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Polyester resin anchoring grout meeting requirements of BS EN 1504-6: Anchoring of reinforced steel bars.



Uses

Lokfix S25 is used for anchoring of steel bars into concrete, brickwork, masonry and rock. Recommended applications include:

- Installation of starter bars
- Base plate bolts
- MOT Bolts
- Installation of balustrades
- Installation of barriers and safety fences
- Installation of tie bars

Advantages

- Easy to mix and apply
- Rapid strength gain
- Vibration resistant
- Corrosion resistant
- Non-expansive
- Can be placed underwater
- Increased flowability

Description

Lokfix S25 is a two component polyester anchoring grout supplied in pre-measured quantities. The material cures quickly to give consistent, high performance anchorages. It is a pourable grade, with a 25 minute gel time at 20°C for use in vertical down holes where the hole is 8 to 40 mm greater in diameter than the bar.

Specification Clause

The anchor grout should be Lokfix S25 pourable grout in vertical downwards holes. The anchor grout should comply with the requirements of BS EN1504-6 and have a compressive strength of 100 MPa at 28 days.

Standards compliance

Lokfix S25 complies with the requirements of BS EN 1504-6 : Anchoring of reinforced steel bar.

Lokfix S25 conforms to the requirements of Highways Agency Interim Advice Note 104/07: The anchorage of reinforcement and fixings in hardened concrete.

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Fosroc Ltd Drayton Manor Business Park, Coleshill Road, Tamworth, B78 3TL, UK 09 DoP: UK9-07 0370-CPR-0845	
Lokfix S25	
EN1504-6: Anchoring of reinforcing steel bar	
Testing of anchoring products by pull out method	≤ 0.6 mm at 75 kN
Chloride ion content	≤ 0.05%
Glass transition temperature	
Lokfix S25:	74 °C
Lokfix P25:	67 °C
Creep under tensile load	≤ 0.6mm
Fire Classification	B
Dangerous substances	Conforms to 5.3

Fosroc® Lokfix S25

Properties

The following results were obtained at a temperature of 20°C unless otherwise stated.

Test method	Standard	EN 1504-6	Result LokfixS25
Testing of anchoring products by pull out method	EN 1881:2006	Displacement < 0.6mm @ 75KN bad	Dry 0.40 mm Wet 0.44 mm
Determination of creep under sustained tensile load	EN 1544:2006	Displacement < 0.6mm after 3 months of continuous 50KN bad	0.47 mm
Chloride ion content:	EN 1015-17:2000	≤ 0.05%	0.00%
Determination of glass transition Temperature	EN 12614:2006	> 45°C or > 20°C above ambient	73.5°C
Compressive Strength	EN 12190	-	100 MPa 28 days 100MPa
Tensile Strength	BS 6319 Pt.7	-	11MPa 28 days 11 MPa
Flexural Strength	BS 6319 Pt. 3	-	20 MPa 28 days 19 MPa
Gel time / minimum loading time	-	-	Temp °C Gel Time Min loading time (hrs) 5 130 12 10 65 5 20 25 2 30 10 1
Chemical resistance	-	-	The cured resin is resistant to fresh and salt water, petrol, oils, grease and most acids, alkalis and solvents. Consult Fosroc Technical Services for specific chemical resistance
Minimum annular gap	-	-	4 mm
Maximum annular gap	-	-	20 mm

Clarification of property values: The typical properties given above are derived from laboratory testing. Results derived from field applied samples may vary.

Design Criteria

Parameters of anchor design

The high strength of the cured resin permits strong anchors to be created. Ultimate strength is varied by:

- Strength of host material
- Length of resin bond to bar
- Hole preparation and formation
- Type and dimension of bar

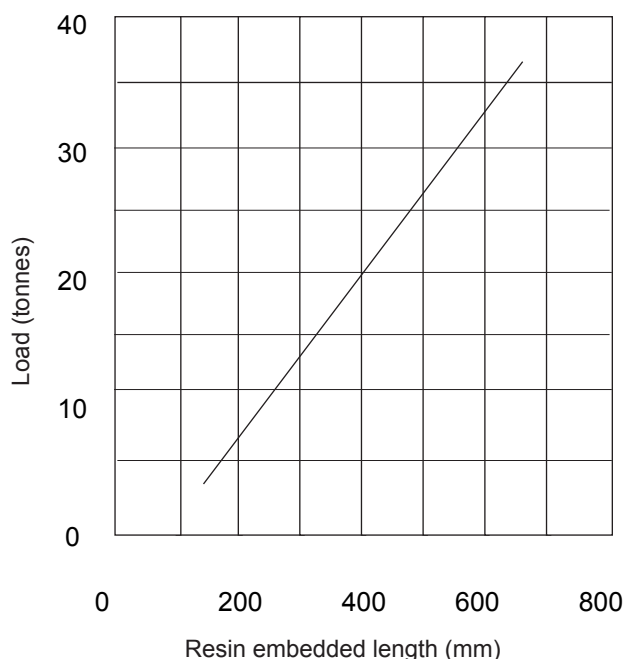
Typical loads attained

Concrete: 20 N/mm² unreinforced.

Bar: Deformed rebar to BS 4449.

Hole: Air-flushed rotary percussive drilled.

Fosroc® Lokfix S25



Note: The graph illustrates typical failure loads. Minimum safety factors of 1.5 in non-critical and 2 in critical cases should be considered for design purposes. Where relevant, the local codes of practice or standards must also be considered in relation to anchorage length.

Application instructions

Hole preparation and formation

Optimum performance of Lokfix S25 requires rough sided, dust-free holes. Use of rotary percussive drills with air or water flushing is recommended.

Diamond drilled holes should be under-reamed or the surface roughened with a drill steel.

Cast holes should preferably be of inverse dovetail configuration. If parallel sided holes are cast they should be rough to provide adequate keying.

Bar preparation

All bars should be deformed. They should preferably be degreased and all flaky rust removed.

Mixing

A complete pack of resin and catalysed filler should be mixed in one operation. Mixing may be carried out manually or mechanically. When a smooth, even consistency is achieved the grout is ready for use and should be placed well within the gel time of the grout.

Packs have been designed to produce practical and economic volumes of grout.

DO NOT attempt to mix partial pack components.

Installation

Lokfix S25

Using the calculated volume of grout based on the estimating guide table, the grout should be poured steadily into the prepared holes. The anchor bar is then pressed into the hole to the required depth; slight agitation will assist in achieving a complete bond. The bar should be left undisturbed in the required position until the resin is set.

Cleaning

Any mixing drums, pumps, etc., should be cleaned with Fosroc Solvent 105 within the pot life of the grout. Cured material can only be removed mechanically.

Supply

The pack consists of a can of resin and a plastic bag of hardener contained in a plastic mixing pail with a snap-on lid. Volume of mixed components: 2.5 litres.

Storage

Store in accordance with the Highly Flammable Liquids and Liquefied Petroleum Gases Regulations 1972. Shelf life of 12 months at 20°C will be reduced at higher temperatures.

Limitations

Fire resistance

Resin anchors should not be used where structural load bearing performance has to be maintained in anchors subjected to fire conditions. Conbextra GP or Conbextra HF would be suitable in this case. Contact Fosroc Technical Service for advice.

Precautions

Health and safety

For further information see appropriate Product Safety Data Sheet available from www.fosroc.com

Fire

Lokfix S25 and Fosroc Solvent 105 are flammable. Do not expose to naked flames or other sources of ignition. No Smoking. Containers should be tightly sealed when not in use. In the event of fire, extinguish with CO₂ or foam.

Flash points

Lokfix S25:	29°C
Fosroc Solvent 105:	43°C

Fosroc® Lokfix S25

Estimating guide

To find the quantity of material required

The table below indicates the quantity of material in litres required for each 100 mm of hole depth.

Example

- 100 fixings, each using a 20 mm diameter bolt into a 38 mm diameter hole which is 300 mm deep.
- From the table: 20 mm diameter bolt and 38 mm diameter hole gives **0.082 litre** per 100 mm depth of hole therefore **0.082 litre** x 3 (300 mm deep hole) equals **0.246 litre** per hole/fixing.
- As 100 fixings are required: 100 x 0.246 litre = **24.6 litres total**.
- Lokfix S25 and Lokfix P25 are supplied in 2.5 litre packs
therefore $24.6/2.5 = 9.84$ 10 packs required

NB: This example and the table below quotes net quantities and makes no allowance for overdrilling the hole or for any wastage. A typical allowance to cover these factors is approximately 10%.

To determine the quantity of material per 100 mm of hole depth

Hole diameter	Bolt diameter							
	12 mm	16 mm	20 mm	25 mm	32 mm	38 mm	44.5 mm	51 mm
20 mm	0.020 litre	—	—	—	—	—	—	—
25 mm	0.038 litre	0.029 litre	—	—	—	—	—	—
32 mm	0.069 litre	0.060 litre	0.049 litre	0.031 litre	—	—	—	—
38 mm	—	0.093 litre	0.082 litre	0.064 litre	—	—	—	—
45 mm	—	—	0.128 litre	0.110 litre	0.079 litre	0.046 litre	—	—
51 mm	—	—	—	0.155 litre	0.124 litre	0.091 litre	—	—
57 mm	—	—	—	0.206 litre	0.175 litre	0.142 litre	0.100 litre	—
64 mm	—	—	—	0.273 litre	0.241 litre	0.208 litre	0.166 litre	0.117 litre
76 mm	—	—	—	—	—	0.340 litre	0.298 litre	0.249 litre

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Important note

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