

EPOCAST INDUSTRIE processing instructions

1. PREPARATION

- 1.1 Adjust machine part to manufacturers instructions. Please take into consideration that after adjusting the chocks may compress 0,001 times the chock height when the holding down bolts are tightened.
- 1.2 Clean the foundation and bedplate surfaces where chocks are to be poured. Remove all grease, oil, rust, paint, loose concrete layers and other dirt. A epoxy based priming is allowed. Coats of paint have to be removed.
- 1.3 Flexible damming is inserted between the bedplate and foundation to form liquid tight sides for the moulds or dams. Make sure the damming is firmly in place, and cannot collapse or leak.
- 1.4 If set screws are used for adjusting of the machine parts these have to be protected from EPOCAST INDUSTRIE (after adjusting) by sleeving with Silicon putty or rubber tube so they can be taken off without problems after hardening of chocks.
- 1.5 Closing of holes in the foundation with closed cell rubber tube to avoid running out of resin.
- 1.6 Fitting of front damming plate (metal thickness 3 – 6 mm) so the pouring opening is 20 – 30 mm. The top of the damming plate should be 40 – 60 mm above the planned chock height to take the overpour.
- 1.7 Sealing of damming plates with Silikon putty to avoid running out of resin.
- 1.8 Spray the space between machine and foundation base with Silikon spray. If the foundation of the installation should lay on concrete, the concrete has to be protected from Silikon spray.
- 1.9 Before pouring check the adjusting and take down the results.

2 MIXING / POURING / ANCHOR BOLT TIGHTENING TORQUE

- 2.1 Possibly warm up the resin component on max. 30°C. Before adding of hardener component it should be guaranteed that the warm up temperature of resin in the tin occurred consistently. If necessary mix the resin component without hardener before. While mixing keep care that no air bubbles get locked into the system (see point 2.2.). Afterwards add hardener. We recommend „Jiffy“– Mixer for good results.
- 2.2 Put the delivered mixing blade in a drill. Ensure that the EPOCAST resin tin stands fixed on the ground and can't twist during the mixing procedure. Feed the switched off mixer into the tin and then mix both components for 2-3 minutes at about 500 rpm, until the compound looks well and is free from air bubbles.
- 2.3 Straightaway after mixing fill the compound slowly and if possible from the deepest point in the prepared chocking area to get de-aeration. Ensure no break in pouring of one chock to avoid layer pouring or trapped air.
- 2.4 The curing time of EPOCAST INDUSTRIE at 13°C machine and ambient temperature is

48 hours, but can be reduced by external post heating of EPOCAST chocks
(min. curing time: 24 hours at 20°C).

- 2.5 Correct curing of EPOCAST INDUSTRIE can be proved with a Barcol hardness tester at every chock. We recommend 40 Barcol (equivalent to 25 Brinell). After achievement of this hardness grade adjusting screws can be removed.
- 2.6 Take rubber tube out off the bore holes and tighten anchor bolts.
- 2.7 Tighten anchor bolts according to calculation for cast resin bearing.