

PRODUCT DESCRIPTION

CWC 604 Machine Bond is a three-component, 100% solids, epoxy resin grout specifically formulated for grouting heavy machinery, engines and production equipment. It is designed to resist vibration, chemical attack, high torque loads and the various stresses associated with such installations.

Features:

- Excellent physical properties
- Flowable, self leveling
- Low exotherm
- Deeper monolithic pours (18"+)
- Extended placement time
- Easy water clean-up

BASIC USES

- Heavy machinery
- Compressors and engines
- Production equipment
- Auxiliary equipment

INSTALLATION METHOD

Pour in place, self-leveling.

PACKAGE AND YIELD

A unit of CWC 604 Machine Bond consists of three components: Two liquids (Part A resin, Part B - hardener) and an aggregate (Part C). Parts A and B are packaged in a two-component five gallon pail and Part C is packaged in four 60 pound bags.

Yield1.7 cubic feet (0.048 cubic meters)

Shipping weight284 pounds (129 kilograms)

Freight ClassificationAcid Proof Cement

SURFACE PREPARATION

All surfaces to be bonded must be dry, sound and free from any contamination of foreign matter. Concrete surfaces should be prepared by mechanical abrasion such as chipping, bush hammering, sand blasting or similar methods. A rough surface will aid adhesion. Sandblasting is recommended in preparing metal surfaces.

FORMING

CWC 604 Machine Bond is a "flowing" grout and must be retained within forms until cured. Forms must be of adequate strength, properly braced and sealed watertight against leakage. Forms must be coated with a suitable release agent, such as paste wax, to permit their removal after the grout has cured. Forms should allow for hydraulic head as needed to facilitate the filling of the grout bed area.



TECHNICAL INFORMATION

COMPRESSIVE STRENGTH:	16,100 psi
COMPRESSIVE MODULUS OF ELASTICITY:	3.8 x 10 ⁶ psi
TENSILE STRENGTH:	3,065 psi
TENSILE MODULUS OF ELASTICITY (ASTM D638):	3.4 x 10 ⁶ psi
FLEXURAL STRENGTH:	7,880 psi
FLEXURAL MODULUS OF ELASTICITY:	2.0 x 10 ⁶ psi
BOND STRENGTH (ASTM C882):	2,520 psi
SHEAR STRENGTH (ASTM D732):	3,910 psi
COEFFICIENT OF LINEAR THERMAL EXPANSION (ASTM D732):	16.0 x 10 ⁶ in/in°F 28.8 x 10 ⁶ mm/mm/°C
HARDNESS, SHORE D (ASTM C2240):	93
SPECIFIC GRAVITY:	1.89
POT LIFE:	3.5 hours @ 75°F Samples cured and tested at 75°F, 14 days.
STORAGE CONDITIONS:	Store dry at 55°F - 95°F, condition to 75°F - 90°F prior to applying.
VISCOSITY:	Slurry consistency
SHELF LIFE:	1 year
PRECAUTION:	<u>Caution:</u> Eye and skin irritant (evidenced by itching, redness). Potential skin sensitizer. Avoid contact with eyes. Avoid prolonged or repeated skin contact. Do not take internally. Wash thoroughly after handling. <u>First Aid:</u> Eyes - flush with water for 15 minutes. get immediate medical attention. Skin - remove contaminated clothing and excess contaminant, wash skin with soap and water. Inhalation - remove to fresh air. Ingestion - get immediate medical attention. See Material Safety Data Sheet for more complete information.

PROPER TOOLS, SUPPLIES AND ACCESSORIES

All material and equipment for mixing, placing and clean-up should be on hand before any mixing is started. The use of a simple checklist is recommended for use by personnel involved in a CWC 604 Machine Bond installation. This list should include: rubber gloves, safety glasses, particle masks, protective clothing, electric or air drill and paddle attachment, concrete or mortar mixer and cleaning solvent. For a detailed material checklist consult our brochure "CWC 604 Machine Bond Epoxy Resin Grout; Specifications for Installation".

MIXING AND PLACING

Strict adherence to instructions printed on the container is essential. Resin and curing agent must be thoroughly mixed prior to adding the aggregate. Consult our brochure "CWC 604 Machine Bond Epoxy Resin Grout; Specifications for Installation" for detailed instructions.

All surface preparation and forming must be done before mixing procedures are started.

TEMPERATURE FACTORS AFFECTING GROUTING

The temperature of all components of CWC 604 Machine Bond, Parts A, B, and C, should be 75°F - 90°F (23.8°C -32.2°C) before mixing to produce a readily self-leveling grout with good flowability. Mixing grout materials when their temperatures are below or at the low end of the indicated ranges adversely affects proper mixing and inhibits the flowability of the grout. Mixing grout materials when their temperatures are above or at the high end of the indicted ranges hastens the cure of the grout thus reducing the "working time". The grout materials should be stored at a temperature within the ranges indicated. Work area and substrate temperatures should also be within the recommended temperature range.

General: Every reasonable effort is made to insure the technical information and recommendations on these data pages are true and accurate to the best of our knowledge at the date of issuance and are subject to change without notice. Products and information are intended for use by qualified applicators that have the required background, technical knowledge, and equipment to perform said tasks in a satisfactory manner.

Warranty: ITW Resin Technologies, a division of Illinois Tool Works Inc., warrants that its products meet their printed specifications. This is the sole warranty. This warranty expires one year after the shipment.

Warranty Claims: If any product fails to meet the above, ITW Resin Technologies will, at its option, either replace the product or refund the purchase price. ITW Resin Technologies will have no other liability for breach of warranty, negligence or otherwise. All warranty claims must be made in writing within one year of date of shipment. No other claims will be considered.

Disclaimer: ITW Resin Technologies makes no other warranty, express or implied, and specifically disclaims any warranty of merchantability or fitness for a particular purpose. Suggestions concerning use of products are not warranties. The purchaser assumes

the responsibility for determining suitability of products and appropriate use. ITW Resin Technologies' sole liability, for breach of warranty, negligence or otherwise, shall be replacement of product or refund of the purchase price, at ITW Resin Technologies' election. Under no circumstances shall ITW Resin Technologies be liable for any indirect, incidental or consequential damages, even if advised of the possibility of such damages.

Modification of Warranty: No distributor or sales representative has the authority to change the above provisions. No change in the above provisions will be valid unless in writing and signed by an officer or the Technical Director of ITW Resin Technologies. No term of any purchase order shall serve to modify any provision of this document.

Mediation and Arbitration: If any dispute arises relating to products or product warranties, either the purchaser or ITW Resin Technologies may a) initiate mediation under the then current Center for Public Resources ("CPR") Model Procedure for Mediation of Business Disputes, or b) initiate non-binding arbitration under the rules of the American Arbitration Association for the resolution of commercial disputes.