



PRODUCT HANDLING
GUIDE

www.geoproinc.com

A LETTER FROM OUR VICE PRESIDENT

This product handling guide is a collection of solutions for issues that GeoPro has helped contractors solve since we began offering the world's first thermally-enhanced grout, Thermal Grout 85, in 1996. Our intent is not to answer every possible question but we hope you will take the time to thoroughly read this document so that you might be able to avoid some of the same problems that others before you might have experienced.

As always, we are here to help you work through any specific problems you may have. Please give us a call at **(877) 580-9348** and a member of our experienced staff will be available to help.

Sincerely,



Allan Skouby

P.S. This product handling guide and an ever-growing collection of geothermal and thermal grout related resources and tools can be found on our web site. Just go to **www.geoproinc.com** to get free access to all we have available. Also, don't forget to take advantage of our free support services like grout thermal conductivity testing, silica sand analysis and loopfield design assistance.

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GEOPRO GROUTING PRODUCTS

Every GeoPro grouting product is designed to meet a specific range of project requirements. Selecting the correct grout for a project will save you time, money and reduce the chances a problem will occur. Below is a brief introduction to our line of grouting products to help you make the correct choice for your application.

BH20

grout

BH20 is a specially formulated bentonite based grouting product used as a 20-25% solids mixture ideally suited for use in projects where thermal conductivity in the bore hole is not critical.

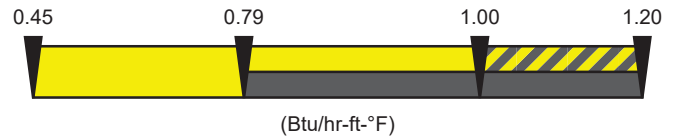
0.40 - 0.42
(Btu / hr-ft-°F)

Thermal Conductivity Increases with % Solids.

TG Lite

thermal grout

TG Lite is the first product in our Thermal Grout line and is designed specifically for geothermal heating and cooling applications where traditional silica sand-based mixes are being used and desired thermal conductivities range between 0.45-1.00 Btu/hr-ft-°F. TG Lite can be used with PowerTEC or PowerTEC_x to achieve thermal conductivities up to 1.20 Btu/hr-ft-°F with or without the use of silica sand.



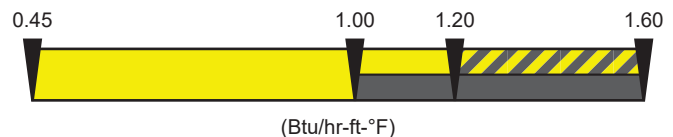
- TG Lite w/ Silica Sand Only
- TG Lite w/ PowerTEC/PowerTEC_x Only
- ▨ TG Lite w/ Silica Sand & PowerTEC/PowerTEC_x

For thermal conductivities greater than 1.20, use TG Select.

TG Select

thermal grout

TG Select shares the pumpability and ease of handling exhibited by BH20 and TG Lite but has an increased capacity for thermal enhancement compounds allowing for thermal conductivities in the range of 0.45-1.20 Btu/hr-ft-°F for traditional silica sand-based mixes. TG Select can be used with PowerTEC or PowerTEC_x to achieve thermal conductivity values up to 1.60 Btu/hr-ft-°F with or without the use of silica sand.



- TG Select w/ Silica Sand Only
- TG Select w/ PowerTEC/PowerTEC_x Only
- ▨ TG Select w/ Silica Sand & PowerTEC/PowerTEC_x

THERMAL ENHANCEMENT COMPOUNDS

Specific thermal conductivities and handling characteristics of GeoPro's thermal grouts are achieved through the proper blending of thermal enhancement compounds. The selection of thermal enhancement compound will depend on a variety of factors including target conductivity, installation type and project cost.

POWERTEC \ POWERTEC^x

PowerTEC and PowerTEC^x are specially formulated, graphite based thermal enhancement compounds designed to be field mixed with GeoPro thermal grouts to achieve thermal conductivities ranging from 0.79-1.60 Btu/hr·ft·°F. Use PowerTEC and PowerTEC^x with, or as a replacement for traditional silica sand to lower mixed viscosity, reduce formation losses, decrease grout weight, and to minimize the amount of material required at the job site.

CONSIDER FOR USE IN

- All Horizontal and Vertical boring applications especially where silica sand is difficult to source or expensive to ship.
- Horizontally Bored GHEX installations to lower viscosity and improve pumpability.
- Loopfield installations where space is limited and the reduction of total material on-site is beneficial.
- Commercial ground heat exchange designs that require thermal conductivities above 1.20 Btu/hr·ft·°F.

BENEFITS

- Capable of delivering the widest range of thermal conductivities in the industry. Mix conductivities range from 0.79 all the way up to 1.60 Btu/hr·ft·°F.
- Reduces or eliminates the need for silica sand on the jobsite.
- Lower viscosity and self-lubricating nature decreases wear on grouting equipment.
- Decreases formation losses in fractured and porous formations as compared to traditional thermal grout mixes.
- Reduces total freight cost for a project by decreasing the required amount of dry material.
- NSF/ANSI Standard 60 Certified to not contribute contaminants to drinking water that could cause adverse health effects.

Mixes using PowerTEC^x are extremely sensitive to mix water volume. It is strongly recommended that a water meter assembly like GeoPro's Water Meter Kit be used with every PowerTEC^x installation.

PowerTEC^x is designed exclusively for use with GeoPro's thermal grout products. Use with unapproved bentonite products may result in damage to equipment and unknown performance/handling characteristics.



THERMAL ENHANCEMENT COMPOUNDS

SILICA SAND

High quality silica sand is the traditional thermal enhancement compound used for geothermal grouting applications. Silica sand may be sourced locally however, we do specify minimum requirements that must be met to ensure that the sand will work as a thermal enhancement compound.

Silica sand should be washed, dried and pre-packaged. This ensures that moisture in the sand will not affect the water volume required in our mix recipes. The Silica Dioxide (SiO_2) content of the sand should be greater than 99% and the sand particle size must conform to the following guidelines.

PARTICLE SIZE

Over a decade of research has shown that the SHAPE of a particle is not as important as its SIZE. Recommended values for grain fineness (**AFS GFN**), a measure of the particle size distribution of the sand, are shown below:



Sands having AFS GFN values lower than the recommended range will be difficult to suspend in the grout slurry and sands having AFS GFN values higher than the recommended range will result in a mixture that is very thick and difficult to pump.

SAND EVALUATION SERVICES

We encourage drilling contractors to explore various sand sources that are close to the project site. While we have already evaluated a large number of commercial high-grade silica sand sources, there may be some sources that have not been fully examined. Simply contact us when interested in using sand from a given source.

If we have already evaluated the sand source, GeoPro will supply you with the necessary information. If we have not evaluated the source in question, we will take the action necessary to determine its suitability for use with our thermal grout products.

In most cases, we will obtain approximately 15 lbs. of the sand and have it sent to our laboratory for a free evaluation. Once the sample is received, we will determine the thermal conductivity range of values that can be obtained with the sand. If necessary, we will offer an adjusted recipe to achieve the target value. In some cases, locally obtained sand may not be able to satisfy the specified thermal conductivity value for your project. In these cases, we will provide alternative recommendations.

When the silica sand for a given project is not supplied by GeoPro, we will not take any responsibility for the quality control of the sand or of the final delivered thermal conductivity on the project.

WHICH GROUT IS RIGHT FOR YOU?

GeoPro grouting products DO NOT flash hydrate.

BH20

BH20 is a standard grouting product (not a thermally-enhanced grout), specifically designed to be used as a 20-25% solids mixture.

- Commonly used for residential GSHP applications.
- BH20 is not designed for use at higher than 25% solids concentrations.
- Not designed for use with any thermal enhancement compounds.
- When used outside of specified limits, BH20 is designed to become nearly impossible to mix and pump.
- BH20 does not require the use of polymer, soda ash or other mix water additives for proper handling.



TG LITE

Thermal Grout Lite (TG Lite) is GeoPro's mid-range, thermally-enhanced grouting product designed to reach thermal conductivity values between 0.45 and 1.00 Btu/hr ft °F in traditional silica sand-based mixes and may be mixed to conductivities up to 1.20 Btu/hr ft °F with PowerTEC or PowerTECx.

- TG Lite is commonly used on both residential and commercial applications, as specified by the system designer.
- TG Lite is not designed for use with more than 250 lb of silica sand (per bag) in traditional silica sand-based mixes.
- When used outside of its specified limits, TG Lite is designed to become difficult to mix and pump.
- It is possible to mix TG Lite at levels below its intended use, but the cost to do so will be higher than using BH20 and there is generally no economic or performance-related benefit to justify doing so.
- TG Lite does not require the use of polymer, soda ash or other mix water additives for proper handling.



TG SELECT

Thermal Grout Select (TG Select) is GeoPro's premium, thermally-enhanced grouting product designed to reach thermal conductivity values between 0.45 and 1.20 Btu/hr ft °F in traditional silica sand-based mixes and may be mixed to conductivities up to 1.60 Btu/hr ft °F with PowerTEC or PowerTECx.

- TG Select is commonly used on commercial applications, as specified by the system designer.
- TG Select is not designed for use with more than 400 lb of silica sand (per bag) in traditional silica sand-based mixes.
- It is possible to mix TG Select at levels below its intended use, but the cost to do so will be higher than using TG Lite and there is generally no economic or performance-related benefit to justify doing so.
- TG Select does not require the use of polymer, soda ash or other mix water additives for proper handling.



GENERAL MIXING GUIDELINES

Follow the instructions printed directly on every bag of our products.

As trivial as this statement seems to be, it is extremely important. Follow the mixing instructions printed on the bag to increase the success rate with our products.

MIXING GUIDELINES

- ⦿ For all grouts do your best to make sure your mix water measurements are accurate. The easiest way to do so is to use GeoPro Water Meter Kit, which is specifically designed for use with Geo-Loop grouting equipment.
- ⦿ For thermally-enhanced grouts, allow enough time for the grout to thicken before adding thermal enhancement compounds. Adding thermal enhancement compounds too soon can cause issues with settling.
- ⦿ Make sure the thermal enhancement compound (especially sand) is fully mixed into the slurry before pumping. Lumps of sand can plug a tremie line.
- ⦿ Follow the specified mixing order and mixing times provided on each bag and wear a Particulate Respirator that meets or exceeds NIOSH: N95 approval when mixing.

BH20, Thermal Grout Lite and Thermal Grout Select have been specifically designed to maximize working time without requiring the use of polymers or chemical additives.

DON'T "THIN IT DOWN"

Accurate mix water measurement will reduce issues in the field and ensure that delivered performance meets specifications (with respect to thermal conductivity and permeability).

Many loop contractors that are new to the industry may not be familiar with the handling of high-solids grouting products, especially thermally-enhanced grouts. Thermal grout will be denser and more viscous than traditional bentonite-based drilling fluid and by nature, more difficult to mix and pump. A common reaction is to add extra water to the slurry to "thin it down". However, over watering thermal grout will cause multiple problems:

- ⦿ Over-watering dilutes the mixture, lowering the overall solids content and reducing the ability of thermal grout to properly seal the bore and transfer heat away from the pipe.
- ⦿ Over-watering reduces ability of thermal grout to suspend the silica sand in the slurry. When this happens, the sand can settle to the bottom of the paddle mixing tank and pack into the piston pump assembly, plugging it completely.

WATER QUALITY



NO ADDITIVES REQUIRED

While water quality is a major issue with certain manufacturers and their respective thermal grout products, Thermal Grout Lite, Thermal Grout Select and BH20 are the only products available that **will not flash hydrate** and **do not require water additives** for proper handling (such as polymer to prevent flash hydration or soda ash to treat water quality), except in extreme situations.

USE POTABLE WATER

Simply use potable water throughout the entire grouting process and issues that stem from water quality will be minimal. Do not use surface water or drilling fluid for mix water. Also, keep in mind that the optimum mix water temperature during grouting is 50-80°F. Refer to **Seasonal Issues** for a complete discussion on the effect of mix water temperature on thermal grout.

pH LEVEL

Typical ground water pH values will range between 5 and 6. In areas where ground water could be contaminated by acid rain, a pH as low as 4 could be seen. Water high in minerals could see pH values above neutral and are typically in the range between 7 and 9. BH20, TG Lite and TG Select will perform best when mix water pH levels are between 5 and 7 but will still provide satisfactory performance with pH values between 7 and 9.

DISSOLVED SODIUM (SALT)

Sodium is naturally present in ground water. The content of sodium in water varies anywhere from a few parts per million to as high as 35 g/L in saltwater. For our purposes, salt concentration in mixing water should not exceed 0.5 g/L.

It should be noted that when BH20, TG Lite or TG Select are mixed with fresh water and then pumped into a formation where salt water exists, grout performance will not be affected. **Salt water will only negatively affect grout characteristics when it is used as mix water.**

CHLORINE CONTENT

BH20, TG Lite and TG Select are not sensitive to chlorine levels in mixing water. As long as the concentration level does not exceed 20 ppm, the presence of chlorine in mixing water will not be an issue. As a frame of reference, heavily chlorinated swimming pool water will contain about 2 - 3 ppm of chlorine. Levels above 5 ppm are not typically seen as such concentrations are deemed a risk to human health.

MIXING EQUIPMENT CAPABILITIES

Any downtime during grout placement due to process inefficiency or inadequate equipment capabilities will increase the chance for a plugged pump assembly or tremie line (or both). Proper mixing and pumping equipment as well as a sufficiently sized tremie line mounted on a reel will greatly reduce equipment-related issues in the field.

A natural property of bentonite is that it reacts with water more rapidly with high rates of shear. In other words the faster you try to move and agitate the material, the faster it will hydrate or “set up”. When grout is exposed to high rates of shear, it will hydrate quickly and can become too thick to mix and pump through a long tremie line. This fact predetermines the kind of mixing and pumping equipment as well as the methods that can be used with our grouting products.

MIXING EQUIPMENT

The method used for mixing grout must be low-shear. Paddle mixing is the recommended method which simply uses rotating paddles in a barrel-like container to agitate and mix the slurry. Jet mixing or recirculation methods are not recommended.

PUMPING EQUIPMENT

As is the case with mixing, the method used for pumping must be low shear. When a silica sand-based mix is used, thermal grout will be extremely abrasive to most types of positive displacement pumps. Research and field experience has proven that a piston-style pump offers the best results with the least amount of maintenance cost. Use of non-positive displacement pumping equipment (such as centrifugal pumping equipment) is not recommended.

Ensure that the selected piece of equipment is a "grout" pump and not a "mud" pump. "Grout" pumps are designed to deliver the high pressures and low volumes that are typically required for proper placement. "Mud" pumps deliver high volumes at low pressures which are not usually adequate for proper grout placement.

TREMIE LINE

Although a tremie line can be constructed of any material, we highly recommend using one made of flexible material with a high pressure rating for long life and ease of use (such as 2500-psi rated flexible sewer cleaning hose).

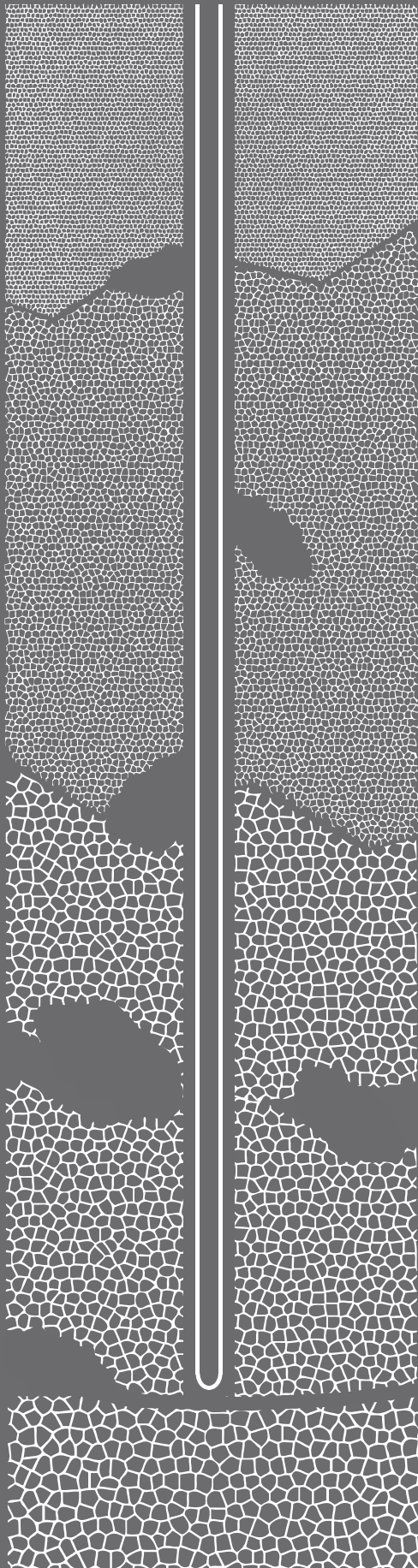
The recommended diameter for a tremie line is 1¼" for most applications. However, using a 1" tremie may be possible when BH20 (20% solids, standard high solids grout) is used in shallow bores.

TREMIE REEL ASSEMBLY

A tremie reel is another piece of equipment that can increase efficiency during grout placement. A tremie reel will roll or unroll the coiled tremie line as it is inserted into and removed from the bore during the grouting process. Tremie reels can either be manually or hydraulically controlled.

We recommend using a reel that is mounted on a swivel so that it can be properly aligned with the bore for ease of tremie insertion and subsequent removal.

FORMATION LOSSES



In certain formations, bores will require excessive amounts of BH20 or thermal grout to be completely filled to the top. Some examples would be highly-fractured consolidated (rock) formations, large crevasses, small caverns or flow aquifers, gravel formations, cobbles, etc.

UNCONSOLIDATED FORMATION WITH POROUS GRAVEL OR COBBLE ZONES

PROBLEM

When porous unconsolidated formations are encountered, it is likely that there won't be a specific zone that can be plugged. However, large amounts of grout can still flow into permeable soil before the grout fully hydrates or "sets up".

SOLUTION

There are two methods to reduce (but not completely eliminate) such losses. First, for thermally enhanced grouts, use PowerTEC_x to replace all or part of the traditional silica sand. The inherent increase in bentonite increases the gel strength of the mix while the lighter weight of PowerTEC_x mixes decreases the pressure exerted by the grout against the bore wall thus slowing the flow of the grout through the permeable soil.

Second, allow the grout to thicken before placement. This can be accomplished by either extending mixing time in the tank or by reducing the amount of mix water in each batch (by 1-2 gallons per 50 lb bag of BH20, TG Lite or TG Select).

HIGHLY FRACTURED OR CAVERNOUS CONSOLIDATED ROCK FORMATIONS

PROBLEM

When highly-fractured or cavernous rock formations are encountered, large amounts of grout can flow into or be washed through the fractured zones.

SOLUTION

One way to stop such losses is to place a granular material such as our 3/8" Bentonite Plug through the problem area. In this situation, the best method of placement is to start by pumping grout from the bottom of the bore up to the problem area. Next, plug the fractured zone by removing the tremie line from the hole and simultaneously pouring 3/8" Bentonite Plug and pea rock from the surface to build a bridge through the fracture.

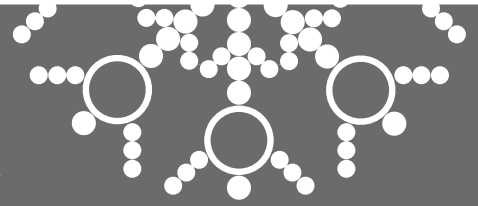
The bridge will serve as a platform to resume grouting from just above the fracture up to the top of the hole. Typically, this small amount of material (with a considerably lower thermal conductivity value) will not significantly affect the average thermal performance of the bore.



CONTACT
877.580.9348

Contact our technical support department for help determining the best course of action when similar problems arise.

SEASONAL ISSUES



Time of year can greatly affect incoming mix water temperature. Through the winter and into early spring, mix water temperatures will be their coldest. Conversely, through the summer months and into early fall, water temperatures will be their warmest.

50°F IDEAL MIX WATER TEMPERATURE RANGE **80°F**

COLD MIX WATER (< 50°F)

A natural property of bentonite is that it reacts with water more slowly with decreasing water temperature. When thermal grout is exposed to cold mix water, its slow hydration rate may cause sand settling in the mixing tank. While nothing can be done to the bentonite itself to overcome this issue, several precautions can be made to minimize issues in the field.

Extend mixing time for each batch. Increasing the mix time by 2-4 minutes on each batch before adding the silica sand component will give the thermal grout more time to hydrate and in doing so, give it more gel strength so it can adequately suspend the sand in the slurry.

Decrease water content in each batch. Removing mix water (1-2 gallons of water per 50 lb bag of BH20, TG Lite or TG Select) will thicken the mixture, increasing its overall gel strength and ability to suspend the sand in the slurry.

Use finer sand. Fine sand particles are easier to suspend than coarse particles. Switching to a finer grade of silica sand may alleviate issues related to cold mix water and sand settling.

Use PowerTEC_x. PowerTEC_x particles are lighter and easier to suspend than sand. Extended mix times may still be necessary to ensure proper suspension.

HOT MIX WATER (> 80°F)

Hot mix water has the opposite effect of cold mix water. Bentonite reacts more rapidly with increasing water temperature. When exposed to hot mix water, the rapid hydration rate may cause thermal grout to become difficult to handle. If the mix water is hot enough, it can plug the mixing tank, pump assembly or tremie line. As before, while nothing can be done to the bentonite to overcome this issue, several precautions can be made to minimize issues in the field.

Draw directly from the public water supply. The most effective way to prevent mix water from becoming too warm is to draw it directly from the public water system into the mixing tank. This will ensure that the mix water is not given time to absorb excessive amounts of solar energy before being mixed with the grout.

Keep storage tanks in shaded areas. If drawing directly from the public water supply is not an option, make sure that the on-site storage tank is not placed in direct sunlight. If possible, place it in a shaded area to minimize solar heat absorption by the water.

Drain water lines. Ensure that the water line from the storage tank to the mixing tank is not extremely long. If the water line holds a large volume of water and is allowed to sit in direct sunlight, drain the line completely to prevent the hot water from being introduced into the mixing tank.

Use coarser sand. Coarse sand particles absorb less water than fine particles. Switching to a coarser grade of silica sand will yield a thinner grout slurry and may alleviate issues related to hot mix water.

SAMPLING ISSUES



GeoPro offers grout sample thermal conductivity testing (performed in our lab according to ASTM D-5334, line source method) as a free service to any customer who chooses to take advantage of the service.

All of the thermal conductivity (TC) tests performed by GeoPro are blind. We report the tested TC value of a sample without any knowledge of your targeted value. If the reported value meets or exceeds the target value, no action will be required. If the reported value falls below target, we will work to help determine possible causes and solutions for the discrepancy.

SAMPLING GUIDELINES

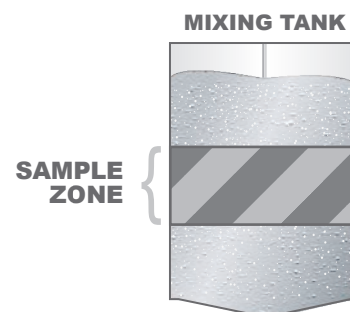
If our mixing specifications are followed with a reasonable degree of accuracy in the field, drilling contractors should meet or exceed thermal conductivity specifications every time. Occasionally, we are contacted when the contractor is making every effort to follow our mixing specifications, are using a pre-approved silica sand source and the tested values of the grout samples they submit still fall below their target value. In these cases, the discrepancies can usually be attributed to sampling error.

When obtaining a sample fill the sample container completely. Samples that are too small will not be tested and a new sample will need to be submitted.

SAMPLING FROM THE PADDLE MIXING TANK

Take the sample from the middle (vertically) of the batch. When sampling from the tank, make sure the mixer is at a COMPLETE STOP before doing so.

Taking the sample by skimming grout off of the top of the tank will probably result in a thermal conductivity test value that falls below target. GeoPro makes a grout sample collector available for purchase that has been specifically designed to take an appropriately-sized sample from the center of the mixing tank without requiring the sample-taker to get their hands dirty. Contact us for more information.



SAMPLING FROM THE TREMIE OR CLEANOUT LINE

When obtaining a grout sample directly from the end of the tremie or from the cleanout bypass (side discharge), take the sample in the middle or near the end of pumping the batch. It will be easiest to take the sample when the tremie line is at the top of the bore and there is material left in the line.

Taking the sample at the beginning of the pumping process will likely result in a tested thermal conductivity value which falls below target.

SAMPLING FROM THE COMPLETED BORE

NEVER attempt to take a grout sample intended for thermal conductivity analysis from the completed bore.

To initiate sample thermal conductivity testing, simply contact our Technical Support department and we will send the requested number of grout sample containers with instructions and a Thermal Conductivity Analysis Sheet to fill out with each sample.

SHIPPING AND STORAGE



SHIPPING



GeoPro grouts are shipped on heat shrunk 54 bag pallets. The number of pallets per truck may vary by carrier but is typically 17 for a total of 918 bags of grout per truckload. Prior to leaving our facility, we require that all loads are tarped because heat shrinking and the bags themselves are not designed to withstand the elements. If a load arrives on site and is untarped, it is important to contact us prior to taking possession of the load at (877) 580-9348.

If your load is untarped upon arrival, contact us immediately at (877) 580-9348.

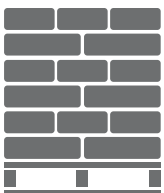
TIME YOUR DELIVERIES



On large projects, grouting materials can require a large area for storage. It is important to know how much space is available on site prior to ordering your grout. GeoPro will work with you, your distributor and your construction schedule to time deliveries to keep your job site safe and your crew working.

Remember, PowerTEC_x can significantly reduce the required amount of material on site when compared to traditional silica sand-based mixes. Consider switching when space is at a premium.

PROTECT YOUR PURCHASE



Exposure to moisture prior to mixing will ruin grouting products and will alter the performance of thermal enhancement compounds. GeoPro's bags are water resistant not water proof. The heat shrinking on our pallets keeps our pallets together for shipping and is not intended as a water proofing measure.

It is very important that pallets are tarped or stored under cover. The tarp used during shipment is the property of the carrier and will not be left on site. Be sure to make arrangements for proper storage prior to delivery. Failure to do so may result in lost product, damage to equipment and/or unpredictable product performance.

Always protect your GeoPro products from the elements by storing them under a tarp or under cover.

INFORMATION AND RESOURCES



GeoPro has collected a lot of useful information throughout our years in the geothermal industry. Our resources are here to shed some light on topics like grout selection, ground heat exchanger design and just generally useful bits of information for geothermal system installers and designers. All of this information can be found in the resources section on our website at: www.geoproinc.com.

THE IMPORTANCE OF GROUT TC



This informative guide explains how choosing the correct grout thermal conductivity value can save a lot of money on your next geothermal system design.

geoproinc.com/resources/importance_of_grout_tc.html

THERMAL GROUT COMMISSIONING



This document is intended to serve as a road map for ensuring the success of your system through the design and installation process from a grouting perspective.

geoproinc.com/resources/thermal_grout_commissioning.html

PRODUCT SUBMITTAL SHEETS



Submittals provide proper mixing and pumping instructions for every thermal grout product we sell with all the specifications for accurate loopfield grouting.

geoproinc.com/resources/documents.html#submittals

RECOMMENDED GROUTING SPECS



Suggested specifications for the correct materials, target thermal conductivity, proper installation and inspection of each borehole.

geoproinc.com/resources/documents.html#specs

SAMPLING GUIDELINES



Accurate grout thermal conductivity testing results for geothermal applications start in the field with proper sampling.

geoproinc.com/services/grout_sample_collection_101.html

GROUT VOLUME & COST CALCULATOR



This calculator will allow you to estimate the installed volume of grout required for your project, help to estimate total project costs including: material, freight and labor.

geoproinc.com/calculators/grout_calculator.htm

CONTACT

877.580.9348



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