

PRODUCT DATA SHEET

Sikadur®-42 Grout Pak LE

Pre-proportioned, precision epoxy grouting system

PRODUCT DESCRIPTION

Sikadur®-42 Grout Pak LE is a high-strength, multi-purpose, three-component, precision grouting system. It is solvent-free, moisture insensitive and it generates both low exotherm and low dusting during installation. Sikadur®-42 Grout Pak LE has been designed to seat and support high demanding equipment.

WHERE TO USE

Sikadur®-42 Grout Pak LE may only be used by experienced professionals.

- Precision seating of baseplates
- Grouting under equipment, including heavy impact and vibratory machinery, reciprocating engines, compressors, pumps, presses, etc.
- Grouting under crane rails

CHARACTERISTICS / ADVANTAGES

- Meets API Standard 686
- Low peak exotherm
- Low dusting, ready-to-mix, pre-proportioned kits
- Moisture insensitive
- Corrosion and impact resistant
- Stress and chemical resistant
- High compressive, tensile and shear strengths
- High vibration resistance
- Low coefficient of thermal expansion; compatible with concrete
- Material does not require heated transportation

ENVIRONMENTAL INFORMATION

LEED® Credit Contributions:

- Contributes towards satisfying MR Credit - Building Product Disclosure and Optimization – Environmental Product Declarations (Option 1): EPD Type III - Product Specific (ISO 14025-2006 and ISO 21930-2017 compliant)

PRODUCT INFORMATION

Packaging	56.6 L (2.0 ft³) Unit = ▪ Component A: 9.1 L [10.28 kg (22.5 lb)] pail ▪ Component B: 3.7 L [3.57 kg (7.8 lb)] pail ▪ Component C: 6 x 19.4 kg (6 x 42.7 lb) bag
Appearance / Colour	Dark Brown
Shelf Life	24 months from date of production
Storage Conditions	▪ Store dry at temperatures between 5 °C and 32 °C (41 °F and 89 °F) ▪ Condition product at temperatures between 23 °C and 30 °C (73 °F and 86 °F) for 48 hours prior to using. For temperatures outside of this range, contact Sika Canada Technical Services.

Density 2300 kg/m³ (144 lb/ft³)

TECHNICAL INFORMATION

Compressive Strength	24 hours	16 MPa (2321 psi)	(ASTM C579)
	2 days	50 MPa (7255 psi)	
	3 days	70 MPa (10 157 psi)	
	7 days	83 MPa (12 038 psi)	
	28 days	92 MPa (13 340 psi)	
Effective Bearing Area	~90 % (High)		(ASTM C1339)
Modulus of Elasticity in Flexure	Flexural Strength	28 MPa (4062 psi)	(ASTM C580)
	Tangent Modulus of Elasticity in Bending	15 GPa (21.7 x 10 ⁵ psi)	
Tensile Strength	14.0 MPa (2,031 psi)		(ASTM D638)
Elongation	0.75 – 1.00 %		(ASTM D638)
Linear Dimensional Change	0.060 %		(ASTM C531)
Creep	4.1 MPa, 60 °C (600 psi, 140 °F)	4.5 x 10 ⁻³	(ASTM C1181)
	2.7 MPa, 60 °C (400 psi, 140 °F)	3.5 x 10 ⁻³	
Thermal Compatibility	No delamination/pass		(ASTM C884)
Coefficient of Thermal Expansion	-30 to +30 °C (-22 to +86 °F)	2.3 x 10 ⁻⁵ /°C (1.3 x 10 ⁻⁵ /°F)	(ASTM C531)
	+24 to +100 °C (+75 to +212 °F)	3.0 x 10 ⁻⁵ /°C (1.7 x 10 ⁻⁵ /°F)	
Reaction to Fire	Self-extinguishing		(ASTM D635 - Flammability)
Shear Adhesion Strength	> 40 MPa (5804 psi) concrete failure		ASTM C882

APPLICATION INFORMATION

Mixing Ratio	Ratio solid/liquid by weight	8.43:1
Yield	56.6 L (2 ft³)	
Peak Exotherm	34.6 °C (94.3 °F)	(ASTM D2471)
Pot Life	Mix 3:1 (A:B 300 g)	2 h 20 min

BASIS OF PRODUCT DATA

Product properties are typically averages, obtained under laboratory conditions. Reasonable variations can be expected on-site due to local factors, including environment, preparation, application, curing and test methods.

Product properties tested at 23 °F (73 °C), 50 % R.H., unless stated otherwise.

LIMITATIONS

- If material is subject to cold or freezing temperatures during transportation to, or storage on, a job site, care must be taken to properly precondition A, B, and C components prior to beginning grouting operations.
- Cold ambient, substrate or material temperatures will inhibit the flow and curing characteristics of Sikadur®-42 Grout Pak LE. For temperatures below 23 °C (73 °F), contact Sika Canada Technical Services.
- Grouting material must be stored in an area with an

ambient temperature between 23 °C and 30 °C (73 °F and 86 °F) for a minimum of 48 hours before use. Component C should be between 28 °C and 30 °C (82 °F and 86 °F), when measured with a probe thermometer, to have proper flow of the mixed material.

- Should ambient, substrate or material temperatures exceed 30 °C (86 °F), contact Sika Canada Technical Services for guidance as excessive heat can influence the properties of epoxy polymer grouts.
- Do not thin with solvents. Solvents will prevent proper cure. Adding diluent will void any applicable Sika® warranty.
- Material is a vapour barrier after cure.
- Minimum grout thickness: 25 mm (1 in).
- Maximum grout thickness: 450 mm (18 in) per lift. For grout thickness between 300 and 450 mm (12 and 18 in), contact Sika Canada Technical Services.
- Component C must be kept dry at all time.
- For bolt grouting applications, contact Sika Canada Technical Services.
- For proper seating, allow grout to rise 3 mm (1/8 in) above the bottom of the base plate.
- Do not batch. Mix complete units only.
- Do not subject cured epoxy grout to sudden temperature changes especially during early curing stages.
- Contact Sika Canada Technical Services for control joint spacing on large base plate grouting projects.
- Contact Sika Canada Technical Services to obtain a copy of the technical bulletin: Installation Guide for Epoxy Grouting with Sikadur®-42 Grout Pak LE. This document should be reviewed prior to grouting, for additional information.

ENVIRONMENT, HEALTH & SAFETY

User must read the most recent corresponding Safety Data Sheets (SDS) before using any products. The SDS provides information and advice on the safe handling, storage and disposal of chemical products and contains physical, ecological, toxicological and other safety-related data.

Keep out of reach of children
For industrial use only

APPLICATION INSTRUCTIONS

SUBSTRATE PREPARATION

For optimum results when grouting in critical items of equipment, it is recommended to follow the surface preparation requirements prescribed in the latest edition of the API Recommended Practice 686, Chapter 5. This document, *“Recommended Practices for Machinery Installation and Installation Design”*, is published by the American Petroleum Institute.

Surface and base plate contact area must be clean and sound. For best results, the substrate should be dry.

Remove dust, laitance, oils, grease, curing compounds, impregnations, waxes, foreign particles, coatings, and disintegrated materials by mechanical means, such as chipping with a chisel and sandblasting. All anchor pockets or sleeves must be void of water. Sandblast metal base plates to a commercial white finish (SP-10) for maximum adhesion. Apply grout immediately to prevent re-oxidizing.

Forming

The consistency of the epoxy grout system requires the use of forms to contain the material around the base plates. In order to prevent leakage or seepage, all forms must be properly constructed and sealed. Apply polyethylene film or wax to all forms to prevent adhesion of the grout. Prepare form work to maintain more than 100 mm (4 in) liquid head to facilitate placement. A grout box equipped with an inclined trough attached to the form will enhance the grout's flowability and minimize air encapsulation.

Note: Expansions joints are recommended especially in exterior applications. Follow recommendations of API 686, and consult the Technical Bulletin for further information. Joints can be filled with an appropriate Sikaflex® sealant once formwork is removed.

MIXING

1. Thoroughly stir both Component A and Component B, distributing any settled solids and achieving an even consistency throughout each component.
2. Mix at low speed (300–450 rpm) for three (3) minutes the entire contents of components A and B in the component A pail using a drill fitted with an appropriate mixing paddle. During the mixing operation, scrape down the sides and bottom of the mixing pail with a flat or straight edge trowel at least once, to ensure complete mixing of A and B components.
3. Empty entire contents of mixed A and B components into an appropriate mortar mixer ensuring that walls and bottom of mixing pail are scraped/drain clean, and all of mixed epoxy resin is added to mortar mixer. Slowly add the entire content of component C and mix until uniformly blended, approximately five (5) minutes. Add all component C bags to the mix. With correct pre-conditioned temperatures, flow should not be a concern.
4. Mixed grout should be kept agitated prior to placement. Place grout after mixing.

APPLICATION METHOD / TOOLS

1. Pour the mixed grout into the prepared forms from one or two adjacent sides only, to eliminate air entrapment. Maintain the liquid head to ensure intimate contact to the base plate.
2. The minimum void depth beneath the base-plate should be 25 mm (1 in), but 38 mm (1.5 in) is preferred. Follow API 686 if applicable. Where the void

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beneath the base plate exceeds 450 mm (18 in), place the epoxy grout in successive 450 mm (18 in) lifts or less, once the preceding lift has cooled.

3. Place sufficient epoxy grout in the forms to rise slightly [3 mm (1/8 in)] above the underside of the base plate. The last lift must be kept at 50 mm (2 in) of thickness. Contact Sika Canada Technical Services for further information.

CLEAN UP

Sweep into appropriate containers. Dispose of in accordance with applicable local regulations. Uncured material can be removed with a solvent, such as xylene. Strictly follow solvent manufacturer's warnings and instructions for use. Cured material can only be removed mechanically.

LOCAL RESTRICTIONS

Note that as a result of specific local regulations the declared data and recommended uses for this product may vary from country to country. Consult the local Product Data Sheet for exact product data and uses.

LEGAL NOTES

The information, and in particular, the recommendations relating to the application and end-use of Sika products, are given in good faith based on Sika's current knowledge and experience of the products when properly stored, handled and applied under normal conditions in accordance with Sika's recommendations. In practice, the differences in materials, substrates and actual site conditions are such that no warranty in respect of merchantability or of fitness for a particular purpose, nor any liability arising out of any legal relationship whatsoever, can be inferred either from this information, or from any recommendations, or from any other advice offered. The information contained herein does not relieve the user of the products from testing them for the intended application and purpose. The proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users must always refer to the most recent issue of the local Product Data Sheet for the product concerned, copies of which will be supplied on request or may be downloaded from our website at: www.sika.ca

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