Polyester resin grouts

Uses

Lokfix are used for high strength corrosion resistant anchoring of bolts and bars from 12 - 51mm diameter into concrete, rock, masonry or brickwork where high speed of installation and early application of load is required.

Permanent installation of reinforcement starter bars, foundation bolts, base plates, balustrading, barriers and safety fences, railway tracks, tie-back anchors, reinforcement dowelling abutments, ground anchors for towers, cranes, dock sills.

Advantages

- Rapid strength gain
- Vibration resistant
- Corrosion resistant
- Non expansive
- Can be placed under water

Standards and specifications

Materials tested in accordance with
BS 4551
BS5080
BS2782

Description

The three versions of Lokfix polyester resin grout are all pre-measured, two part, filled polyester resin grouts. After hardening the grout produces anchorages of consistent reproducible values.

The versions are:
- Lokfix L (Large aggregate)
- Lokfix S (Small aggregate)
- Lokfix P (Pumpable grade)

Lokfix L is used where hole diameter exceeds bar diameter by 25 to 50mm.

Lokfix S is used where the difference between the hole diameter and bar diameter is ≤25mm.

Lokfix P is used in overhead or horizontal holes where bar / hole relationship conforms to Lokfix polyester resin grout S.

The thixotropic nature of Lokfix polyester resin grout P reduces flow of grout out of the hole.

Technical support

Fosroc offers a comprehensive range of high performance, high quality concrete repair and construction products. In addition, Fosroc offers technical support service to specifiers, end-users and contractors, as well as on-site technical assistance in locations all over the country.

Design criteria

The version of Lokfix grout to be used will depend upon ambient temperature and anchor conditions.

The high strength of the cured resin permits strong anchors to be created. The ultimate bond strength developed depends upon:

- Strength of host material
- Length of resin bond to bar
- Hole preparation and formation
- Type and dimension of bar

The following formula may be used to determine the minimum depth of installation for Type 1 rebar bolts, to ensure the shear stress within the concrete is kept within the limits set out in BS 8110.

Minimum hole depth = \( \frac{0.6Y \cdot P_{d 1}^2}{S \cdot P_{d 2}} \cdot \frac{4}{Y_d^2} \)

where Y is characteristic yield strength of steel (460 N/mm²)

S is permitted shear stress in concrete (N/mm²)

d₁ is bar diameter (mm)

d₂ is hole diameter (mm)

This formula is used typically as shown in Table 1.

| Table 1 |
|------------------|------------------|------------------|
| Minimum hole depth (mm) | Minimum hole depth (mm) |
| Characteristic concrete strength (N/mm²): | 20 | 25 | 30 | > 40 |
| Permitted concrete shear stress using Type One Bar (N/mm²): | 1.8 | 2.0 | 2.2 | 2.5 |
| Bar diameter (tonnes) | Hole diameter (mm) | Minimum hole depth (mm) |
|------------------|------------------|------------------|------------------|------------------|
| | | | | |
| 12 | 5.2 | 20 | 280 | 250 | 225 | 200 |
| 16 | 9.3 | 20 | 490 | 445 | 400 | 355 |
| 20 | 14.5 | 25 | 615 | 555 | 500 | 440 |
| 25 | 22.6 | 32 | 750 | 675 | 615 | 540 |
| 32 | 37.0 | 38 | 1035 | 930 | 845 | 745 |
| 40 | 57.8 | 45 | 1365 | 1225 | 1115 | 980 |
**Properties**

<table>
<thead>
<tr>
<th>Temp(°C)</th>
<th>Gel time (min)</th>
<th>Minimum time required before loading (hours)</th>
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<tbody>
<tr>
<td>20</td>
<td>80</td>
<td>7</td>
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<tr>
<td>40</td>
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Compressive strength: After the minimum time required before loading the grout typically attains a compressive strength in excess of 20N/mm² and an ultimate compressive strength of 70N/mm² in 7 days (50mm x 50mm x 50mm) when tested as per BS 6319 Part 2: 1983.

Chemical resistance: The cured resin is resistant to fresh and salt water, petrol, oils, grease and most acids, alkalis and solvents.

**Application instructions**

**Selection of grout version**

The version of Lokfix chosen will depend on anchor conditions (see description).

**Parameters of anchor design**

The high strength of the cured resin permits strong anchors to be created. Ultimate strength is determined by:
- Strength of host material
- Length of resin bond to bar
- Hole preparation and formation
- Type and dimension of bar

**Note**: The graph illustrates typical failure loads.

Minimum safety factors of 1.5 in non critical and of 2 in critical cases should be considered for design purposes. Wherever relevant, the local code of practice or standard must also be considered in relation to anchorage length.

**Hole preparation and formation**

Optimum performance of Lokfix requires rough sided, dust free holes. Uses of rotary percussive drills with air or water flushing is recommended.

Diamond drilled holes should be under-reamed unless necessary safety factors are incorporated.

Cast holes should preferably be inverse dovetail configuration. If parallel sides holes are cast they should be rough to provide adequate keying.

**Bar preparation**

All bars should preferably be degreased and all flaky rust removed.

**Mixing**

A complete pack of resin and catalysed filler should be mixed in one operation. Mixing may be carried out mechanically. When a smooth, even consistency is achieved the grout is ready for use and should be placed well within the gel time of the grout (see properties).

Packs have been designed to produce practical and economic volumes of grout.

Do not attempt to mix partial pack components.

**Installation**

**Lokfix polyester resin grout S & L**

Using the calculated volume of grout based on Table 1, the grout should be poured steadily into the prepared holes. The anchor bar is then pressed into the hole to the required depth. Slight agitation of the bar will assist in achieving a complete bond. The bar should then be left undisturbed in the required position until the resin is set.

**Lokfix polyester resin grout P**

The grout should be injected to the rear of the hole to avoid air entrapment. The thixotropic nature of Lokfix P will prevent significant flow of resin out of the hole.

**Cleaning**

Any mixing drums, pumps, etc. should be cleaned within the pot life of the grout. Nitoflor Sol is available for this purpose.
Precautions

Fire resistance and creep

At operating temperatures above 40°C, the creep of Lokfix polyester resin grout resin under load may become significant. Resin anchors should not be used where structural load bearing performance has to be maintained in anchors subjected to fire conditions.

Health and safety instructions

Confined areas must be well ventilated and no naked flames allowed. Contact with the skin should be avoided as certain sensitive skins may be affected by contact with the polyester resin. In such cases if contact with the resin occurs, the skin should be washed immediately with soap and water - not solvent. Gloves and barrier creams should be used when handling these products. Eye contamination must be immediately washed with plenty of water and medical treatment sought.

Fire

Lokfix polyester resin grout resin is flammable. Confined areas must be well ventilated and no naked flames allowed. Do not smoke during use.

Flash point

Lokfix S,L, P 29°C
Nitoflor Sol 33°C

Additional information

The Fosroc range of associated products includes high strength cementitious grouts, epoxy grouts. Also available a range of products for use in construction; viz., admixtures, curing compounds, release agents, flooring systems and repair mortars.

Separate datasheets are available on these products.

Table 1

Quantity estimating guide

Table indicates volume of Lokfix polyester resin grout grout in cm³ /100mm bond

<table>
<thead>
<tr>
<th>Hole diameter mm</th>
<th>12</th>
<th>16</th>
<th>20</th>
<th>25</th>
<th>32</th>
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<td>280</td>
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These figures allow for a 25% wastage factor.
If the anchor is in very old concrete, masonry or brickwork the wastage factor should be increased.

No of bolts/200 mm deep hole which can be fixed using a 2.5 litre pack of Lokfix

<table>
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<tr>
<th>Hole diameter mm</th>
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<th>20</th>
<th>25</th>
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Estimating

Packaging

Lokfix S/P/L : 0.5 and 2.5 L Packs
Nitoflor Sol  : 5 litres and 20 litres.

Storage

The product should be stored away from high temperature. 6 months shelf life when stored below 25°C in original unopened containers.
Important note:

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<th>Kolkata</th>
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<td>30/B Jodhpur Park</td>
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<td>Opp: Vivek Cinema, Main Patel Rd</td>
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<tr>
<td>Bangalore 560 080</td>
<td>Navi Mumbai 400 703</td>
<td>New Delhi 110 008</td>
<td>Kolkata 700 068</td>
</tr>
<tr>
<td>Fax : 080-2361 7454</td>
<td>Fax: 022 - 2789 6413</td>
<td>Fax: 011-25884422</td>
<td>Fax: 033-2472 9921</td>
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<tr>
<td>email: <a href="mailto:Bangalore@fosroc.com">Bangalore@fosroc.com</a></td>
<td>email:<a href="mailto:Mumbai@fosroc.com">Mumbai@fosroc.com</a></td>
<td>email:<a href="mailto:Delhi@fosroc.com">Delhi@fosroc.com</a></td>
<td>email:<a href="mailto:Kolkata@fosroc.com">Kolkata@fosroc.com</a></td>
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Ahmedabad : (079) 26762799   Ankleshwar : (02646) 220704/224687   Bhubaneshwar : (0674) 2521176   Chennai : (044) 24899949/24853383
Chandigarh: (0172) 2639360   Cochin : (0484) 2356666   Coimbatore : (0422) 2472966   Goa : (0832) 2542465   Guwahati (0361) 2548793
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