



CHOCKFAST® GRAY – TWO-COMPONENT EPOXY CHOCKING COMPOUND

REVISED: 10/2023

TECHNICAL DATA SHEET #656

VERSION: K

PRODUCT DESCRIPTION

CHOCKFAST Gray (PR-610FR) is a specially formulated 100% solids, two component, inert filled compound developed for use in chocking non-precisely aligned equipment or in setting anchor bolts in concrete. 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 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. and the United States Coast Guard, as well as other regulatory agencies.

USE & BENEFITS

CHOCKFAST GRAY was developed as a chocking 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. It is also used extensively in the setting of anchor bolts into concrete.

When used as a chocking 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 provides

superior chemical and oil resistance, 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 of machine shop machinery, sealing of cable penetrations, and as a filler to dampen machinery vibrations. CHOCKFAST Gray, like our other 2 component chocking compounds CHOCKFAST Orange and CHOCKFAST Black, are dammed, mixed and poured exactly the same way. Refer to Technical Guides 612 and 694 for additional information on damming, mixing and pouring.

DESIGN CONSIDERATIONS

CHOCKFAST Gray may be used where equipment alignment does NOT have to be maintained precisely AND the equipment's normal operating temperature is below 125°F (52°C). 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 ½" to 2" (12 mm to 50 mm). The maximum suggested static load on CHOCKFAST Gray is 800 psi (5.5 MPa). Static load consists of total bolt tension and machine weight. Please refer to Technical Guide 692 for further recommendations and guidance on evaluating static load.

Please contact your local representative of our Worldwide Distributor Network or ITW Performance Polymers if you need to pour CHOCKFAST Gray outside of these limits.

APPLICATION INSTRUCTIONS

Please refer to the appropriate safety data sheet (SDS) prior to using this product.

CHOCKFAST Gray requires no special tools or special skills as does chocking with steel. When cast, CHOCKFAST GRAY flows readily into the chock area, filling all voids and conforming to all irregularities. This eliminates the need to machine base plates or foundations for a perfectly fitted chock.

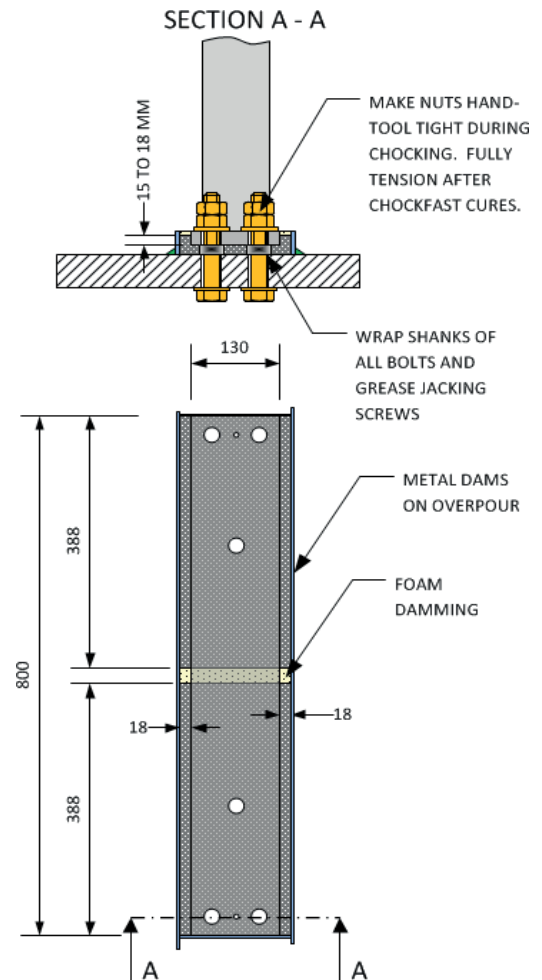
To facilitate mixing and pouring, pre-condition CHOCKFAST Gray such that it is within an ideal temperature of 68° to 77°F (20° to 25°C) at least 24 hours prior to intending to mix and install. Pour the entire contents of the hardener container into the resin container and power mix using a Jiffy Mixing blade at 250 to 450 RPM for 3 to 4 minutes. Make sure to mix the side and bottom of the container with the mixing blade. Do not allow air to be drawn into the mixture.

Precondition the surrounding metal and/or concrete surfaces to at least 55°F (13°C). Pour the mixed CHOCKFAST Gray into the overpour area of one end of a prepared mold. Allow the epoxy to flow under the mounting foot, pushing the air out ahead of it. Fill the overpour to at least 1/2" (12mm) above the mounting foot at the highest point in the chock.

NOTE - Do not scrape epoxy from the sides or bottom of the container when pouring.

STORAGE RECOMMENDATIONS

All product components should be stored in a dry, shaded area in original unopened containers and within a temperature range of 65°- 95°F (16° - 35°C). For additional information, please refer to Technical Guide 1024.



PHYSICAL PROPERTIES

COMPRESSIVE STRENGTH	16,000 psi (110.3 MPa)	ASTM D695 MOD*
COMPRESSIVE MODULUS OF ELASTICITY	520,000 psi (3585.3 MPa)	ASTM D695 MOD*
LINEAR SHRINKAGE	0.0003 in/in (0.0003 mm/mm)	ASTM D2566
COEFFICIENT OF LINEAR THERMAL EXPANSION	16.8 x 10 ⁻⁶ /°F @ 32°F to 140°F (30.3 x 10 ⁻⁶ /°C @ 0°C to 60°C)	ASTM D696
TENSILE STRENGTH	4,000 psi (27.6 MPa)	ASTM D638
IZOD IMPACT STRENGTH	7.2 in.lbs./in. (0.32 N-m/cm)	ASTM D256
FIRE RESISTANCE	Self-extinguishing	ASTM D635
VIBRATION RESISTANCE	Pass 33 cps @ 0.02 in. (0.51mm) amplitude	
THERMAL SHOCK RESISTANCE	Pass 20°F to 200°F (- 6.5°C to + 93°C)	
CORROSION RESISTANCE	Pass FTM 151A @ 96 hrs. 0.5% NaCl 96°F (35°C) Fog	
SPECIFIC GRAVITY	1.82	
HARDNESS	35-40	ASTM D2583

The data shown reflect typical results based on laboratory testing under controlled conditions. Variations from the above data are typical for field-prepared samples.

**Cured 24 hours at room temperature, post-cured 4 hours, and conditioned 4 hours at room temperature before evaluation.*

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PRODUCT INFORMATION

UNIT COVERAGE	SMALL UNIT -	187 in ³ (3.06 liters)	
	LARGE UNIT -	816 in ³ (13.37 liters)	
TYPICAL POUR DEPTH	½" to 2" (12 mm to 50 mm)		
TYPICAL APPLICATION TEMPERATURES	55°F to 95°F (13°C to 35°C)		
INITIAL CURE TIME (APPROXIMATE, BASED ON CONTACT SURFACE TEMPERATURES)	65°F (18°C):	24 hours	
	85°F (30°C):	18 hours	
POT LIFE (APPROXIMATE)	70°F (21°C):	30-40 mins.	
PACKAGING PER UNIT	SMALL UNIT -	RESIN (A):	0.76 gal (2.9 L) in a 1 gal can
		HARDENER (B):	9 oz (0.3 L) in 8-oz bottle
	LARGE UNIT -	RESIN (A):	3.2 gal (12 L) in a 5-gal bucket
		HARDENER (B):	40 oz (1.2 L) in a ½ gal can
COMPONENT WEIGHTS	SMALL UNIT -	RESIN (A):	12.5 lbs (5.6 kg)
		HARDENER (B):	0.55 lbs (0.25 kg)
	LARGE UNIT -	RESIN (A):	53.5 lbs (24.3 kg)
		HARDENER (B):	2.6 lbs (1.2 kg)
UNIT SHIPPING WEIGHT	SMALL UNIT -	58 lbs (26.3 kg) /case, 4 kits/case	
	LARGE UNIT -	57 lbs. (25.9 kg)	
COLOR	RESIN (A):	GRAY	
	HARDENER (B):	CLEAR TO AMBER	
	MIXED (A + B):	GRAY	
CLEAN UP	IMPAX IXT-59 Solvent or equal		
SHELF LIFE	2 years in dry storage		
CHEMICAL RESISTANCE	Refer to Technical Guide 675		

REFERENCE

For any additional recommendations or applications beyond the typical ones listed in this document, please contact your local representative of our Worldwide Distributor Network or ITW Performance Polymers for further support.

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