TECHNICAL BULLETIN

CHOCKFAST® Orange

the Premier Grouting Compound

Bulletin # 659F

Product 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.

Use & Benefits

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.

Design Considerations

For design considerations and application details please request Bulletin No. 692 for Marine and 642 for Industrial applications or contact ITW Philadelphia Resins' Engineering Services Department.

Application Instructions

ITW PHILADELPHIA RESINS
130 Commerce Drive • Montgomeryville, PA 18936 • 215-855-8450 • Fax 215-855-4688

Physical Properties

COMPRESSIVE STRENGTH:	1,336 kg/cm^2 (19,000 psi)	ASTM D-695 (Modified)
COMPRESSIVE MODULUS OF ELASTICITY:	37,482 kg/cm^2 (533,000 psi)	ASTM D-695
LINEAR SHRINKAGE:	0.0002 mm/mm (0.0002 in/in) or 0.02%	ASTM D-2566
COEFFICIENT OF LINEAR THERMAL EXPANSION:	30.8 x 10^{-6}/C° @ 0°C to 60°C (17.1 x 10^{-6}/F° @ 32°F to 140°F)	ASTM D-696
FLEXURAL STRENGTH:	575 kg/cm^2 (7,615 psi)	ASTM C-580
FLEXURAL MODULUS OF ELASTICITY:	72,880 kg/cm2 (8.6 x 105 psi)	ASTM C-580
TENSILE STRENGTH:	349 kg/cm2 (4,970 psi)	ASTM D-638
SHEAR STRENGTH:	380 kg/cm2 (5,400 psi)	FED-STD-406 (Method 1041)
IZOD IMPACT STRENGTH:		ASTM D-258
SHOCK RESISTANCE:	Pass MIL-S-901C (Navy) High Impact Shock Test, Grade A, Type A, Class 1	
THERMAL SHOCK:	Pass -18°C to 100°C (0°F to 212°F)	ASTM D-746
VIBRATION:	Meets MIL-STD-167	
FIRE RESISTANCE:	Self extinguishing	ASTM D-635
SPECIFIC GRAVITY:	1.58	
BARCOL HARDNESS:	40+ fully cured 35 minimum	ASTM D-2583

Product Information

UNIT PACKAGING:	Small Can Large Can
UNIT WEIGHT:	3.4 kg (7.5 lbs.) 6.8 kg (15 lbs.)
UNIT COVERAGE:	1,966 cc (120 cu.in) 4,261 cc (260 cu.in)
APPLICATION TEMPERATURE:	
CURE TIME (approximate):	48 hours @ 15°C (60°F) 36 hours @ 18°C (65°F) 24 hours @ 21°C (70°F) 18 hours @ 26°C (80°F)
POT LIFE:	30 min. @ 21°C (70°F)
SHELF LIFE:	2 years
CLEAN UP:	PRT-59 or similar epoxy solvent

Date 04/2004