

Technical Bulletin # 619A

Bulletin Description

CHOCKFAST and ESCOWELD grouts are specifically formulated for use where concrete and steel foundation temperatures at the time of application are within a range of 55° to 95° F (13° to 35° C). Should temperatures be below 55° F the following procedures should be followed.

Grout Storage

All grout materials shall be stored in a dry and weatherproof area prior to grouting. Under no circumstances should grouting materials be stored outside or in an area that cannot be heated to 55° F or above. For optimum handling characteristics, all materials (particularly aggregate portion) shall be adjusted to a temperature of 55° F to 80° F 48 hours prior to grouting. Aggregate bags shall be unstacked to allow for equal heating.

Preparation

The work area, including foundation and machinery, shall be preconditioned to a temperature above 55°F for 24 hours prior to grouting. This can best be accomplished by constructing a temporary structure around the work area with a suitable covering such as canvas or plastic sheet. The temperature of the concrete foundation and steel machinery shall be a minimum of 55°F prior to grouting.

Cure Time

The work area, including foundation and machinery, shall be held at a minimum of 55° F for 48 hours after placement of the grout. Heating sources (lamps, steam or gas heaters, etc.) shall not be positioned so as to create hot spots (localized heating) on the grout.

The following cure times are approximate and are dependent on the temperatures listed below remaining constant for the required amount of cure time.

<u>CHOCKFAST RED or ESCOWELD 7505E/7530</u>	<u>CHOCKFAST RED SG</u>
96 hours @ 50°F (10°C)	60 hours @ 50°F (10°C)
72 hours @ 55°F (13°C)	48 hours @ 55°F (13°C)
54 hours @ 60°F (16°C)	36 hours @ 60°F (16°C)
36 hours @ 72°F (21°C)	24 hours @ 72°F (21°C)
24 hours @ 80°F (27°C)	18 hours @ 80°F (27°C)
18 hours @ 90°F (32°C)	12 hours @ 90°F (32°C)

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