

CHOCKFAST BLUE

TECHNICAL BULLETIN #616-J

CHOCKFAST BLUE is a two component, pourable epoxy grouting compound for severe applications. This highly developed material is often used to replace steel soleplates or rails and is used as an epoxy foundation capping material which is resistant to high operating temperatures. Its unique properties permit usage directly under highly stressed machinery mounting surfaces. Typical applications include the grouting of diesel engines, compressors, generators, gears, pumps and most other heavy equipment. CHOCKFAST BLUE is unexcelled under heavy reciprocating and rotary machinery due to its excellent resistance to creep, fatigue and shock forces. It is also an excellent support surface for the CHOCKFAST BLACK epoxy chock.

CHOCKFAST BLUE is normally used in a thickness range of 25-38mm (1" to 1-1/2"). Thicker sections can be constructed with CHOCKFAST BLUE if proper layering techniques are used. Please contact ITW Philadelphia Resins for additional application instructions.

Long pours should be divided into sections not exceeding 1.1m (3'6") in length. Longer, thicker or thinner pours are possible, but ITW Philadelphia Resins should be consulted before deciding upon them. The pourable viscosity of the CHOCKFAST BLUE provides for essentially 100% surface contact. Because CHOCKFAST BLUE has negligible shrinkage, final alignment may be set before grouting.

For CHOCKFAST BLUE temperatures that will be between 49°-60°C (120°-140°F) during engine operation the static loading shall not normally exceed 35 kg/cm² (500 psi) which is perfectly practical for most machinery. Below 49°C (120°F) loadings up to 140 kg/cm² (2,000 psi) are permissible, but 85 kg/cm² (1,200 psi) should not be exceeded without reference to ITW Philadelphia Resins, who are always available for consultation on any application. Request Bulletins # 640 and #642 for additional design and application detail.

Precondition resin and hardener to 21°-27°C (70°-80°F) for 24 hours before mixing. The hardener should be added to the resin and power mixed until a homogeneous color and texture are apparent. Mixing for 3-5 minutes with a Kol mixer or a large Jiffy mixer blade in a 3/4" drilling machine is usually sufficient.



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PHYSICAL PROPERTIES

COEFFICIENT OF LINEAR THERMAL EXPANSION: Temperature range	0°C to 60°C ASTM D-6 15.4 X 10 ⁻⁶ /F°	27.7 x 10 ⁻⁶ /C° (32°F to 140°F)
COMPRESSIVE MODULUS OF ELASTICITY:	115300 kg/cm ² (1,640,000 psi)	ASTM C-579
COMPRESSIVE STRENGTH:	1336 kg/cm ² (19,000 psi)	ASTM C-579
FIRE RESISTANCE:	Self-extinguishing	ASTM D-635
FLEXURAL STRENGTH	345 kg/cm ² (4920 psi)	ASTM C-580
FLEXURAL MODULUS OF ELASTICITY	120300 kg/cm ² (1.7 X 10 ⁶ psi)	ASTM C-580
IZOD IMPACT STRENGTH:	.15 Newton m/cm (3.4 in.lbs./in.)	ASTM D-256
LINEAR SHRINKAGE:	0.0001 mm/mm (0.0001 in./in.)	ASTM D-2566
POT LIFE:	35-50 minutes @ 21°C (70°F)	
SPECIFIC GRAVITY:	2.0	
TENSILE STRENGTH:	225 kg/cm ² (3156 psi)	ASTM D-638
COVERAGE:	500 cc/kg .435 m ² @ 30 mm (13.8 cu.in./lb.) (640 in ² @ 1-1/4")	
CURE TIME:	36 hrs. @ 16°C (60°F) 24 hrs. @ 21°C (72°F) 16 hrs. @ 27°C (80°F) 11 hrs. @ 32°C (90°F)	
PACKAGING:	26 kg (58 lbs.) in 5-gal. can 13.1 liters (800 cu.in.)	
SHELF LIFE:	Excess of 2 years in dry storage	