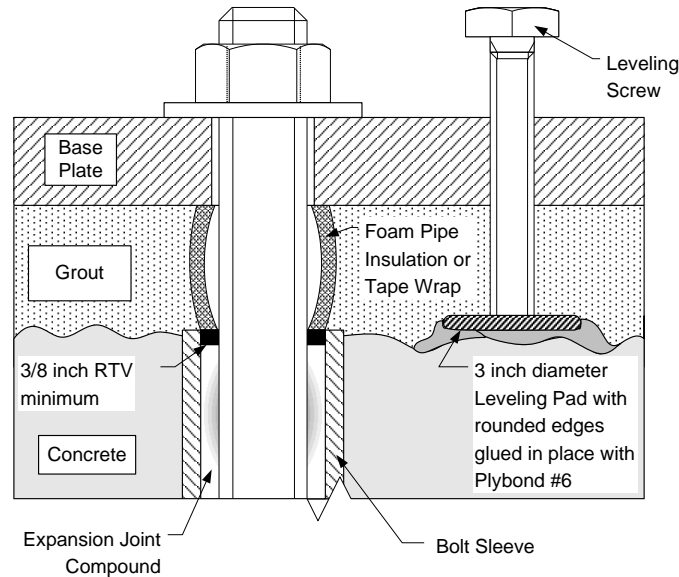


Technical Bulletin # 1647D

Bulletin Description

This bulletin illustrates the recommended method of protecting an anchor bolt and installing a leveling screw prior to the pouring of Chockfast or Escoweld epoxy grout. The normal sequence of preparation, mixing, and pouring is as follows:

**Installation** Instructions

1. Remove all laitence and foreign matter from the surface of the concrete by use of a chipping hammer. All areas coming in contact with grout should be roughened.
2. Remove all debris such as concrete chips and all moisture from the bolt sleeve by the use of an air hose.
3. The anchor bolt located within the concrete should be protected by a plastic bolt sleeve in order to prevent the grout from coming in contact with the anchor bolt. This will ensure proper stretch of the bolt.
4. If possible, fill the sleeve with a non-binding material such as ITW Expansion Joint Compound or spray foam insulation. If additional sealing is required, fill the top end of the pipe sleeve with RTV Silicone or equivalent.
5. Cover the top portion of the anchor bolt with Armaflex Pipe Insulation or wrap with foam-backed tape to prevent it from touching the grout.
6. Sand blast the bottom of the base plate to obtain a 1 to 1 ½ mil profile (SP-6) and coat with AST MS-7CZ Rust Inhibitive Primer.
7. Attach a leveling pad to the surface of the concrete foundation using Phillybond #6. This pad must be round with rounded edges and must be capable of supporting the load imposed by the leveling screw on the foundation.
8. Set and level the base plate. After leveling, apply paste wax to any areas on the base plate

that may get grout dripped on them to make it easier to clean later.

9. Apply a heavy coat of non-melt grease to all leveling screws both before and after the base plate is aligned.
10. Mix and pour the grout in accordance with "Installation Specification for Pumps and Drivers when Using Epoxy Grouts".
11. After the grout has hardened, remove the leveling screws and fill the holes with Silicone. If this is not practical back off the leveling screws a minimum of three full turns

Reference

For further design considerations and application details, please contact your local representative of our Worldwide Distributor Network or ITW Performance Polymers.

Date June 2018

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