

SikaGrout® 328

High performance, precision, grout with extended working time

Construction

Description	<p>SikaGrout® 328 is a non-shrink, non-metallic, cementitious precision grout powered by ViscoCrete technology. This grout provides extended working time and exceptional physical performance at fluid consistency.</p> <p>A structural, precision grout, SikaGrout® 328 can be placed from fluid to dry pack over a temperature range of 40°-95°F. SikaGrout® 328 meets the ASTM-C 1107 (Grade B & C) and Corps of Engineers Specification CRD-C621.</p>
Where to Use	<ul style="list-style-type: none"> ■ Where exceptional one day and ultimate compressive strengths are required. ■ Applications requiring a pumpable grout. ■ Non-shrink grouting of machinery and equipment, base plates sole plates, precast panels, beams, columns and curtain walls. ■ Applications where a non-shrink grout is needed for maximum effective bearing area to transfer optimum load. ■ For underwater application in conjunction with Sikament® 100SC. Consult Technical Service for dosage information. Independent test data is available however on site testing is recommended to confirm performance under actual field conditions. ■ For grouting rebar, bolts, dowels and pins, etc.
Advantages	<ul style="list-style-type: none"> ■ Multiple fluidity with one material. ■ Reaches 10,000 psi in dry pack consistency. ■ Outstanding performance in fluid state. ■ Extended working time. ■ Excellent fluidity - sufficient time for placement. ■ Contains premium quality quartz aggregate. ■ Hardens free of segregation. ■ Non-metallic, will not stain or rust. ■ Meets CRD C-621 & ASTM C-1107 (Grade C). ■ Shows positive expansion. ■ SikaGrout® 328 is USDA-approved.
Coverage	Approximately 0.44 cu. ft./bag at high flow.
Packaging	Multi-wall bags; 40 bags/pallet, 50 lbs. per bag.

Typical Data (Material and curing conditions @ 73°F (23°C) and 50% R.H.)

RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.

Shelf Life	9 months in original, unopened bags.			
Storage Conditions	Store dry at 40°-95°F (4°-35°C). Recommend conditioning material to 65°-75°F before using.			
Color	Concrete gray			
Flow Conditions	Dry Pack (10-25%)	Plastic (100-125%)	Flowable¹ (124-145%)	Fluid² (20-60 sec)
Typical Water Requirements:	5.5 -6.0 pts.	6.5 -7.0 pts.	7.0 -7.5 pts.	8.0 -8.5 pts.
Set Time (ASTM C-191):	<i>Initial</i> <15mins	> 2 hr.	> 3 hr.	> 4 hr.
	<i>Final</i> < 2 hrs	< 6 hr.	< 7 hr.	< 8 hr.
Compressive Strength, psi ASTM-C-109				
1 day	5,000	4,500	4,000	3,500
3 day	8,000	6,500	6,000	5,500
14 day	9,200	7,000	6,700	6,500
28 day	10,000	8,200	8,000	7,500
Splitting Tensile, psi (ASTM C-496)				
3 day				350
7 day				400
28 day				650
Flexural Strength, psi (ASTM C-78)				
3 day				1,100
7 day				1,200
28 day				1,300

PRIOR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET WHICH ARE AVAILABLE ONLINE AT [HTTP://USA.SIKA.COM/](http://usa.sika.com/) OR BY CALLING SIKA'S TECHNICAL SERVICE DEPARTMENT AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION TO READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.



Bond Strength, psi (ASTM C-882 modified):

Hardened concrete to plastic grout

3 day	950
7 day	1750
28 day	2000

Freeze Thaw Cycles Procedures - (ASTM - C-666)

300 Cycles RDF 99%

¹CRD C-227: 100-124% (plastic), 124-145% (flowable)

²CRD C-611: 10-30 sec efflux time.

How to Use

Surface Preparation

Remove all dirt, oil, grease, and other bond-inhibiting materials by mechanical means. Anchor bolts to be grouted must be de-greased with suitable solvent. Concrete must be sound and roughened to promote mechanical adhesion. Prior to pouring, surface should be brought to a SSD (saturated surface dry) condition.

Forming: For pourable grout, construct forms to retain grout without leakage. Forms should be lined or coated with bond-breaker for easy removal. Forms should be sufficiently high to accommodate head of grout. Where grout-tight form is difficult to achieve, use SikaGrout® 328 in dry pack consistency.

Mixing

Mechanically mix with a low speed drill (400-600 rpm) for at least 5 minutes using a Sika mixing paddle or a jiffy paddle. SikaGrout® 328 can be mixed in an appropriately sized mortar mixer. Mixing should continue until a homogenous mixture is achieved.

Product Extension: For deeper applications, SikaGrout® 328 (plastic and flowable consistencies only) may be extended with 25 lbs. of 3/8" pea gravel. The aggregate must be non-reactive (Reference ASTM C1260, C227 and C289), clean, well-graded, saturated surface dry, have low absorption and high density, and comply with ASTM C33 size number 8 per Table 2. Add the pea gravel after the water and SikaGrout® 328.

Mixing Procedure: Make sure all forming, mixing, placing, and clean-up materials are on hand. Add appropriate quantity of clean water to achieve desired flow. Add bag of powder to mixing vessel. Mix to a uniform consistency, minimum of 5 minutes. Ambient and material temperature should be as close as possible to 70°F. If higher, use cold water; if colder, use warm water. Use only the amount of water required to achieve desired consistency. **DO NOT OVER WATER!**

Application

Within 60 minutes after mixing, place grout into forms in normal manner to avoid air entrapment. Vibrate, pump, or ram grout as necessary to achieve flow or compaction. SikaGrout® 328 must be confined leaving minimum exposed surface. After grout has achieved final set, remove forms, trim or shape exposed grout shoulders to designed profile. SikaGrout® 328 is an excellent grout for pumping, even at high flow. For pump recommendations, contact Technical Service. Wet cure for a minimum of 3 days or apply a curing compound which complies with ASTM C-309 on exposed surfaces.

Limitations

- Minimum ambient and substrate temperature 45°F and rising at time of application.
- Minimum application thickness: 1/2 in.
- For application thicknesses of 6 inches or greater, consult Sika's Technical Service Department.
- Do not use as a patching or overlay mortar or in unconfined areas.
- As with all cement based materials, avoid contact with aluminum to prevent adverse chemical reaction and possible product failure. Insulate potential areas of contact by coating aluminum bars, rails, posts etc. with an appropriate epoxy such as Sikadur 32 Hi-Mod.

PRIOR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET WHICH ARE AVAILABLE ONLINE AT [HTTP://USA.SIKA.COM/](http://usa.sika.com/) OR BY CALLING SIKA'S TECHNICAL SERVICE DEPARTMENT AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION TO READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.

KEEP CONTAINER TIGHTLY CLOSED. KEEP OUT OF REACH OF CHILDREN. NOT FOR INTERNAL CONSUMPTION. FOR INDUSTRIAL USE ONLY. FOR PROFESSIONAL USE ONLY.

For further information and advice regarding transportation, handling, storage and disposal of chemical products, users should refer to the actual Safety Data Sheets containing physical, ecological, toxicological and other safety related data. Read the current actual Safety Data Sheet before using the product. In case of emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887.

Prior to each use of any Sika product, the user must always read and follow the warnings and instructions on the product's most current Product Data Sheet, product label and Safety Data Sheet which are available online at <http://usa.sika.com/> or by calling Sika's Technical Service Department at 800-933-7452. Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instruction for each Sika product as set forth in the current Product Data Sheet, product label and Safety Data Sheet prior to product use.

SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS. SALE OF SIKA PRODUCTS ARE SUBJECT SIKA'S TERMS AND CONDITIONS OF SALE AVAILABLE AT [HTTP://USA.SIKA.COM/](http://usa.sika.com/) OR BY CALLING 201-933-8800.

Visit our website at usa.sika.com

1-800-933-SIKA NATIONWIDE

Regional Information and Sales Centers. For the location of your nearest Sika sales office, contact your regional center.

Sika Corporation
201 Polito Avenue
Lyndhurst, NJ 07071
Phone: 800-933-7452
Fax: 201-933-6225

Sika Canada Inc.
601 Delmar Avenue
Pointe Claire
Quebec H9R 4A9
Phone: 514-697-2610
Fax: 514-694-2792

Sika Mexicana S.A. de C.V.
Carretera Libre Celaya Km. 8.5
Fracc. Industrial Balvanera
Corregidora, Queretaro
C.P. 76920
Phone: 52 442 2385800
Fax: 52 442 2250537



Sika and SikaGrout are registered trademarks. Printed in Canada.

