

PRODUCT DATA SHEET

SikaGrout®-928

(formerly MFlow 928)

High-strength, non-shrink cementitious precision grout for placement by pouring or pumping

PRODUCT DESCRIPTION

SikaGrout®-928 is a one-part, high-strength, non-shrink cementitious precision grout. When mixed with water, SikaGrout®-928 forms a mortar with a fluid consistency which can be easily applied by hand or machine. It has very good flow properties without segregation or bleeding.

USES

SikaGrout®-928 is used for:

- Creating a load-transferring, supporting, force transmitting bond between concrete foundations and machines, steel bed plates and high shelving pillars
- Precision grouting of machines, turbines, pumps and generators
- Force-transmitting grouting of prefabricated concrete pillars in hole footings
- Creating a void-free bond between components and reinforced or non-reinforced concrete
- Anchoring of bolts and reinforcing bars
- Concrete exposure classes XC 1-4, XF 1-4, XD 1-3, XS 1-3 and XA 1-2 as described in EN 206

SikaGrout®-928 is used for interior and exterior applications.

Please note:

- The Product may only be used by experienced professionals.
- In case of severe dynamic operating forces and repetitive loading such as founding in steel and aluminium rolling mills, crane rails and heavy presses, consider using the metallic-aggregate-reinforced grout SikaGrout®-4800.

CHARACTERISTICS / ADVANTAGES

- Shrinkage-compensated both in plastic and hardening stage
- Easy to apply
- Good flowability
- No segregation or bleeding
- Can be pumped into intricate areas
- High early and final strengths
- Very good durability
- Controlled expansion for very good adhesion and volume filling
- Minimal cracking due to controlled expansion
- Very good freeze-thaw and de-icing salt resistance

ENVIRONMENTAL INFORMATION

- Environmental Product Declaration (EPD) in accordance with EN 15804. EPD independently verified by Institut für Bauen und Umwelt e.V. (IBU)

APPROVALS / STANDARDS

- CE marking and declaration of performance based on EN 1504-6:2004 Products and systems for the protection and repair of concrete structures — Anchoring reinforcing steel bar

PRODUCT INFORMATION

Chemical Base	Cement, selected aggregates and special additives	
Packaging	Standard bag	25 kg
	Bulk bag	1000 kg on request
	Refer to the current price list for available packaging variations.	
Colour	Grey	
Shelf Life	Refer to product packaging.	
Storage Conditions	The Product must be stored in original, unopened and undamaged sealed packaging in dry conditions at temperatures between +5 °C and +30 °C. Always refer to the packaging. Refer to the current Safety Data Sheet for information on safe handling and storage.	
Colour	Powder	

TECHNICAL INFORMATION

Compressive Strength	1 day	$\geq 30 \text{ N/mm}^2$	(EN 12190)
	3 days	$\geq 50 \text{ N/mm}^2$	
	7 days	$\geq 60 \text{ N/mm}^2$	
	28 days	$\geq 65 \text{ N/mm}^2$	
	All data determined at +21 °C.		
Modulus of Elasticity in Compression	$\geq 23,000 \text{ N/mm}^2$		
Flexural Strength	1 day	$\geq 5 \text{ N/mm}^2$	(EN 12190)
	3 days	$\geq 6 \text{ N/mm}^2$	
	7 days	$\geq 7 \text{ N/mm}^2$	
	28 days	$\geq 8 \text{ N/mm}^2$	
	All data determined at +21 °C.		
Pull-Out Resistance	Pull-out strength (Displacement at load of 75 kN)	$\leq 0.6 \text{ mm}$	(EN 1881)
Freeze Thaw De-icing Salt Resistance	Freeze – Thaw Scaling (56 cycles)	$< 0.10 \text{ kg/m}^2$ (= classification: "very good")	(SS 137244)

APPLICATION INFORMATION

Mixing Ratio	Refer to product packaging.	
Consumption	Approx. 1,900 kg powder is needed to prepare 1 m ³ of fresh mortar.	
Yield	12–13 L grout per 25 kg bag Note: Consumption data is theoretical and does not allow for any additional material due to surface porosity, surface profile, variations in level, wastage or any other variations. Apply the Product to a test area to calculate the exact consumption for the specific substrate conditions and proposed application equipment.	
Product Temperature	Maximum	+30 °C
	Minimum	+5 °C
Ambient Air Temperature	Maximum	+30 °C
	Minimum	+5 °C

Substrate Temperature	Maximum	+30 °C
	Minimum	+5 °C
Pot Life	At +20 °C	60 minutes
	Pot life depends on temperature Note: Pot life will be shorter at higher temperatures. Pot life will be longer at lower temperatures.	
Waiting time	At +20 °C	Removal of formwork after approx. 12 hours
Fresh mortar density	Approx. 2.2 kg/L	

VALUE BASE

All technical data stated in this Data Sheet are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

ECOLOGY, HEALTH AND SAFETY

Local safety regulations must be observed and it advisable to wear PPI when working with this product with particular attention paid to cutting and handling. Transportation Class: The product is not classified as hazardous good for transport. Disposal: The material is recyclable. Disposal must be according to local regulations. Please contact your local Sika sales organisation for more information.

APPLICATION INSTRUCTIONS

SUBSTRATE PREPARATION

CONCRETE

The substrate must be structurally sound, thoroughly clean, free from oil, grease, dust, loose material, surface contamination and materials which will reduce adhesion strength.

1. Remove delaminated, weak, damaged and deteriorated substrate using suitable mechanical preparation techniques such as high-pressure water jetting or abrasive blast cleaning equipment.
2. Remove any debris from pockets or holes for structural fixings.

The substrate is structurally sound, thoroughly clean, and has a textured finish exposing the aggregate.

ALIGNING EQUIPMENT

1. Set and align equipment.
2. If shims are to be removed after the grout has set, lightly grease them for easy removal.

SHUTTERING OR FORMWORK

1. Select suitable formwork (permanent or temporary) of sufficient strength to contain the grout around areas such as base plates.
2. Construct formwork around machines so that it is at least 2 cm higher than the bottom of the plate to be underpoured.
3. Ensure all edges and joints of the formwork are sealed tightly to prevent leakage or seepage of the grout.
4. If vacuum extraction equipment is not used to remove pre-wetting water, ensure the formwork com-

- prises outlets for the pre-wetting water to drain.
5. Coat all surfaces of the formwork that will come into contact with the grout with polyethylene film or release agent to prevent adhesion.
6. Construct a header box or hopper on one side of the formwork to maintain a minimum grout head of 150 mm to 200 mm during the grouting process.

PRE-WETTING

1. Thoroughly saturate the prepared concrete substrate with clean water.
 2. Do not allow the substrate to dry within this time.
 3. Remove all water from within the formwork, cavities or pockets.
- The final surface has a dark matt appearance (saturated-surface-dry) without glistening.

MIXING

ELECTRIC SINGLE OR DOUBLE PADDLE MIXER
IMPORTANT

Do not add more water than the maximum specified

1. Pour the minimum amount of water into a suitable clean mixing container.
2. Stir the water slowly with a spiral paddle (300–500 rpm).
3. Add the complete bag of powder into the water.
4. Mix continuously for 3 minutes, until a uniform mix is achieved.
5. Within the mixing time, add more water up to the maximum allowed until the required consistency is achieved.
6. Wait for 2–3 minutes to release entrained air bubbles.
7. Remix briefly for maximum 1 minute.
8. Do not retemper grout by adding water or remixing after it stiffens.

FORCED ACTION PAN MIXER (NOT CONTINUOUS)
IMPORTANT

Carry out equipment trials

Carry out equipment trials to make sure the Product can be mixed satisfactorily before full project application.

IMPORTANT

Do not use continuous mixing equipment

The Product is not designed for processing with continuous mixing equipment.

1. Pour the minimum amount of water according to the mixing ratio into the mixer.
2. While stirring the water, slowly add the powder.
3. Within the mixing time, add more water up to the maximum allowed until the required consistency is

- achieved.
- Mix continuously for a minimum of 3 minutes. For larger mixes the mixing time must be extended to approximately 5 minutes or as necessary.
 - Mix until the material achieves a lump-free, smooth consistency.
 - Do not retemper grout by adding water or remixing after it stiffens.

APPLICATION

IMPORTANT

Strictly follow installation procedures

Strictly follow installation procedures as defined in Method Statements, application manuals and working instructions which must always be adjusted to the actual site conditions.

IMPORTANT

Risk of cracking due to application in direct sun or strong winds

- Do not apply the Product in direct sun, strong winds or both.

IMPORTANT

Risk of reduced strength gain and impaired physical properties in cold weather

Take the following measures in cold weather:

- Store bags in a warm environment.
- Use warm mixing water to assist with achieving strength gain and maintaining physical properties.

IMPORTANT

Risk of cracking and impaired physical properties in hot weather

Take the following measures in hot weather:

- Store bags in a cool environment.
- Use cold mixing water to assist with controlling the exothermic reaction to reduce cracking and to maintain physical properties.

PLACING: MANUAL APPLICATION

Preconditions

Nearby operating equipment that causes excess vibration of the foundation or base plate has been shut down. It must remain shut down until the newly-placed grout has finally set.

Material has been left in the mixing container for ~3 minutes to release entrained air bubbles.

- Pour the mixed grout into the formwork or header box from one side only.
- Ensure continuous grout flow during the complete grouting operation. Avoid trapping air.
- Ensure the grout fills the entire space to be grouted and makes full contact with the underside of any base plate.
- Use rods or straps to improve grout flow in large, inaccessible areas. Do not use vibrating equipment.

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PLACING: PUMP APPLICATION

Use grout pumps for large volume placement. Conduct equipment trials to confirm the product can be pumped satisfactorily before full project application.

SURFACE FINISHING

- Finish exposed grout surfaces to the required surface texture as soon as the grout has started to stiffen. Do not add water to the surface and do not overwork the surface during finishing.
- Remove the formwork when the grout has initially hardened.
- Trim the grout shoulders while the concrete is "green". Minimise shoulders to avoid cracking.

CURING TREATMENT

Protect exposed grout surfaces after finishing from premature drying and cracking using an appropriate curing method such as curing compounds, moist geotextile membranes, hessian or polythene sheeting. In cold weather, apply insulated blankets to maintain a constant temperature to prevent surface damage from freezing and frost.

CLEANING OF TOOLS

Clean all tools and application equipment with water immediately after use. Hardened material can only be removed mechanically.

LOCAL RESTRICTIONS

Note that as a result of specific local regulations the declared data and recommended uses for this product may vary from country to country. Consult the local Product Data Sheet for the exact product data and uses.

LEGAL NOTES

The information, and, in particular, the recommendations relating to the application and end-use of Sika products, are given in good faith based on Sika's current knowledge and experience of the products when properly stored, handled and applied under normal conditions in accordance with Sika's recommendations. In practice, the differences in materials, substrates and actual site conditions are such that no warranty in respect of merchantability or of fitness for a particular purpose, nor any liability arising out of any legal relationship whatsoever, can be inferred either from this information, or from any written recommendations, or from any other advice offered. The user of the product must test the product's suitability for the intended application and purpose. Sika reserves the right to change the properties of its products. The proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users must always refer to the most recent issue of the local Product Data Sheet for the product concerned, copies of which will be supplied on request.

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