

### MIXING INSTRUCTIONS

Thank you for interest in our EP15-GROUT XP product. This high-performance grout is one of the best products available for high-stress applications such as machine base plate grouting, however proper handling and use is extremely important if you would like to achieve the published performance results. Included below are E-Chem's official recommendations for proper mixing of EP15-GROUT XP.

#### **INSTRUCTIONS**

Resin and hardener should be conditioned to between 65° F (18° C) and 85° F (29° C) for at least 12 hours before use. Pour Part B into the Part A container and mix thoroughly for 3 minutes with a low speed drill at 300 rpm. Keep the mixer completely submerged to prevent air entrapment.

**MIXER:** First and foremost, it is extremely important that the right type of mixing equipment is selected for use. Failure to do so can lead to serious equipment damage and/or failure. When mixing EP15-GROUT XP, E-Chem recommends a powerful (10 amp) electric mixer with a 2-speed gearbox, such as those designed specifically for the mixing of cementitious adhesives and resins. If this is not available, a powerful 2-speed angle head drill will also work well. E-Chem DOES NOT recommend the use of a standard carpentry power drill, as the motor will likely be damaged or destroyed.

**PADDLE:** Once you have obtained the proper mixer, it is time to select the appropriate mixing paddle for the materials you will be using. For EP15-GROUT XP, E-Chem recommends a Jiffy Mixer type paddle – a heavy duty mixing paddle made entirely of stainless steel for industrial and commercial applications. With a patented blade system developed for efficient mixing - not just stirring - of dense and viscous materials in an open container, the Jiffy Mixer will help to eliminate waste while minimizing unwanted aeration.

**MIXING:** When mixing EP15-GROUT XP, it is vital that the proper technique is used if you want your materials to perform as published. Before starting your mixer, make sure that the mixing paddle is completely submerged into the materials. Once the motor is started, keep the paddle submerged as you mix the materials at low speed (300 rpm) for 3 minutes, then shut the motor off and allow all motion to stop before the mixing unit reaches the surface of the materials. Failure to keep the mixing unit submerged and/or allowing the material to be mixed at high speeds is likely to cause unwanted air entrapment.

**BULK MIXING:** When bulk mixing EP15-GROUT XP, it is important that the proper equipment is used if you want your materials to perform as published. E-Chem recommends a mortar mixer (aka stucco mixer) where the shaft and paddles rotate to mix the material. Do NOT use a standard drum mixer, where the drum rotates around fixed fins or vanes, using gravity to mix the material. Mixing sand based materials using this type of equipment can be difficult, as they tend to stick to the walls of the drum instead of tumbling and churning to create the proper mix needed for published performance.

