

Technical Bulletin # 615E

### Bulletin Description

This bulletin promotes the use of CHOCKFAST® Red or ESCOWELD 7505E/7530 as a grout for setting large anchor bolts in large, deep anchor bolt pockets. Typical 2-part epoxy chocking compounds CHOCKFAST Gray, while good for use in smaller holes, should not be used in such cases because the exothermic heat created by their large mass may crack the epoxy.

Deep anchor bolt pockets - up to 2 meters (6 ft) long and 200mm (8") wide - may be filled conveniently with a single placement of CHOCKFAST® Red or ESCOWELD 7505E/7530.

The gentle exotherm of CHOCK-FAST® Red and ESCOWELD 7505E/7530 allows grout placement around large bolts to be executed with a single pour in extremely hot and humid climates with negligible shrinkage.

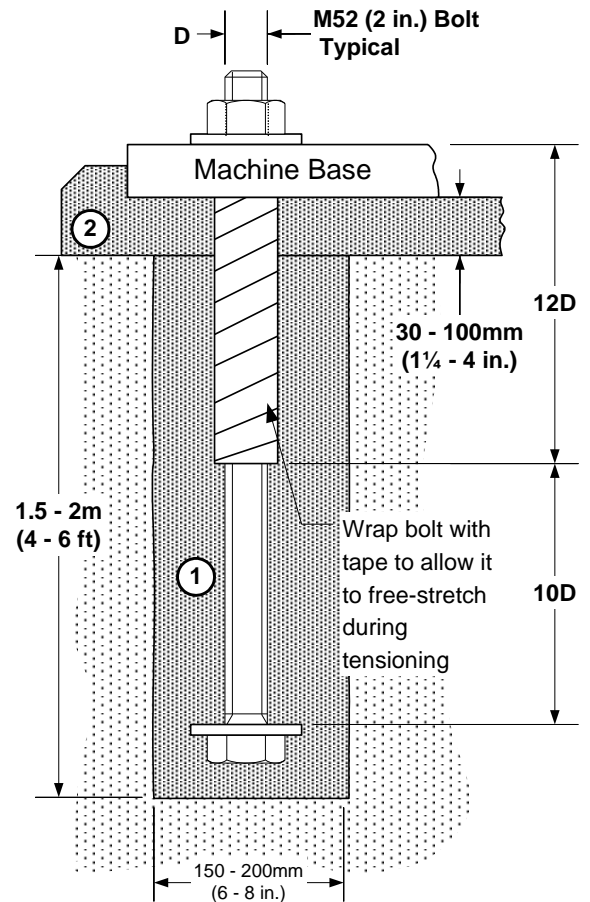
### Design Considerations

Most process machinery is critically aligned within hundredths of a millimeter tolerance. Therefore, final horizontal leveling pours in contact with critically aligned baseplates, rails, soleplates or coupled machinery should be limited to a depth of 100mm (4").

Two separate grout pours are required:

- ① The first pour in the Anchor Bolt Pocket filled is made using CHOCKFAST® Red or ESCOWELD 7505E/7530
- ② The Final Leveling Pour under the critically aligned machinery is then made using CHOCKFAST® RED or ESCOWELD 7505E/7530

**Date** June 2018



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