

Bulletin 656G

Product Description

CHOCKFAST Gray (PR-610FR) is a specially formulated 100% solids, two component, inert filled casting compound developed for use as a chocking or grouting material. The compound is designed to withstand severe marine and industrial environments involving a high degree of both physical and thermal shock. The compound is non-shrinking, non-burning and has a very high impact and compressive strength. Years of successful experience have shown the use of PR-610FR to be a far superior yet less expensive method of establishing and retaining precise equipment alignment under extreme conditions. When poured as a continuous chock under deck equipment, CHOCKFAST Gray provides a corrosion proof moisture seal. PR-610FR is approved or accepted for marine use by A.B.S., Coast Guard, Lloyd's Register and other regulatory agencies.

Use & Benefits

CHOCKFAST GRAY was developed as a chocking or grouting compound for use under marine deck machinery, pumps, generators and steering gears. Industrially, the compound is used under diesel engines, generators, compressors, pumps, turbines, bearing blocks, crane rails and numerous other applications.

When used as a grouting compound for machinery, the CHOCKFAST Gray provides perfectly even support without the tedious hand packing associated with conventional cement grouts. Because the compound flows readily, much thinner cross sections can be used. The compound is also completely chemical and oil resistant, will not powder or crack with age, weathering, or freeze-thaw cycling, and will seal the mounting surfaces protecting them from deterioration. Steel soleplates and rails between the machinery and the concrete foundations are not necessary with CHOCKFAST Gray.

Other successful applications of CHOCKFAST GRAY include mounting of crane rails, chocking of crane bull gears, chocking and grouting of precision milling machinery and sealing of cable penetrations.

Design Considerations

CHOCKFAST Gray may be used where equipment alignment does NOT have to be maintained precisely AND the equipments normal operating temperature is below 52°C (125°F). Examples of this class of machinery include winches, pumps, skid mounted diesel generators and other self-contained equipment. CHOCKFAST Gray works best when poured at a depth of between 12 mm and 50 mm (½" to 2"). Please consult your CHOCKFAST distributor or ITW Philadelphia Resins if you need to pour CHOCKFAST Gray outside of these limits.

Application Instructions

CHOCKFAST Gray requires no special tools or special skills as does chocking with steel. When cast, CHOCKFAST GRAY flows readily into chock area filling all voids and conforming to all irregularities. This eliminates the machining of base plates or foundations for a perfectly fitted chock. Please consult Technical Bulletin 692 General Guidelines for Marine Designers for details regarding the installation of CHOCKFAST Gray.

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File No. A3790



ITW Performance Polymers Europe
ISO 9001:2000
Q 05420

Physical Properties

COMPRESSIVE STRENGTH:	1,125 kg/cm ² (16,000 psi)	ASTM C-695
COMPRESSIVE MODULUS OF ELASTICITY:	36,568 kg/cm ² (520,000 psi)	ASTM C-695
LINEAR SHRINKAGE:	0.0003 mm/mm (0.0003 in/in)	ASTM D-2566
COEFFICIENT OF LINEAR THERMAL EXPANSION:	30.3 x 10 ⁻⁶ /C° @ 0°C to 60°C (16.8 x 10 ⁻⁶ /F° @ 32°F to 140°F)	ASTM D-696
FLEXURAL STRENGTH:		ASTM C-582
FLEXURAL MODULUS OF ELASTICITY:		ASTM C-582
TENSILE STRENGTH:	281 kg/cm ² (4,000 psi)	ASTM D-638
IZOD IMPACT STRENGTH:	0.32 Newton m/cm (7.2 in.lbs./in.)	ASTM D-256
FIRE RESISTANCE:	Self-extinguishing	ASTM D-635
SHOCK RESISTANCE:	Pass MIL-S-901C (Navy) High Impact Shock Test, Grade A, Type A, Class 1	
VIBRATION RESISTANCE:	Pass 33 cps @ 0.51mm (0.02 in.) amplitude Total cycles 237,600	
THERMAL SHOCK RESISTANCE:	Pass -6.5°C to +93°C (20°F to 200°F)	
CORROSION RESISTANCE:	Pass FTM 151A @ 96 hrs. 0.5% NaCl 35°C (96°F) Fog	
SPECIFIC GRAVITY:	1.82	
HARDNESS:	35-40	ASTM D-2583

Product Information

UNIT PACKAGING:	Small Can Large Pail
UNIT WEIGHT:	Small Can – 5 kg (11 lb.) Large Pail – 21.7 kg (48 lb.)
UNIT COVERAGE:	Small Can - 3.06 liters (187 cu.in.) Large Pail - 13.37 liters (816 cu.in.)
CURE TIME (approximate):	18 hrs. @ 30°C (85°F) 24 hrs. @ 18°C (65°F)
POT LIFE:	30-40 mins. @ 21°C (70°F)
SHELF LIFE:	18 MONTHS
CLEAN UP:	PRT-59 Solvent or equal

Reference For design considerations and application details please request Bulletin No. 692 or contact ITW Philadelphia Resins' Engineering Services Department.

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