

### PRODUCT DESCRIPTION

Stonset CG4 is a four-component, castable, novolac epoxy based grout designed for setting heavy equipment and machinery in place. Stonset CG4 exhibits exceptional strength and vibration resistance.

### PACKAGING

Stonset CG4 is packaged in units for easy handling. Each unit consists of:

- 1 carton containing:
  - 6 foil bags of Part A (curing agent)
  - 6 poly bags of Part B (resin)
- 6 individual bags of Part C-1 (aggregate)
- 6 individual bags of Part C-2 (aggregate)

### COVERAGE

Approximately 0.06 m<sup>3</sup> per unit (0.009 m<sup>3</sup> per mix).

### STORAGE CONDITIONS

Store all components of Stonset CG4 between 18 to 30°C in a dry area. Avoid excessive heat. Do not freeze. The shelf life is 3 years in the original, unopened container.

### SUBSTRATE PREPARATION

Proper preparation is critical to ensure an adequate bond and system performance. The substrate must be dry and properly prepared utilizing mechanical methods. Questions regarding substrate preparation should be directed to your local Stonhard representative or Technical Service.

### PREPARING METAL

If necessary, reinforce metal to prevent equipment from moving or flexing. All metal surfaces that will be directly in contact with Stonset CG4 must be cleaned to white metal by removing all rust, mill scale, coatings, oil, grease, dirt and other contaminants. After abrasive blasting, grinding or wire brushing, wash with solvent to remove all traces of dust, grease or oil. Do not use mineral spirits.

### PHYSICAL CHARACTERISTICS

Compressive Strength (ASTM C-579)	39 N/mm <sup>2</sup> after 7 days
Tensile Strength (ASTM C-307)	17 N/mm <sup>2</sup>
Flexural Strength (ASTM C-580)	35 N/mm <sup>2</sup>
Flexural Modulus of Elasticity (ASTM -C-580)	8.2 x 10 <sup>3</sup> N/mm <sup>2</sup>
Hardness. (ASTM D-2240, Shore D)	85 to 90
Indentation (MIL-D-3134F)	No Indentation
Pot Life (@70°F/21°C)	20 minutes
Initial Set (ASTM C-308 @ 70°F/21°C)	2 to 4 hours
Cure Rate (@ 70°F/21°C)	6 hours shim removal 24 hours for operations
VOC Content (ASTM D-2369)	80 g/l

**Note:** The above physical properties were measured in accordance with the referenced standards. Samples of the actual floor system, including binder and filler, were used as test specimens. All sample preparation and testing is conducted in a laboratory environment, values obtained on field applied materials may vary and certain test methods can only be conducted on lab made test coupons

### FORM PREPARATION

Forms used to contain the Stonset CG4 should provide a grout level of a minimum 19 mm above the machine base. Although lumber is generally used for the forms, any material of adequate strength and tightness to contain the grout may be used. In confined areas, the forms should be set up to provide a hydraulic head for the grout. The forms must be liquid tight to prevent loss of material, as Stonset CG4 is very flowable. Foam rubber, caulking or weather-stripping can be placed into cracks at the bottom of the forms to prevent liquid loss. It is very important that the forms be treated to prevent the Stonset CG4 from bonding to them. A colored paste wax or form release agent may be used.

**Note:** In situations where the formed grout is to be overlaid, the wax or form release agent can inhibit bonding. In these situations it is best to line the forms with plastic or clear box sealing tape.

## PRIMING

Stoncrest GS3 should be used in all applications of Stonset CG4 where a metal surface is in contact with the grout and the grouting does not immediately follow the preparation. This is done to avoid flash rusting of the substrate. Priming of the concrete substrate is not necessary for the application of Stonset CG4.

## MIXING

- Empty the contents of liquids into a 5 gallon mixing container. Utilizing a JB Power Blender, mix the liquids for one minute.
- Add the contents of one bag of Part C-1 aggregate and one bag of Part C-2 aggregate. Mix for one minute or until a homogeneous grout is achieved.

## APPLYING

The mixed Stonset CG4 is poured starting at one end of the equipment and working toward the opposite end. This is done to displace any air pockets that might form under the equipment. Using a trowel or push rod, force material underneath the equipment by exerting a downward pressure. Be sure to use the first portion of each new unit to make up for any loss of material due to flow of the grout from under the piece of equipment. This procedure should provide a positive head to aid in placing the grout.

## FINISHING

Allow the material to set in the form for approximately 10 minutes before beginning the finishing process. Any bubbles present in the finished surface can be removed by lightly spraying the surface with mineral spirits. The forms should be left in place until the grout has cured.

## CURING

The temperatures of the equipment and surface will determine the rate of cure of Stonset CG4. At 21 °C, the cure time before removing the jack or shims is 6 hours and the cure time before placing into service is 24 hours minimum.

## RECOMMENDATIONS

- Minimum ambient and surface temperatures are 30°C at the time of application.
- Apply only on a clean, sound, and properly prepared substrate.
- Material must be mixed to a uniform consistency. **Do not mix over 3 minutes!**
- Application and curing times are dependent upon ambient and surface conditions.
- Clean tools immediately with either scouring pads and water or mineral spirits. Hardened material will require mechanical removal.

## PRECAUTIONS

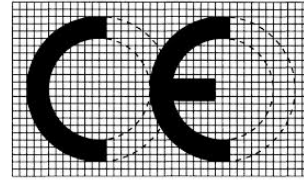
- Both liquid Parts A and B are skin and eye irritants; avoid contact.
- The use of safety glasses and impervious gloves is required during application.
- In case of contact, flush the area with copious amounts of water for 15 minutes and seek medical attention. Wash skin with soap and water.
- Use only with adequate ventilation.

## NOTES

- For environments not referenced in the Stonchem 600 Series Chemical Resistance Guide, consult Stonhard's Technical Service Department for recommendations.
- Material Safety Data Sheets for Stonset CG4 are available online at [www.stonhard.com](http://www.stonhard.com) under Products or upon request.
- A staff of technical service engineers is available to assist with application, or to answer questions related to Stonhard's products.
- Requests for technical literature or service can be made through local sales representatives and offices, or corporate offices located worldwide.

## CE MARKING

The harmonized European Standard EN 13813 "Screed material and floor screeds - Screed materials - Properties and requirements" specifies the requirements for screed materials for use in floor construction internally. Resinous flooring systems as well as resinous screeds fall under this specification they have to be CE-labelled as **per Annex ZA., Table ZA.1.5 and 3.3** and fulfil the requirements of the given mandate of the Construction Products Regulation no. 305/2011



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EN 13813 SR-C35-F30-B2.0

Synthetic resin grouting material for use internally in buildings  
(system as per Product Data Sheet)

Release of corrosive substances:	SR
Compressive strength:	C35
Flexural strength:	F30
Adhesion strength by pull-off test:	> B2.0
Chemical resistance:	CRG <sup>1</sup>

<sup>1</sup>CRG: see Stonhard Chemical Resistance Guide

## IMPORTANT:

Stonhard believes the information contained here to be true and accurate as of the date of publication. Stonhard makes no warranty, expressed or implied, based on this literature and assumes no responsibility for consequential or incidental damages in the use of the systems described, including any warranty of merchantability or fitness. Information contained here is for evaluation only. We further reserve the right to modify and change products or literature at any time and without prior notice.

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