

## PENAFLOW PANEL GROUT

### General Purpose Non Shrink Class A Cementitious Grout

#### DESCRIPTION

Aftek Penaflow Panel Grout is a Class A construction grout based on a blend of Portland cement, high quality graded aggregates and additives, which control expansion whilst the grout is in a plastic state.

#### RECOMMENDED USES

- General purpose grout
- Grouting underneath precast panels and concrete sections
- Anchor bolts filling
- Filling in cavities, gaps and base infill's
- Filling in core holes created in panels by core drilling
- Suitable for block work in core filling

#### FEATURES AND BENEFITS

- Shrinkage compensated
- Gaseous expansion while in plastic state eliminates shrinkage and settlement
- Non-metallic iron content eliminates staining
- Can be dry packed, rammed, troweled or poured
- Pump able for larger applications
- Grouting from 20mm to 150mm in a single application
- Australian made

#### APPLICATION INSTRUCTIONS

##### Surface and Substrate Preparation-

The substrate to be grouted must be clean, sound and free from dust, oil, grease, curing compounds or any foreign matter that will affect the grout adhesion bond. Bolt holes and anchor points must be clean and free of water.

##### Pre-Soaking-

All prepared areas must be saturated with water for a minimum of 4 hours prior to grouting. This will reduce the porosity of the substrate.

Prior to grouting, ensure all excess water is removed and all holes must be free from water and no puddles of water are present.

If grouting under base plates, it is imperative that bleed holes or venting holes are provided (this will eliminate pressure build up in a confined area).

##### Formwork-

It is essential that the formwork to be constructed is leak proof and water tight. In order to achieve this it is recommended that foam rubber strips or a suitable sealant such as polyurethane or silicone be used underneath the formwork.

The formwork should be constructed, which will allow and ensure a grout head is maintained on the side above the level of the underside at the base plate. The formwork should allow for gravity flow of grout with a suitable grout head allowing for continuous flow between the base plate and the concrete substrate.

To ensure ease of formwork removal, the formwork should be coated with form oil or release oil prior to grouting (consult ITLS-Aftek Technical Department for additional information).

It is recommended that Penaflow Panel Grout be kept in a cool environment and the use of cold water be used for mixing. It is recommended that in instances where the temperature is greater than 30° C, the grouting be conducted early in the day or late in the evening and sheltered from sunlight and direct heat.

**Mixing-**

Penaflo Panel Grout is ready to use, simply requiring the addition of water.

Penatech HS Grout must be mixed with a mechanical mixer with a high shear mixer or a suitable drum mixer that creates a forced action mixing.

For smaller quantity mixing, an electric drill with a spiral mixing paddle is suitable. The speed drill should be approx. 500-600 rpm.

**DO NOT MIX BY HAND.**

|                                    |                                   |
|------------------------------------|-----------------------------------|
| <b>Dry Pack/ Stiff Grout:</b>      | Add 2.7 - 2.9 litres per 20kg bag |
| <b>Plastic/ Trowellable Grout:</b> | Add 3.0 - 3.4 litres per 20kg bag |
| <b>Flowable/ Pourable Grout:</b>   | Add 3.6 - 4.0 litres per 20kg bag |

Always add the grout powder to the pre-measured water. **DO NOT ADD ADDITIONAL WATER AS GROUT WILL SEGREGATE AND BLEED AFFECTING PERFORMANCE.**

The selected water level should be accurately measured and added to a suitable mixing container.

Add the powder (grout) to the water and mix for 3-5 minutes until a homogeneous consistent mix is obtained.

**DO NOT ADD ADDITIONAL WATER OTHER THAN SPECIFIED ABOVE. DISCARD ANY GROUT THAT HAS STIFFENED OR IS UNWORKABLE.**

**Placement-**

Penaflo Panel Grout can be placed in three different ways:

1. Dry Pack/ Stiff Grout-  
(2.7 - 2.9 litres water per bag)

Ensure sufficient water is present to obtain a stiff/ dry pack consistency. If the grout is too dry, insufficient hydration of the cements will cause low strength gain and inadequate curing. Using a tamping rod or a suitable tamping tool, apply the grout in the required position tamping to ensure adequate compaction.

2. Gravity flow using header box-

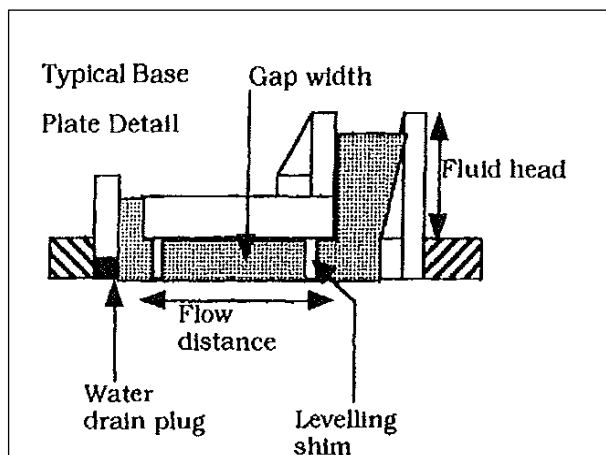
Mix the grout to a flowable consistency and pour grout from one side to avoid air entrapment. Ensure a grout head box is used and the grout head is maintained at all times. This will ensure continuous flow of grout without the possibility of air entrapment.

3. Large volume pumping-

Mix the grout using a forced action mixer. A positive displacement pump is the recommended pump for large placement application. For large grout pours ensure the grout is pumped from the bottom upwards as this will minimize any air entrapment and ensure complete void filling. For base plates pump from one side ensuring an air bleeder hole is available in the formwork or base plate to ensure any build-up of pressure is released from the bleeder hole.

**DO NOT VIBRATE OR USE MECHANICAL VIBRATOR TO ASSIST FLOW.**

For special grout application and placement contact an Aftek office for further details.



DRAWING 1.1

## Curing-

On completion of grout application, all exposed grout should be cured in accordance to 'good practices' in concrete curing. The exposed grout should be covered with plastic sheeting, wet hessian or wet liquid curing compounds such as the Curecon range at Aftek Curing Compounds. Consult your Aftek representative for advice on the most suitable product.

Curing plays a vital role in ultimate grout performance and strength development.

| TYPICAL PROPERTIES                  |  |
|-------------------------------------|--|
| Appearance                          | Grey powder (grey when mixed)                      |
| Fresh wet density Kg/m <sup>3</sup> | Approx. 2190 kg/m <sup>3</sup> (flowable/pourable) |
| Application Temp                    | Minimum 10° C<br>Maximum 30° C                     |
| Expansion characteristics           | Expansion 1-2%<br>Plastic state                    |
| Time for Expansion                  | Start 15 min<br>Finish 3 hrs (plastic state)       |
| Bleed                               | 0%   |
| Youngs Modulus                      | 25 GPa   |

## SETTING TIMES

| Consistency                      | Dry Pack | Trowellable | Flowable |
|----------------------------------|----------|-------------|----------|
| Initial Set (hours)              | 1.5      | 3.0         | 4.5      |
| Final Set (hours)                | 2.5      | 4.5         | 6.5      |
| Water requirement Litres per bag | 2.7-2.9  | 3.0-3.4     | 3.6-4.0  |

Tested at 20°C 50% RH  
Tested to AS 1012.18 for setting times

## COMPRESSIVE STRENGTH

| Age (Days) | Compressive Strength MPa | Flexural Strength MPa |
|------------|--------------------------|-----------------------|
| 1          | >20                      | >1.5                  |
| 3          | >30                      | >3.5                  |
| 7          | >40                      | >8.5                  |
| 28         | >55                      | >9.5                  |

Tested AS 1012.9 and AS2073 at 20°C for compressive strength  
Tested to ASTM C348-86 at 20 degrees for flexural strength.  
Tested at flowable consistency.

## BOND STRENGTH

| Age (Days) | Strength MPa |
|------------|--------------|
| 7          | >5MPa        |
| 28         | >10MPa       |

Tested to ASTM C882-1987, Slant shear method.

## YIELDS

| Consistency                                     | Dry Pack | Trowellable | Flowable |
|---|----------|-------------|----------|
| Litres of water per 20kg Bag                    | 2.7-2.9  | 3.0-3.4     | 3.6-4.0  |
| Yield per bag Litres                            | 10.3     | 10.6        | 11.0     |
| Fresh wet density kg/m <sup>3</sup>             | 2250     | 2220        | 2190     |
| Bags required per cubic metre (m <sup>3</sup> ) | 97       | 94          | 91       |

**SPECIFICATION CLAUSES****Performance specification-**

All grouting shown on the drawing 1.1 must be carried out with a pre-packaged cement based grout which is chloride free.

It shall be mixed with clean water to the required consistency. The plastic grout must not bleed or segregate.

A positive volumetric expansion shall occur while the grout is plastic by means of a gaseous system. The compressive strength of the grout must exceed 40 MPa at 7 days and 55 MPa at 28 days.

The storage and placement of the grout must be in strict accordance with the manufacturer's instructions.

**Supplier's specification-**

All grouting where shown on the drawing must be carried out using as manufactured by Aftek and used in accordance with the manufacturer's data sheet.

**PACKAGING**

Penaflow Panel Grout is supplied in 20kg poly lined bags- Item No. 204039

**STORAGE-SHELF LIFE**

Penaflow Panel Grout has shelf life of 9 months if stored in the original sealed packaging in dry, low humid environments.

**PRECAUTIONS**

- Unrestrained area must be kept to a minimum
- Do not add additional water other than what is specified
- Never apply mixed grout to a dry porous substance
- Refer to MSDS (material safety data sheet) prior to mixing
- Always apply grout in a continuous operation ensure grout head is maintained
- At low temperatures, grout setting time and strength gain will be extended
- At very high temperatures, grout will set and cure faster potentially causing cracking and delamination

For more detailed information, please read the MSDS for this product.

**CLEAN UP**

Wash all tools and equipment with fresh, clean water immediately after use. Penaflow Panel Grout can only be removed mechanically.

**HEALTH AND SAFETY**

Avoid contact with skin. Protective gloves and clothing are recommended when mixing or using this product. Please refer to full MSDS (material safety data sheet) for this product, which is available from Aftek upon request or through [www.aftek.com.au](http://www.aftek.com.au)

**TECHNICAL SUPPORT**

Aftek manufactures a comprehensive range of high quality and performance construction products. In addition, ITLS offers technical support and on-site advice to specifiers, end users and contractors.

Please contact your ITLS-Aftek sales representative or Head Office for this service.

The information and any recommendations relating to the application and end-use of all ITLS products are provided in good faith based on ITLS's knowledge and experience of the products. In applications, the differences in materials, and variances of substrates and actual site conditions can vary such that no warranty in respect of fitness for a particular purpose, nor any liability arising out of any legal relationship whatsoever, can be taken as inferred either from this information, or from any written recommendations, or from any other advice offered by ITLS. The proprietary rights of third parties must be observed. All orders are accepted subject to our sale terms and conditions. All users should always refer to the most recent and up to date issue of the Technical Data Sheet for the product concerned, which is available on request. It is recommended that products should always be properly stored, handled and applied under tested and recommended conditions. PLEASE CONSULT OUR TECHNICAL DEPARTMENT FOR FURTHER INFORMATION.