Acrocast™ XF Grout

SELECTION & SPECIFICATION DATA

Type

High flow vinyl ester structural grout

Description

Acrocast XF Grout is a 3-component vinyl ester structural grout designed with low shrinkage and high flow for casting applications 3/4 inch (18 mm) thick or more.

Uses

- Concrete resurfacing
- Grouting and casting applications where tolerances are tight or maximum flow is required.
- Grouting of heavy reciprocating or rotating equipment where heavy loads, chemical exposure or vibration may be a factor including:

Compressors	Mixers
Generators	Fans
Pumps	Stamping machines
Ball mills	Paper mill machines
Centrifuges	Packaging machines
Pedestals	Piles

Features

- High flow
- Minimal shrinkage
- Resistant to strong oxidizers, bleach solutions, and alkaline chemicals
- Excellent vibration resistance
- High physical strength
- Good bond to concrete and metal surfaces
- Rapid strength gain

Limitations

- Requires formwork
- When using as an overlay in large surface areas, pour in a checkerboard fashion to reduce curing shrinkage stresses.
- Not for use beyond its chemical resistance or thermal capabilities. Consult ErgonArmor with specific questions.

INSTALLATION GUIDANCE

Reference Specifications

CES-360 Installation of ErgonArmor Resinous Polymer Concretes

Installation Conditions

Acrocast XF Grout is formulated for ideal handling at 70°F (21°C). Materials and substrate should be acclimated to the air temperature prior to installation, and the air temperature should be between 50°F (10°C) and 90°F (32°C) during installation and cure.

Substrate must be clean, dry and neutral pH.

Ratio

1 gallon resin: 2-3 fl. oz. hardener by volume.
1 part catalyzed resin: 8 parts filler by weight.

Filler loading may be adjusted slightly to suit flow preferences. Where higher flow characteristics are required, reduce filler loading by holding back up to 0.6 parts filler.

Mixing

Pour measured quantity of resin into clean, dry mixing vessel. Slowly add measured quantity of hardener to resin and power mix thoroughly. Add filler and power mix until filler is thoroughly wetted.

Work Life

30-45 minutes at 70°F (21°C)

Work life estimates are based on use of 2 fl. oz. CHP Hardener per 1 gallon resin. Increased hardener dosage will reduce work life.

Work life is shorter at higher temperatures. A larger volume of mixed material will have a shorter work life than a smaller volume.

Cleanup

Xylene or MEK

CURE TIME

Temperature	Initial Set	Full Cure
70°F (21°C)	2-3 hours	3 days

SAFETY

Safety

Mixes and applications of this product present a number of hazards. Read and follow the hazard information, precautions and first aid directions on the individual product labels and safety data sheets before using.

Ventilation

Provide thorough air circulation during and after application until the material has cured when used in enclosed areas.

Acrocast™ XF Grout

PACKAGING & ESTIMATING

Product	Code	Packaging
Acrocast™ Resin, Gray	19510	43 lb (5 gal or 19 L) pail
Acrocast Resin, Clear	29646	43 lb (5 gal or 19 L) pail
CHP Hardener	19552	11.2 fl. oz. (0.7 lb) bottle
XF Grout Filler	19600	50 lb (25 kg) bag

A 394 lb (2.9 cu ft) unit consists of 1 pail of resin, 1 bottle of hardener and 7 bags of filler. To enhance flow characteristics, it is permissible to hold back up to one half bag of filler.

Theoretical Coverage

A 394 lb (179 kg) unit will yield approximately 2.9 cubic feet (0.082 m^3) of grout. Yield will be reduced when filler loading is reduced.

Storage & Shelf Life

Maintain products in original packaging and sealed until ready for use. Estimated shelf life of resin is 6 months, and hardener is 1 year when stored in a dry area at 70°F (21°C). Warmer resin storage conditions will dramatically reduce shelf life. Store resin between 55°F (13°C) and 65°F (18°C) for maximum shelf life. Fillers do not degrade with age when stored in a dry area and packaging is intact. Actual shelf life may vary with storage conditions.

If there is any question with respect to the quality of the components, check reactivity prior to use. For assistance consult with ErgonArmor.

TYPICAL PHYSICAL PROPERTIES

Property	Typical Value
Color	Gray Sand, if using clear resin
Density, ASTM C138	135 lb/ft^3 (2,162 kg/m^3)
Compressive strength, ASTM C579	>10,000 psi (69 MPa)
Tensile strength, ASTM C307	>1,800 psi (12.4 MPa)
Flexural strength	>3,000 psi, (20.7 MPa)
Linear shrinkage, ASTM C531	0.12%
Absorption, ASTM C413	0.4%
Minimum application thickness	0.75 inches (19 mm)
Slump using 8.0 filler: 1.0 mixed resin and hardener mix ratio	Approximately 6-7 inches (150-175 mm) with full filler loading. Flow characteristics of resinous polymer grouts are different from Portland cement grouts. Use caution when comparing slump values.

Rev 09/2025