED PROPERTIES	Ultimate Compressive Strength - ASTM C579	115MPa
	Yield Compressive Strength - ASTM C579	95MPa
	Bond Strength Concrete - ASTM D4541	>3MPa
	Tensile Bond Strength Steel - ASTM D897	9.5MPa
	Modulus of Elasticity - ASTM C579	3GPa
	Flexural Strength - ASTM D790	60MPa
	Tensile Strength ASTM D638	28MPa
	Tensile Lap Shear Strength - ASTM D1002	8MPa (steel to steel)
	Hardness - Shore D - ASTM D2240-00	80
	Dielectric Strength (kV/mm)	58
	Surface Resistivity (Ohm) - ASTM D257	10 ¹²
	Volume Resistivity (Ohm.cm)	5.1x10 ¹⁰
	Peak Exotherm Temp - ASTM D2471	93.7°C (415ml)
	VOC (g/l) - ASTM D3960	3
	Water Vapour Transmission - ASTM E96/E96M	0.095 (gram/hr m ²)
Water Absorption - ASTM D570	0.066 Increase in weight (%)	
CHARACTERISTICS	<ul style="list-style-type: none"> • Very Low VOC • Pre-Metered Kits • Mixes Easily - Manually or Mechanically • Flowable, Can be poured under 5mm plates • Adheres and cures under adverse conditions (cold & damp) • Good strength retention after prolonged immersion in water 	<ul style="list-style-type: none"> • High strength permanent bonds • Excellent tensile and compressive strengths, superior to concrete • Excellent chemical resistance • Flash Point above 100°C
LAYER THICKNESS (Single Pour)	Minimum Grout Depth: 5mm Maximum Grout Depth: 50mm*	*To discuss your application and project requirements, please contact the Technical Department for further information and required pour thickness.
STEEL ANCHORING	For anchoring steel into concrete drill a hole approximately 1.5 diameters of the steel to be grouted. Any dust or foreign matter must be blown out with oil-free, dry compressed air. Set the steel into the hole and pour the above Megapoxy 206 Ultra formulation from one side to allow air to escape. The steel should be grit blasted and degreased to achieve good bond.	
TYPICAL PULL OUT STRENGTH - 40Mpa CONCRETE	14mm deformed bar inserted to depth 10 x diameter of bar >50kN 25mm deformed bar inserted to depth 8 x diameter of bar >150kN 14mm deformed bar inserted to depth 8 x diameter of bar >50kN 25mm deformed bar inserted to depth 10 x diameter of bar >150kN	

Technical Data Sheet

SURFACE PREPARATION	<p>Concrete</p> <p>Concrete should be free from grease and oil. If necessary, clean with industrial heavy duty degreaser. When clean, remove surface laitance. This is best done by mechanical abrasion such as scabbling, grit blasting or grinding. If this is not possible acid etching must be carried out. Mix concentrated hydrochloric acid with equal volume of water and spread at the rate of 0.5 litre per square meter of concrete surface. Allow to react for about 10 minutes and wash the area thoroughly and scrub with a stiff bristled broom to remove loose sand. Allow to dry for 24 hours. For maximum adhesion the concrete should be surface dry.</p> <p>Metal Surfaces</p> <p>Metals should be grit blasted to AS 1627.2.2002. If this is not possible, mechanically abrade the surface to a clean, bright metal surface. Once this abrasion is complete, degrease the surface by flooding with an industrial grade degreaser. Wire brushing is not entirely satisfactory and gives minimal adhesion only.</p> <p>Coated Surfaces</p> <p>It is recommend to remove all coatings prior to bonding, bonding to coated surfaces will give inferior bond strengths compared to bonding directly to a prepared substrate.</p> <p>Concrete:</p> <p>The surface may be either flame-cleaned, or mechanically treated with a scutching tool, to remove all traces of paint. Complete the preparation by diamond grinding or scabbling.</p> <p>Metals:</p> <p>Steps should be taken to remove all paint and/or galvanizing. Good quality paint stripper should be used, followed by grit blasting or grinding to a bright metal finish.</p>
MIXING PROCEDURE	<p>Add the entire contents of Part B into the Part A pail, there is enough space to combine both parts in the Part A container.</p> <p>Mix the two parts together thoroughly for 2 minutes, manually or using a mechanical stirrer on a low speed of 200rpm or lower, making sure to scrape the base and corners of the pail.</p> <p>Do not move the mixer up and down.</p> <p>Once 2 minutes is up, scrape the sides of the pail with a straight edge to remove unmixed Part A from the sides of the pail. Do not use the mixer head to scrape the sides.</p> <p>Mix for another 1 minute, if there is a black ring of Part B around the edge of the pail, lift the mixer slightly and lean the mixer back approximately 30°, this will change the resin flow and should pull the Part B into the mix.</p> <p>Ensure the mixture is thoroughly mixed, this is essential, as incomplete mixing will result in poor physical properties. Megapoxy 206 Ultra must be applied immediately after mixing. If ambient temperature is high, Megapoxy 206 Ultra should be stored in a cool place until used. High ambient temperatures will lead to shortened usable life. Topping up can be carried out at a later date when convenient. If you do not require adhesion of the Megapoxy 206 Ultra, form work surfaces should be coated with Megapoxy Wax or silicone based release agent.</p>
IMPORTANT INFORMATION	<p>It is essential that the correct mixing ratio be used and that the Part A and Part B are thoroughly mixed together before use. Inaccuracies and poor mixing will result in lower physical properties of the cured system and, if the error is sufficiently large, the system may not cure satisfactorily and discolour on ageing.</p>

Technical Data Sheet

CLEANING	To keep mixing implements and working tools clean, use Megapoxy Thinners. Use disposable rubber gloves to protect hands and maintain proper industrial hygiene. For further details refer to the Megapoxy 206 Ultra Safety Data Sheet.
PACKAGING	Megapoxy 206 Ultra is available in 8.8kg (approx. 6lt) and 25.3kg (approx.16lt) kits.
TECHNICAL SERVICE	All purchasers of Megapoxy Products, are encouraged to avail themselves of our Technical Service for our Megapoxy Products. The information in this Bulletin is correct at time of publication, however continual research and development is being carried out and specs may change without notice.

Megapoxy®

206 Accelerated

Heavy Duty Epoxy Grout



Technical Data Sheet

DESCRIPTION	Megapoxy 206 Accelerated is a two component, 100% solids, resin based, solvent-free, hydrophilic water displacing, flowable epoxy grout, designed specifically for use in civil engineering applications, where development of high compressive and impact strength is required.	
RECOMMENDED APPLICATIONS	<ul style="list-style-type: none"> • Pile Splicing • Pile Repair & Restoration • Locking Bearings • Rail Track Grouting • Core Hole Filling • Locking PT Cables 	<ul style="list-style-type: none"> • Grouting Machinery • Setting Anchor Bolts • Machinery Grouting • Bridge Bearing Pads • Floor Repairs • Filling Truncation Pockets
PROPERTIES	Mixing Ratio by Volume	5 Part A to 1 Part B
	Work Time at 25°C:	10 minutes
	Minimum Cure Time at 15°C	12 hours
	Minimum Cure Time at 25°C	6 hours
	Minimum Cure Time at 35°	3 hours
	Minimum Application Temperature	10°C
	Viscosity Part A at 25°C	20000 - 30000cps
	Viscosity Part B at 25°C	75-90cps
	Mixed Viscosity at 25°C	5000cps
	S.G. Part A at 25°C	1.65 - 1.70
	S.G. Part B at 25°C	0.97 - 0.99
	Mixed S.G. at 25°C	1.56
	Colour Part A	Grey
	Colour Part B	Black
	Appearance Mixed	Grey
CURED PROPERTIES	Compressive Strength - ASTM D695	105Mpa
	Bond Strength Concrete - ASTM D4541	>3Mpa
	Tensile Bond Strength Steel - ASTM D897	13Mpa
	Modulus of Elasticity - ASTM D695	7.7Gpa
	Flexural Strength - ASTM D790	30Mpa
	Tensile Strength ASTM D638	40Mpa
	Tensile Shear Strength - ASTM D1002	14Mpa
	Hardness - Shore D - ASTM D2240-00	80
	Dielectric Strength 50Hz @25°C(Kv/mm)	17

Technical Data Sheet

CHARACTERISTICS	<ul style="list-style-type: none"> • VOC Free • Pre-Metered Kits • Mixes Easily - By Hand or Mechanically • Flowable, Can be poured under 5mm plates • Adheres and cures under adverse conditions (cold & damp) • Good strength retention after prolonged immersion in water • High strength permanent bonds • Excellent tensile and compressive strengths, superior to concrete • Excellent chemical resistance • Flash Point above 100°C
SURFACE PREPARATION	<p>Concrete</p> <p>Concrete should be free from grease and oil. If necessary, clean with industrial heavy duty degreaser. When clean, remove surface laitance. This is best done by mechanical abrasion such as scabbling, grit blasting or grinding. If this is not possible acid etching must be carried out. Mix concentrated hydrochloric acid with equal volume of water and spread at the rate of 0.5 litre per square meter of concrete surface. Allow to react for about 10 minutes and wash the area thoroughly and scrub with a stiff bristled broom to remove loose sand. Allow to dry for 24 hours. For maximum adhesion the concrete should be surface dry.</p> <p>Metal Surfaces</p> <p>Metals should be grit blasted to AS CK 9.4 - 1964 Class 3 finish. If this is not possible, mechanically abrade the surface to a clean, bright metal surface. Once this abrasion is complete, degrease the surface by flooding with an industrial grade degreaser. Wire brushing is not entirely satisfactory and gives minimal adhesion only.</p> <p>Coated Surfaces</p> <p>It is recommend to remove all coatings prior to bonding, bonding to coated surfaces will give inferior bond strengths compared to bonding directly to a prepared substrate.</p> <p>Concrete:</p> <p>The surface may be either flame-cleaned, or mechanically treated with a scutching tool, to remove all traces of paint. Complete the preparation by diamond grinding or scabbling.</p> <p>Metals:</p> <p>Steps should be taken to remove all paint and/or galvanizing. Good quality paint stripper should be used, followed by grit blasting or grinding to a bright metal finish.</p>

Technical Data Sheet

<p>MIXING PROCEDURE</p>	<p>Add the entire contents of Part B into the Part A drum, there is enough space to combine both parts in the Part A container.</p> <p>Mix the two parts together thoroughly for 2 minutes, by hand or using a mechanical stirrer on a low speed of 200rpm or lower, making sure to scrape the base and corners of the drum.</p> <p>Do not move the mixer up and down.</p> <p>Once 2 minutes is up, scrape the sides of the drum with a straight edge to remove unmixed Part A from the sides of the drum. Do not use the mixer head to scrape the sides.</p> <p>Mix for another 1 minute, if there is a black ring of Part B around the edge of the drum, lift the mixer slightly and lean the mixer back approximately 30°, this will change the resin flow and should pull the Part B into the mix.</p> <p>Ensure the mixture is thoroughly mixed, this is essential, as incomplete mixing will result in poor physical properties. Megapoxy 206 Accelerated must be applied immediately after mixing. If ambient temperature is high, Megapoxy 206 Accelerated should be stored in a cool place until ready to be used. High ambient temperatures will lead to shortened usable life. Topping up can be carried out at a later date when convenient. If you do not require adhesion of the Megapoxy 206 Accelerated form work surfaces should be coated with Megapoxy Wax or silicone based release agent.</p>
<p>IMPORTANT INFORMATION</p>	<p>It is essential that the correct mixing ratio be used and that the Part “A” and Part “B” are thoroughly mixed together before use. Inaccuracies and poor mixing will result in lower physical properties of the cured system and, if the error is sufficiently large, the system may not cure satisfactorily and discolour on ageing.</p>
<p>CLEANING</p>	<p>To keep mixing implements and working tools clean, use Megapoxy Thinners.</p> <p>Use disposable rubber gloves to protect hands and maintain proper industrial hygiene.</p> <p>For further details refer to the Megapoxy 206 Accelerated Safety Data Sheet.</p>
<p>PACKAGING</p>	<p>Megapoxy 206 Accelerated is available in 6lt kits.</p>
<p>TECHNICAL SERVICE</p>	<p>All purchasers of Megapoxy Products, are encouraged to avail themselves of our Technical Service for our Megapoxy Products. The information in this Bulletin is correct at time of publication, however continual research and development is being carried out and specs may change without notice.</p>

Megapoxy®

Deep Pour Grout

Heavy Duty Deep Pour Epoxy Grout



Technical Data Sheet

DESCRIPTION	Megapoxy Deep Pour Grout is a two component, 100% solids, resin based, solvent-free, flowable epoxy grout, designed specifically for use in civil engineering applications, where development of high compressive and impact strength is required. Suitable for deep void grouting where a single pour application is required.	
RECOMMENDED APPLICATIONS	<ul style="list-style-type: none"> • Grouting Machinery • Rail Track Pads • Rail Grouting • Core Hole Filling • Locking PT Cables 	<ul style="list-style-type: none"> • High Load Vibration Grouting • Chocking Machinery • Bridge Bearing Pads • Baseplate Grouting • Filling Truncation Pockets
PROPERTIES	Mixing Ratio by Volume	5 Part A to 1 Part B
	Work Time at 25°C:	60 minutes
	Minimum Cure Time at 15°C	48 hours
	Minimum Cure Time at 25°C	24 hours
	Minimum Cure Time at 35°C	12 hours
	Minimum Application Temperature	10°C
	Mixed Viscosity at 25°C	60000cps
	Mixed S.G. at 25°C	1.71
	Colour Part A	Grey
	Colour Part B	Amber
	Appearance Mixed	Grey
CURED PROPERTIES	Ultimate Compressive Strength - ASTM C579	125MPa
	Yield Compressive Strength - ASTM C579	80MPa
	Bond Strength Concrete - ASTM D4541	>3MPa
	Tensile Bond Strength Steel - ASTM D897	19MPa
	Modulus of Elasticity - ASTM C579	3.3GPa
	Flexural Strength - ASTM D790	72MPa
	Tensile Strength ASTM D638	38MPa
	Tensile Lap Shear Strength - ASTM D1002	9MPa (steel to steel)
	Hardness - Shore D - ASTM D2240-00	88
	Dielectric Strength (kV/mm)	52.7
	Surface Resistivity (Ohm) - ASTM D257	10 ¹²
	Volume Resistivity (Ohm.cm)	1.25x10 ¹¹
	Peak Exotherm Temp - ASTM D2471	40.5°C (415ml)

Technical Data Sheet

CHARACTERISTICS	<ul style="list-style-type: none"> • Low VOC • 2 Part Pre-Metered Kits • Mixes Easily Mechanically • Low Exotherm • Flowable, can be poured under 20mm plates • High strength permanent bonds • Excellent tensile and compressive strengths, superior to concrete • Excellent chemical resistance • Good strength retention after prolonged immersion in water 						
LAYER THICKNESS	<table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 60%;">Minimum Grout Depth:</td> <td style="text-align: right;">50mm</td> </tr> <tr> <td>Maximum Grout Depth:</td> <td style="text-align: right;">300mm*</td> </tr> </table> <p>*To discuss your application and project requirements, please contact the Technical Department for further information and required pour thickness.</p>	Minimum Grout Depth:	50mm	Maximum Grout Depth:	300mm*		
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STRENGTH DEVELOPMENT	<table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 60%;">Day 1:</td> <td style="text-align: right;">57MPa</td> </tr> <tr> <td>Day 2:</td> <td style="text-align: right;">80MPa</td> </tr> <tr> <td>Day 7:</td> <td style="text-align: right;">86MPa</td> </tr> </table> <p>*ASTM C579-23</p>	Day 1:	57MPa	Day 2:	80MPa	Day 7:	86MPa
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Day 7:	86MPa						
SURFACE PREPARATION	<p>Concrete</p> <p>Concrete should be free from grease and oil. If necessary, clean with industrial heavy duty degreaser. When clean, remove surface laitance. This is best done by mechanical abrasion such as scabbling, grit blasting or grinding. If this is not possible acid etching must be carried out. Mix concentrated hydrochloric acid with equal volume of water and spread at the rate of 0.5 litre per square meter of concrete surface. Allow to react for about 10 minutes and wash the area thoroughly and scrub with a stiff bristled broom to remove loose sand. Allow to dry for 24 hours. For maximum adhesion the concrete should be surface dry.</p> <p>Metal Surfaces</p> <p>Metals should be grit blasted to AS 1627.2.2002. If this is not possible, mechanically abrade the surface to a clean, bright metal surface. Once this abrasion is complete, degrease the surface by flooding with an industrial grade degreaser. Wire brushing is not entirely satisfactory and gives minimal adhesion only.</p> <p>Coated Surfaces</p> <p>It is recommend to remove all coatings prior to bonding, bonding to coated surfaces will give inferior bond strengths compared to bonding directly to a prepared substrate.</p> <p>Concrete:</p> <p>The surface may be either flame-cleaned, or mechanically treated with a scutching tool, to remove all traces of paint. Complete the preparation by diamond grinding or scabbling.</p> <p>Metals:</p> <p>Steps should be taken to remove all paint and/or galvanizing. Good quality paint stripper should be used, followed by grit blasting or grinding to a bright metal finish.</p>						

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<p>MIXING PROCEDURE</p>	<p>Add the entire contents of Part B into the Part A pail, there is enough space to combine both parts in the Part A container.</p> <p>Mix the two parts together thoroughly for 3 minutes, using a mechanical stirrer on a low speed of 200rpm - 400rpm, making sure to scrape the base and corners of the pail.</p> <p>Do not move the mixer up and down.</p> <p>Once 3 minutes is up, scrape the sides of the pail with a straight edge to remove unmixed Part A from the sides of the pail. Do not use the mixer head to scrape the sides.</p> <p>Mix for another 2 minutes, if there is a ring of Part B around the edge of the pail, lift the mixer slightly and lean the mixer back approximately 30°, this will change the resin flow and should pull the Part B into the mix.</p> <p>Ensure the mixture is thoroughly mixed, this is essential, as incomplete mixing will result in poor physical properties. Megapoxy Deep Pour Grout must be applied immediately after mixing. If ambient temperature is high, Megapoxy Deep Pour Grout should be stored in a cool place until used. High ambient temperatures will lead to shortened usable life. Topping up can be carried out at a later date when convenient. If you do not require adhesion of the Megapoxy Deep Pour Grout, form work surfaces should be coated with Megapoxy Wax or silicone based release agent.</p>
<p>IMPORTANT INFORMATION</p>	<p>It is essential that the correct mixing ratio be used and that the Part A and Part B are thoroughly mixed together before use. Inaccuracies and poor mixing will result in lower physical properties of the cured system and, if the error is sufficiently large, the system may not cure satisfactorily and discolour on ageing.</p>
<p>CLEANING</p>	<p>To keep mixing implements and working tools clean, use Megapoxy Thinners.</p> <p>Use disposable rubber gloves to protect hands and maintain proper industrial hygiene.</p> <p>For further details refer to the Megapoxy Deep Pour Grout Safety Data Sheet.</p>
<p>PACKAGING</p>	<p>Megapoxy Deep Pour Grout is available in 23kg kits. (approx. 14lts)</p>
<p>TECHNICAL SERVICE</p>	<p>All purchasers of Megapoxy Products, are encouraged to avail themselves of our Technical Service for our Megapoxy Products. The information in this Bulletin is correct at time of publication, however continual research and development is being carried out and specs may change without notice.</p>

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