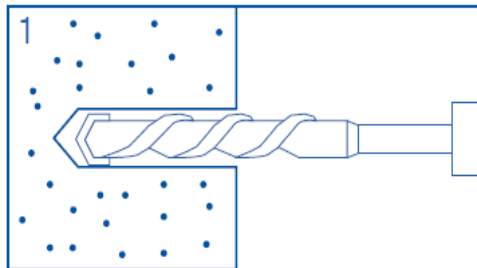


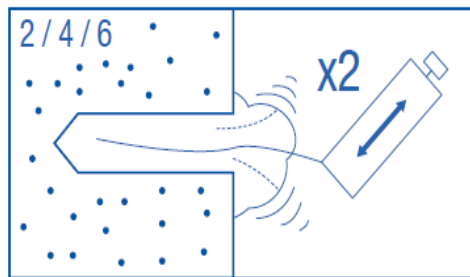
**METHOD STATEMENT: MasterFlow 918 AN – Vinylester resin based Anchoring Grout**

A TWO-COMPONENT VINYLESTER RESIN ANCHORING GROUT FOR USE WITH THREADED RODS ONLY INTO A SOLID SUBSTRATE.



1. Using the SDS Hammer Drill in rotary hammer mode for drilling, with a carbide tipped drill bit of the appropriate size, drill the hole to the required diameter and depth as indicated on the latest **MasterFlow 918 AN** technical data sheet.

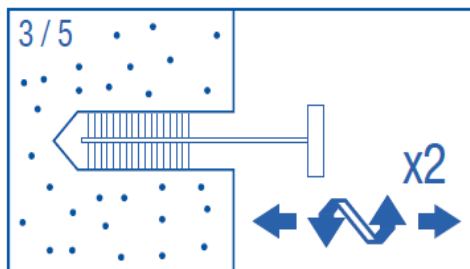
**Holes should be perfectly clean at the time of drilling and installation of the fixings but do NOT need to be dry (Can be used for flooded / underwater installation)**



2. Insert an Air Lance to the bottom of the hole and depress the trigger for 2 seconds. The compressed air must be clean – free from water and oil – and at a minimum pressure of 6 bar.

Perform the blowing operation twice.

Alternatively use a suitable hand operated air pump or wash out with high pressure water.



3. Select the correct size Hole Cleaning Brush. Ensure that the brush is in good condition and the correct diameter. Insert the brush to the bottom of hole, using a brush extension if needed to reach the bottom of the hole and withdraw with a twisting motion. There should be positive interaction between the steel bristles of the brush and the sides of the drilled hole.

Perform the brushing operation twice.

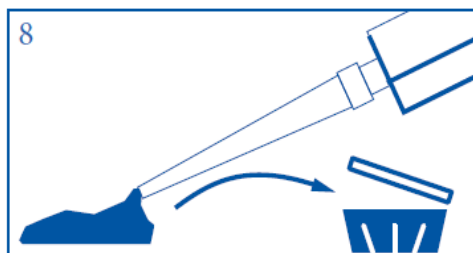
4. Repeat Step 2 to ensure the drilled hole is perfectly clean.

5. Repeat Step 3 for a final time.

6. Repeat Step 2 for a final time.

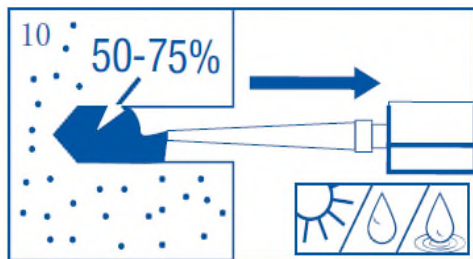
7. Select the appropriate static mixer nozzle, checking that the mixing elements are present and correct (**do not modify the mixer**). Attach mixer nozzle to the cartridge. Check the Dispensing Tool is in good working order. Place the cartridge into the dispensing tool.

**Note:** The QH nozzle is in two sections. One section contains the mixing elements and the other section is an extension piece. Connect the extension piece to the mixing section by pushing the two sections firmly together until a positive engagement is felt.



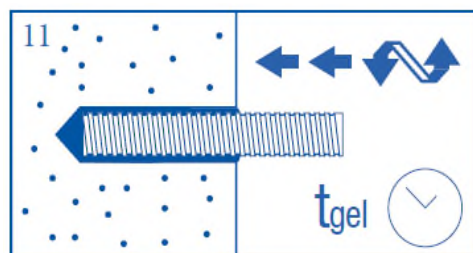
8. Extrude some resin to waste until an even-coloured mixture is extruded. The cartridge is now ready for use.

9. Attach an extension tube with resin stopper (if required) to the end of the mixing nozzle with a push fit. (The extension tubes may be pushed into the resin stoppers and are held in place with a coarse internal thread).

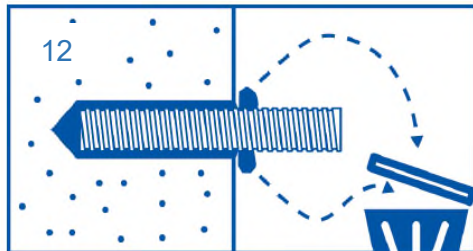


10. Insert the mixing nozzle to the bottom of the hole. Extrude the resin and slowly withdraw the nozzle from the hole. Ensure no air voids are created as the nozzle is withdrawn. Inject resin until the hole is approximately  $\frac{3}{4}$  full and remove the nozzle from the hole. Release the pressure on the cartridge to prevent any further material being extruded accidentally.

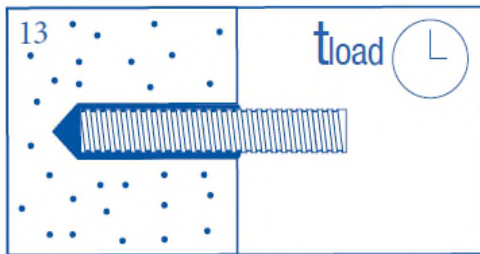
**Select the threaded steel anchor element ensuring it is free from oil or other contaminants and mark with the required embedment depth before any material is applied as the working time of the adhesive is extremely short at high ambient temperatures (>25°C)**



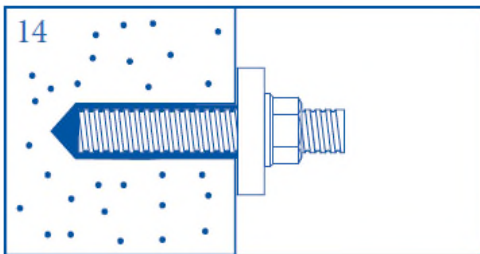
11. Immediately insert the threaded steel anchor element into the hole using a back and forth twisting motion to ensure complete cover, until it reaches the bottom of the hole. Excess resin will be expelled from the hole evenly around the steel element and there shall be no gaps between the anchor element and the wall of the drilled hole.



12. Clean any excess resin from around the mouth of the hole using a clean damp cloth or paper towel. Discard correctly. If necessary fit a template in place to ensure the fitted anchors are held in the correct alignment whilst the epoxy sets hard



13. Do not disturb the anchor until at least the minimum cure time has elapsed. Refer to the Working and Load timetable to determine the appropriate cure time. Cure time is temperature dependent (>3 hours @40°C)



14. Position the fixture and tighten the anchor to the appropriate installation torque. **Always allow sufficient curing time BEFORE tightening the anchors.**

**15. Do not over-torque the anchor as this could adversely affect the performance**

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## STATEMENT OF RESPONSIBILITY

The technical information and application advice given in this Master Builders Solutions publication are based on the present state of our best scientific and practical knowledge. As the information herein is of a general nature, no assumption can be made as to a product's suitability for a particular use or application and no warranty as to its accuracy, reliability or completeness either expressed or implied is given other than those required by law. The user is responsible for checking the suitability of products for their intended use.

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## NOTE

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