

# CHOCKFAST ORANGE®

## Technical Bulletin # 659E

### DESCRIPTION:

CHOCKFAST ORANGE (PR-610TCF) is a specially formulated 100% solids, two component inert filled casting compound developed for use as a chocking or grouting material. CHOCKFAST is designed to withstand severe marine and industrial environments involving a high degree of both physical and thermal shock. The compound is non shrinking and has very high impact and compressive strength. Years of successful in-service experience have shown the use of PR-610TCF to be a far superior yet less expensive method of establishing and permanently retaining precise equipment alignment under extreme conditions. PR-610TCF is approved or accepted for its intended marine use by American Bureau of Shipping, Lloyd's Register, Bureau Veritas, Det Norske Veritas, Germanischer Lloyd and most other major regulatory agencies worldwide.

### APPLICATION:

CHOCKFAST ORANGE was developed as a chocking or grouting compound for use under marine main propulsion machinery. The compound is used under diesel and gas engines, reduction gears, generators, compressors, pumps, bearing blocks, crane rails and numerous other applications. PR-610TCF requires no special tools or special skills as does chocking with steel. When cast, CHOCKFAST ORANGE flows readily into the chock area filling voids and conforming to all irregularities. This eliminates the machining of base plates or foundations for a perfectly fitted chock.

### PHYSICAL PROPERTIES:

COEFFICIENT OF LINEAR THERMAL EXPANSION: Temperature Range: 0°C to 60°C (32°F to 140°F)	30.8 x 10 <sup>-6</sup> /C° 17.1 x 10 <sup>-6</sup> /F°	ASTM D-696
COMPRESSIVE MODULUS OF ELASTICITY:	37482 kg/cm <sup>2</sup> (533,000 psi)	ASTM D-695
COMPRESSIVE STRENGTH:	1336 kg/cm <sup>2</sup> (19,000 psi)	ASTM D-695 (Mod)
FIRE RESISTANCE:	Self extinguishing	ASTM D-635
FLEXURAL STRENGTH:	575 kg/cm <sup>2</sup> (7615 psi)	ASTM C-580
FLEXURAL MODULUS OF ELASTICITY	72880 kg/cm <sup>2</sup> (8.6 x 10 <sup>9</sup> psi)	ASTM C-580
HARDNESS - BARCOL:	40+ fully cured 35 minimum	ASTM D-2583

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**PHYSICAL PROPERTIES (con't)**

LINEAR SHRINKAGE:	0.0002 mm/mm (0.0002 in/in), 0.02%	ASTM D-2566
POT LIFE:	30 min. @ 21°C (70°F)	
SPECIFIC GRAVITY:	1.58	
TENSILE STRENGTH:	349 kg/cm <sup>2</sup> (4,970 psi)	ASTM D-638
COVERAGE:	1966 cc per 3.4 kg (120 cu.in/7.5 lbs.) 4261 cc per 6.8 kg (260 cu.in/15 lbs.)	
CURE TIME:	48 hours @ 15°C (60°F) 36 hours @ 18°C (65°F) 24 hours @ 21°C (70°F) 18 hours @ 26°C (80°F)	
SHELF LIFE:	More than 18 months	
SHOCK RESISTANCE:	Pass MIL-S-901C (Navy) High Impact Shock Test, Grade A, Type A, Class 1	
SHEAR STRENGTH:	380 kg/cm <sup>2</sup> (5,400 psi)	FED-STD-406 (Method 1041)
THERMAL SHOCK:	Pass -18°C to 100°C (0°F to 212°F)	ASTM D-746
VIBRATION:	MIL-STD-167	

For additional information see Bulletin No. 692, "Guidelines for Marine Designers". "Application Instructions".

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