



Standard Test Method for Flowability and Bearing Area of Chemical-Resistant Polymer Machinery Grouts¹

This standard is issued under the fixed designation C 1339; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

1. Scope

1.1 This test method covers the measure of flowability of chemical-resistant polymer machinery grouts as evaluated in a 2-in. (5-cm) or 1-in. (2.5-cm) pour thickness. The test method provides for the assessment of upper surface plate contact area (bearing area). These grouts will typically be two- or three-component formulations that may be used for installations where grout thickness will range from 1 to 6 in. (2.5 to 15 cm) underneath the base or plates being grouted.

1.2 The values stated in inch-pound units are to be regarded as standard. The values given in parentheses are mathematical conversions to SI units that are provided for information only and are not considered standard.

1.3 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

2. Referenced Documents

2.1 *ASTM Standards:*²

C 904 Terminology Relating to Chemical-Resistant Non-metallic Materials

3. Terminology

3.1 *Definitions*—For definition of terms used in this test method, see Terminology **C 904**.

4. Summary of Test Method

4.1 Polymer machinery grout of a flowable consistency is poured into a hopper at one end of a shallow plastic trough with a clear plastic cover plate.

4.2 A movable gate is raised, allowing the grout to flow from the hopper into the trough. The times for the grout to first contact the end plate and to establish full length contact with the top cover plate are recorded and used as indices of flowability.

4.3 After the grout hardens, the mold and top plate are removed. The top surface of the grout is wire brushed to expose any surface air bubbles or voids, and a visual estimate is made of the percentage of grout top surface area that is in contact with the plate. Visual guides are provided for comparative purposes (see **Fig. 1** and **Fig. 2**).

5. Significance and Use

5.1 Chemical-resistant polymer machinery grouts are used to provide precision support for machinery or equipment.

5.2 The machinery or equipment or support bases or plates, or combination thereof, are positioned to the precise elevation and location required. The bases or plates are typically placed on prepared foundations and supported on temporary shims or support bolts (jack screws). Forms are installed to contain the flowable grout. The grout is poured around the perimeter in such a manner as to allow the grout to flow around and under the equipment base or plates. The grout subsequently hardens to provide a strong rigid support layer capable of withstanding the stresses transferred by the equipment to the foundation.

5.3 In addition to the required physical properties of the grout, the flow and bearing area achieved are important considerations for effective grout installation. The two characteristics measured by this test method are flow and bearing area.

5.4 The flow test simulates typical application conditions for a flowable polymer machinery grout. It may be used to evaluate the suitability of a particular grout for a specific application, to compare the flowability and bearing area of two or more grouts, or to evaluate the effects of formulation changes, temperature, mixing techniques, or other factors on flowability.

5.5 The estimated amount of upper grout surface contact in percent can be used to compare two or more grouts or show the effects of temperature, formulation changes, or other factors on bearing area. Because of the limited accuracy in estimating the percent of contact, a limited set of results is suggested (see

¹ This test method is under the jurisdiction of ASTM Committee C03 on Chemical-Resistant Nonmetallic Materials and is the direct responsibility of Subcommittee C03.01 on Mortars and Carbon Brick.

Current edition approved June 1, 2008. Published July 2008. Originally approved in 1996. Last previous edition approved in 2002 as C 1339 – 02^{ε1}.

² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

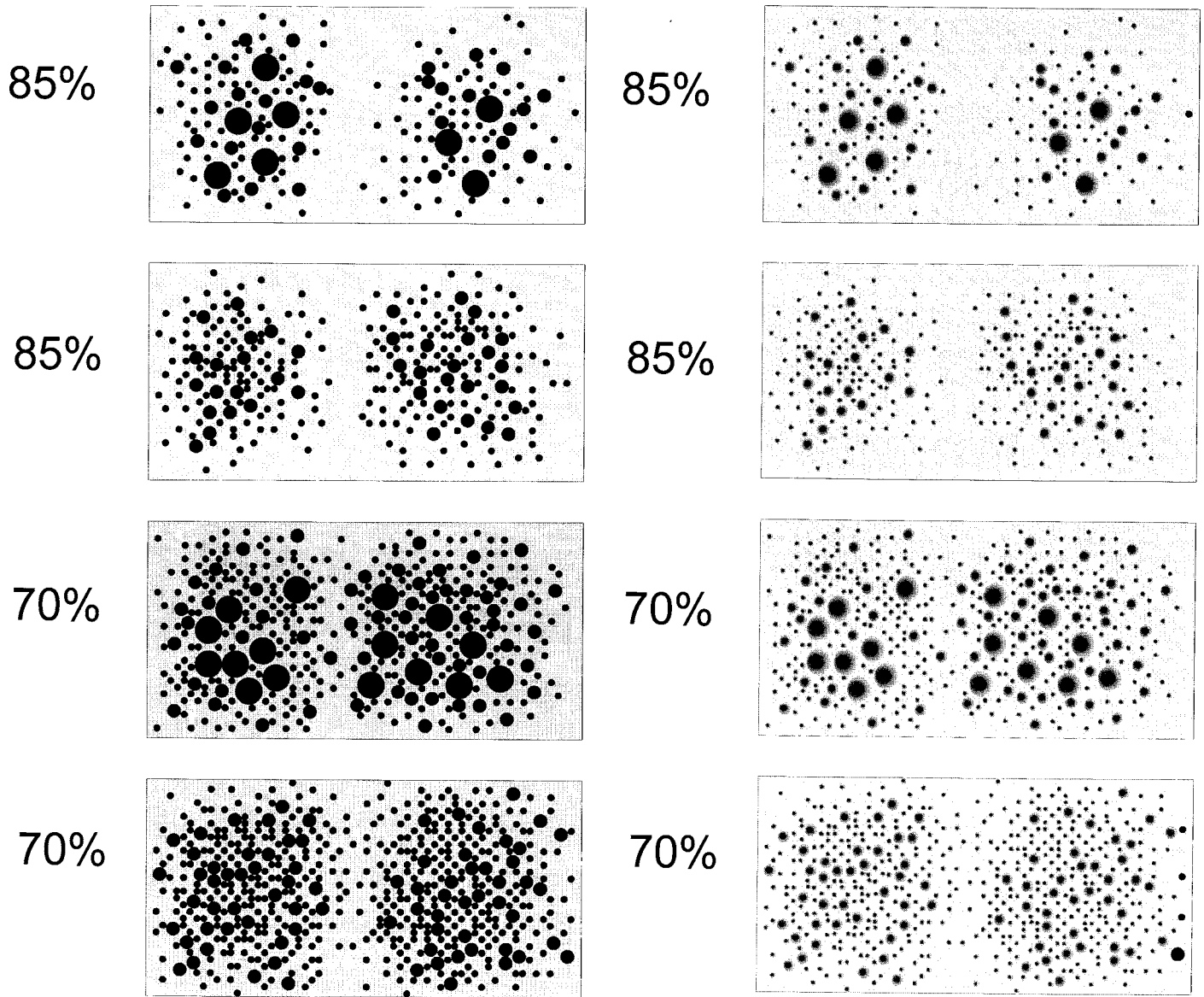


FIG. 1 Grout Top Surface

FIG. 2 Grout Top Surface

9.9.1). Visual guides are provided for comparative purposes (see Fig. 1 and Fig. 2).

6. Apparatus

6.1 *Flow Box*, a plastic flow box as shown in Fig. 3 with demountable sides and ends and a sliding gate, having a transparent cover plate of rigid polycarbonate plastic.

6.2 *Stopwatch*, of normal commercial accuracy, readable to at least 1 s.

6.3 *Thermometer or Thermocouple*, suitable for insertion into the grout while still plastic.

6.4 *Mixer*, a commercial mixing device that is able to rotate a 5-gal metal or plastic pail with a stationary mixing blade to stir the grout mix. Typical operating speed is 30 to 100 rpm (see Fig. 4).

7. Preparation of Apparatus

7.1 Prewax all the component parts of the flow box with paste wax and buff before assembly to ensure that the grout

does not adhere. The top cover plate shall not be waxed since the wax may have an adverse effect on the bearing area.

7.2 Assemble the box as follows:

7.2.1 Place the bottom plate on a flat work surface with the grooves facing upward.

7.2.2 Insert the left and right side plates of the box into the bottom plate with the grooved sides facing inward.

7.2.3 Slide the back plate down between the slanted grooves of the left and right side plates at the headbox end such that it enters the cross groove in the bottom plate.

7.2.4 Slide the gate plate into the vertical grooves in the front of the headbox such that it rests directly on the bottom plate.

7.2.5 Slide the cover plate in horizontally in the 2-in. (or 1-in.) high slots in the side plates from the flow end of the box until it contacts the gate plate firmly.

7.2.6 Slide the front plate down along the gate plate on the outside of the headbox until it contacts the cover plate.

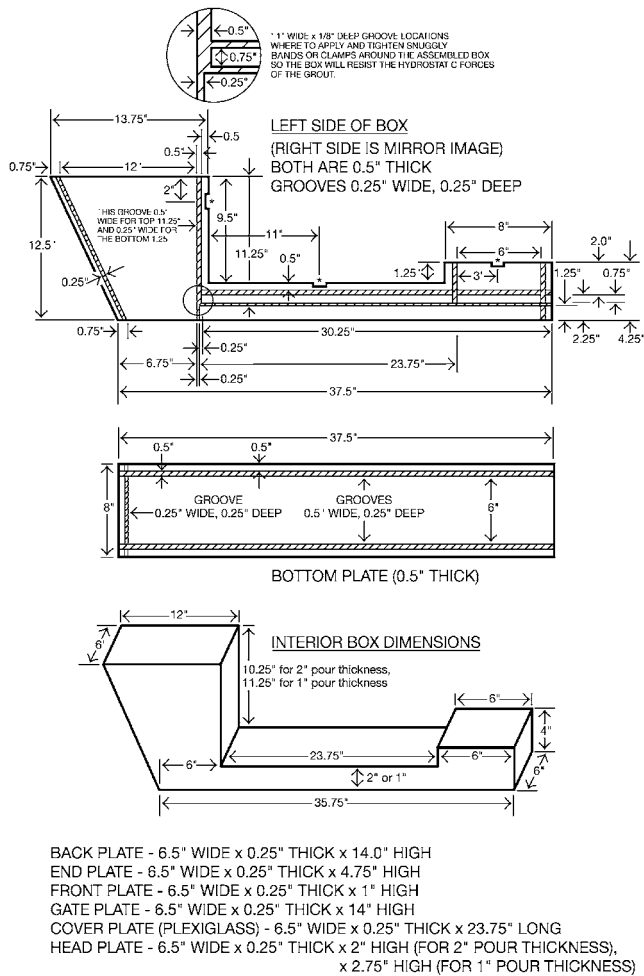


FIG. 3 Grout Flow Box

7.2.7 Slide the end plate down the end vertical grooves so that it seals against the bottom plate.

7.2.8 Slide the head plate down the groove 6 in. from the end plate so that it contacts the cover plate.

7.2.9 Apply bands or clamps around the assembled box at three locations snugly to resist the hydrostatic force of the grout; one near the top of the headbox, one at midsection, and one between the head plate and end plate.

7.3 Set the flow box on a flat level surface free from sources of vibration. Level the surface within 0.125 in. (3 mm) over the length of the flow box.

8. Conditioning

8.1 Store the flow box, mixer, components of grout, and other equipment at a temperature of 73 ± 4°F (23 ± 2°C) for at least 16 h prior to performing the test.

8.2 The test may be performed at higher or lower temperatures to simulate specific installation conditions. If this is done, the temperature should be specified in the report.

9. Procedure

9.1 Mix the grout following the manufacturer’s mixing instructions. For 2-in. (5-cm) thickness, mix at least 600 in.³

(9800 cm³) of the grout. For 1-in. (2.5-cm) thickness, mix at least 400 in.³(6500 cm³) of the grout. Record the mixer type and mixing speed.

9.1.1 The revolving bucket type mixer referenced in 6.4 is recommended for mixing grout materials in the amount required for this test. Large mixers are not recommended for the test since the grout may become unrepresentatively aggregate-rich due to the wetting of the mixer by the liquid components.

9.2 Immediately after mixing, measure and record the temperature of the mix to the nearest 1°F (0.5°C).

9.3 Pour the mixed grout into the hopper to an 11-in. (28-cm) depth for 2-in. thickness or 8 in. (20 cm) for 1-in. thickness.

9.4 Five minutes from the time of completion of mixing the gate should be lifted past the junction of the front plate and cover plate in a smooth fast motion to allow the grout to flow into the box.

9.5 The stopwatch should be started at the moment the gate is lifted.

9.6 Monitor the grout flow through the top cover plate as the grout progresses down the box length. Record the elapsed time at which the grout first makes contact with the end plate as the flow time.

9.7 Record the elapsed time at which the grout makes full length contact with the top cover plate as the fill time.

9.8 Leave the filled flow box to cure undisturbed without movement or vibration.

9.9 At least 16 h after the time of pour, disassemble the mold and remove the top cover plate. Wire brush the grout top surface to expose air bubbles and voids trapped at the grout surface. Visually estimate the percentage of contact area and record as bearing area.

9.9.1 Because of the limited accuracy of this determination, the suggested classifications are: “high—greater than 85 %,” “medium—70 to 85 %,” “low—less than 70 %.”

10. Interpretation of Results

10.1 For the purposes of this test, the elapsed time in seconds for the grout to flow to the end plate and the time to make full length contact with the top cover plate are indices of flowability; the shorter the time, the greater the flowability.

10.2 This test method is a simulation of applications where the flow distance is approximately 30 in. (75 cm), but actual application flow times may be longer because of the greater roughness and porosity of a prepared concrete surface.

10.3 The bearing area is useful in comparing grouts or evaluating effects of different application temperatures.

11. Report

11.1 Report the following information:

- 11.1.1 The date test was performed;
- 11.1.2 The manufacturer’s designation for the grout tested and batch number of the grout components;
- 11.1.3 The grout flow depth used for the test;
- 11.1.4 Type of mixing equipment utilized, mixing speed, and the amount of grout mixed;
- 11.1.5 Temperature of the grout after mixing;
- 11.1.6 Time for the grout to first contact the end plate;



FIG. 4 Mixer

11.1.7 Time for the grout to establish full length cover plate contact;

11.1.8 Description of the wire brushed top surface and percent bearing area range;

11.1.8.1 High (greater than 85 %), medium (70 to 85 %), low (less than 70 %); and

11.1.9 Any deviations from this procedure.

12. Precision and Bias

12.1 The precision and bias for this test method have not been established.

12.2 The percentage range of upper plate contact or bearing area is based on a visual estimate. This will limit accuracy and may produce differences between operators.

13. Keywords

13.1 bearing area; chemical-resistant polymer machinery grout; flowability; surface contact

ASTM International takes no position respecting the validity of any patent rights asserted in connection with any item mentioned in this standard. Users of this standard are expressly advised that determination of the validity of any such patent rights, and the risk of infringement of such rights, are entirely their own responsibility.

This standard is subject to revision at any time by the responsible technical committee and must be reviewed every five years and if not revised, either reapproved or withdrawn. Your comments are invited either for revision of this standard or for additional standards and should be addressed to ASTM International Headquarters. Your comments will receive careful consideration at a meeting of the responsible technical committee, which you may attend. If you feel that your comments have not received a fair hearing you should make your views known to the ASTM Committee on Standards, at the address shown below.

This standard is copyrighted by ASTM International, 100 Barr Harbor Drive, PO Box C700, West Conshohocken, PA 19428-2959, United States. Individual reprints (single or multiple copies) of this standard may be obtained by contacting ASTM at the above address or at 610-832-9585 (phone), 610-832-9555 (fax), or service@astm.org (e-mail); or through the ASTM website (www.astm.org).