

# Conbextra HF



constructive solutions

## Shrinkage compensated cementitious precision grout

### Uses

Conbextra HF is used for free flow precision grouting in a wide range of applications. These critical uses include heavy duty support beneath machine base plates, bridge bearings and crane rails.

### Advantages

- Unique non-metallic dual expansion system compensates for shrinkage in both the plastic and hardened states
- Excellent initial flow and flow retention
- High early strength facilitates rapid installation and early operation of plant
- High ultimate strength and low permeability ensure durability of the hardened grout
- Hydrogen-free gaseous expansion
- Chloride free
- Suitable for pumping or pouring over a large range of application consistencies and temperatures

### Standards compliance

Conbextra HF conforms fully to U.S. Corps of Engineers Specification for non-shrink grout CRD-C621-82A and ASTM C1107-91 (Type C).

When Conbextra HF is specified for use at nuclear sites, it is manufactured and tested in accordance with the AWSI/ASME N45 "Quality Assurance Program Requirements for Nuclear Facilities".

Conbextra HF is suitable for use in contact with potable water. "Water Bye-laws Scheme - approved product" (Listing no. 9106511).

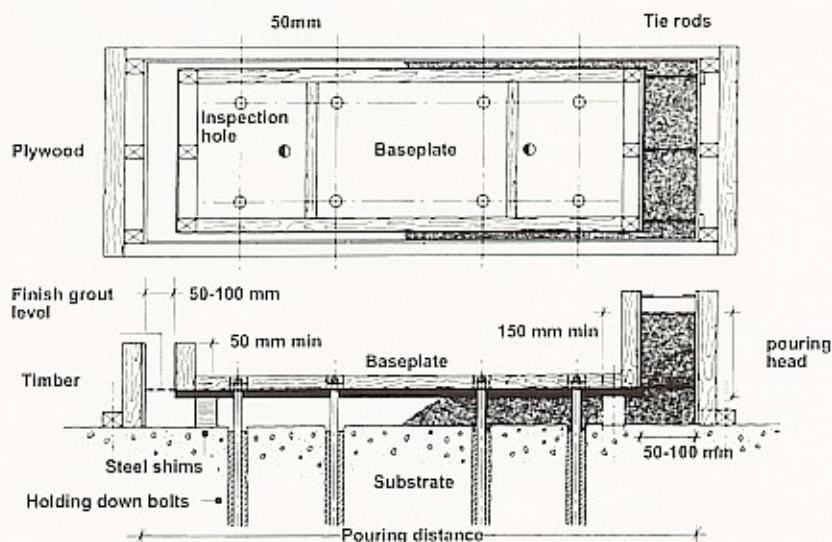
### Description

Conbextra HF is supplied as a ready to use dry powder. The addition of a controlled amount of clean water produces a free-flowing precision grout for gap thicknesses up to 125 mm. In addition the low water requirement ensures high early strength and long term durability.

Conbextra HF is a blend of Portland cements, graded fillers and chemical additives which impart controlled expansion in both the plastic and hardened states. The filler grading minimises segregation and bleeding over a wide range of application consistencies.

Figure 1: Typical specification drawing

Shuttering details: Installation and grouting of base plates



**Holding down bolts**  
Non-removable: Re-bar bolt (with/without extended thread length and sleeve).

Removable: Loksleeve bolt with stud - fully sleeved.

Removable: Loksleeve bolt with hexagon head, bolt, fully sleeved.

#### Shuttering

**Timber:** All timber to be 50 x 75 mm. Bolted to the substrate or fixed to baseplate where appropriate.

**Plywood:** All plywood to be 20 mm thick.

#### Levelling devices

Steel shims, elastic stools, double nuts. See note on alternative levelling devices in this data sheet.

For pouring head and pouring distances see table in this data sheet.

Drawing not to Scale.



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## Technical support

Fosroc offers a comprehensive range of high quality, high performance construction products. In addition, Fosroc offers a worldwide technical support and on-site service to specifiers, end-users and contractors.

## Properties

The following results were obtained at a water:powder ratio of 0.19 and temperature of 20°C.

Test method for	Typical result	
<b>Compressive strength</b>		
BS 1881 : part 116 1983:	20 N/mm <sup>2</sup> @ 1 day 44 N/mm <sup>2</sup> @ 7 days 56 N/mm <sup>2</sup> @ 14 days 64 N/mm <sup>2</sup> @ 28 days 82 N/mm <sup>2</sup> @ 180 days	
<b>Flexural strength</b>		
BS 4551 1980:	2.5 N/mm <sup>2</sup> @ 1 day 8.0 N/mm <sup>2</sup> @ 7 days 9.5 N/mm <sup>2</sup> @ 14 days 10.0 N/mm <sup>2</sup> @ 28 days 11.0 N/mm <sup>2</sup> @ 180 days	
<b>Flow characteristics</b> (Efflux time) CRD-C Cone: 19-25 seconds		
<b>Setting time</b>		
BS 4550 part 3 1978:		
Initial set:	5.5 hours	
Final set:	7.5 hours	
<b>Time for expansion</b>		
Plastic state:	Start	15 minutes
	Finish	initial set
Hardened state:	Start	initial set
	Finish	up to 28 days
Fresh wet density:	Approximately 2200 kg/m <sup>3</sup> depending on actual consistency used.	
<b>Young's modulus</b>		
ASTM C-469-83:	29 kN/mm <sup>2</sup>	
<b>Expansion characteristics:</b>		
An expansion of up to 2% when measured according to ASTM C 827 overcomes plastic settlement in the unset material. Longer term expansion in the hardened state is designed to comply with the requirements of ASTM C 1107-91 to compensate for drying shrinkage.		

## Specification clauses

### Performance specification

All precision grouting (specify details and areas of application) must be carried out with a pre-packaged cement based product, which is non-metallic and chloride-free.

It shall be mixed with clean water to the required consistency and not exhibit bleed or segregation.

A volumetric expansion of up to 2% shall occur while the grout is in a plastic state by means of a gaseous, hydrogen-free system. The grout must also be compensated for shrinkage in the hardened state.

The compressive strength of the grout must exceed 40 N/mm<sup>2</sup> at 7 days and 60 N/mm<sup>2</sup> at 28 days.

The grout shall fully conform to the requirements of US Army Corps of Engineers Specification for non-shrink grout CRD-C621 -82A or ASTM C 1107-91.

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

### Supplier specification

All precision grouting (specify details and areas of application) must be carried out using Conbextra HF manufactured by Fosroc and used in accordance with the manufacturer's data sheet.

## Application Instructions

### Preparation

#### Foundation surface

The substrate surface must be free from oil, grease or any loosely adherent material. If the concrete surface is defective or has laitance, it must be cut back to a sound base. Bolt holes or fixing pockets must be blown clean or any dirt or debris.

### Pre-soaking

Several hours prior to grouting, the area of cleaned foundation should be flooded with fresh water. Immediately before grouting takes place, any free water should be removed. Particular care should be taken to blow out all bolt holes and pockets.

### Base plate

It is essential that this is clean and free from oil, grease or scale. Air pressure relief holes should be provided to allow venting of any isolated high spots.





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## Levelling shims

If these are to be removed after the grout has hardened, they should be treated with a thin layer of grease.

## Formwork

The formwork should be constructed to be leakproof as Conbextra HF is a free flowing grout. This can be achieved by using foam rubber strip or mastic sealant beneath the constructed formwork and between joints.

In some cases it is practical to use a sacrificial semi-dry sand and cement formwork. The formwork should include outlets for the pre-soaking water.

The unrestrained surface area of the grout must be kept to a minimum. Generally the gap width between the perimeter formwork and the plate edge should not exceed 150 mm on the pouring side and 50 mm on the opposite side. There should be no gap at the flank sides.

## Mixing

For best results a mechanically powered grout mixer should be used. For quantities up to 50 kg a slow speed drill fitted with a high shear paddle is suitable. Larger quantities will require a high shear vane mixer. Do not use a colloidal impeller mixer.

It is essential that machine mixing capacity and labour availability is adequate to enable the grouting operation to be carried out continuously. This may require the use of a holding tank with provision for gentle agitation to maintain fluidity.

The selected water content should be accurately measured into the mixer. Slowly add the total contents of the Conbextra HF bag, mix continuously for 5 minutes, ensuring a smooth, even consistency is obtained.

## Consistency of mixed grout

To achieve the consistencies which are defined in CRD-C621-82A, the amount of clean water that is added to a 25 kg bag at 20°C is:

Flowable:	4.5 litres
Fluid:	4.8 litres

## Maximum flow distance at 20°C

Grout consistency	Gap depth mm	Max. flow distance in mm	
		100mm head	250mm head
Flowable:	10	360	1200
	20	950	2600
	30	1500	3000
	40	2200	3000+
	50	3000	3000+
Fluid:	10	900	2500
	20	1900	3000
	30	3000	3000+
	40	3000+	3000+

## Placing

Place the grout within 15 minutes of mixing to gain the full benefit of the expansion process.

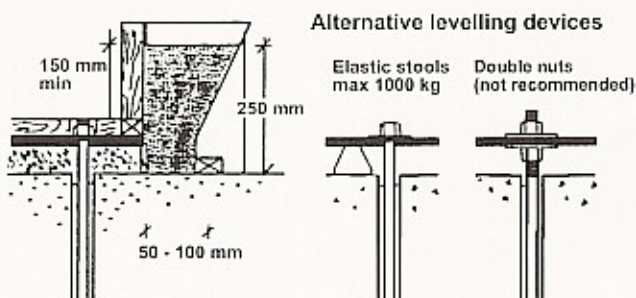
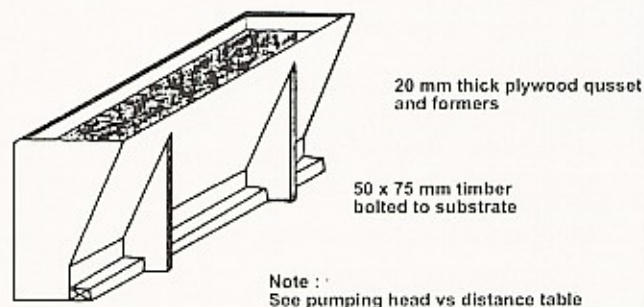
Conbextra HF can be placed in thicknesses up to 125 mm in a single pour.

Any bolt pockets must be grouted prior to grouting between the substrate and the base plate.

Continuous grout flow is essential.

## Figure 2: Typical hopper system

**Removable hopper:** For larger pours the grout may be hand placed or pumped into a removable hopper (trough).





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Sufficient grout must be available prior to starting and the time taken to pour a batch must be regulated to the time taken to prepare the next one.

The mixed grout should be poured only from one side of the void to eliminate the entrapment of air or surplus pre-soaking water. This is best achieved by pouring the grout across the shortest distance of travel. The grout head must be maintained at all times so that a continuous grout front is achieved.

Where large volumes have to be placed Conbextra HF may be pumped. A heavy duty diaphragm pump is recommended for this purpose. Screw feed and piston pumps may also be suitable.

## Curing

On completion of the grouting operation, exposed areas should be thoroughly cured. This should be done by the use of Concure curing membrane, continuous application of water and/or wet hessian.

## Cleaning

Conbextra HF should be removed from tools and equipment with clean water immediately after use. Cured material can be removed mechanically, or with Fosroc Acid Etch.

## Limitations

### Low temperature working

When the air or contact surface temperatures are 5°C or below on a falling thermometer, warm water (30-40°C) is recommended to accelerate strength development.

For ambient temperatures below 10°C the grout consistency should be flowable and the formwork should be maintained in place for at least 36 hours.

Normal precautions for winter working with cementitious materials should then be adopted.

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## High temperature working

At ambient temperatures above 35°C the mixed grout should be stored in the shade. Cool water (below 20°C) should be used for mixing the grout.

## Estimating

### Supply

Conbextra HF is supplied in 25 kg moisture resistant bags.

### Yield

Allowance should be made for wastage when estimating quantities required. The approximate yield per 25 kg bag for different consistencies is:

Consistency	Flowable	Fluid
Yield (litres)	13.25	13.5

## Storage

Conbextra HF has a shelf life of 12 months if kept in a dry store in sealed bags. If stored in high temperature and high humidity locations the shelf life may be reduced.

## Precautions

### Health and safety

Conbextra HF is alkaline and should not come into contact with skin and eyes. Avoid inhalation of dust during mixing. Gloves, goggles and dust mask should be worn.

If contact with skin occurs, wash with water. Splashes to eyes should be washed immediately with plenty of clean water and medical advice sought.

### Fire

Conbextra HF is non-flammable.

## Additional Information

For further details about the use and selection of grouts refer to the Fosroc Information Module entitled "Precision Grouting in the Construction Industry".



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### Important note

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