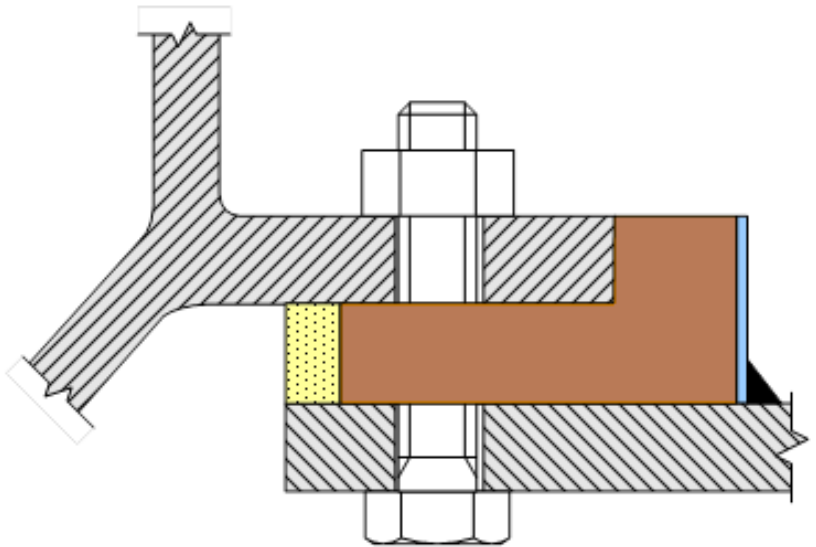


## Some Chocking Do's & Don'ts

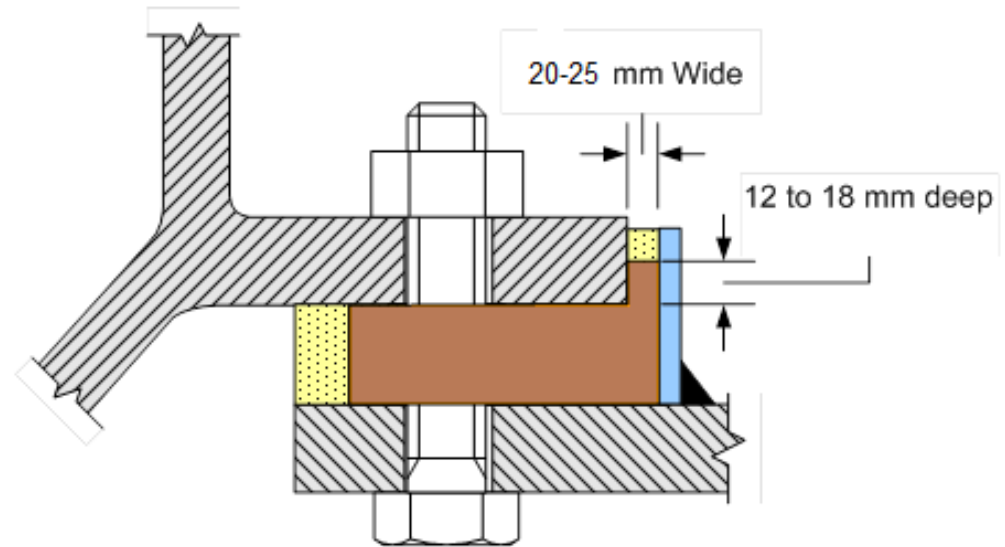
- How to be more successful

## DO NOT Make the Overpour Too Large

Don't Do This

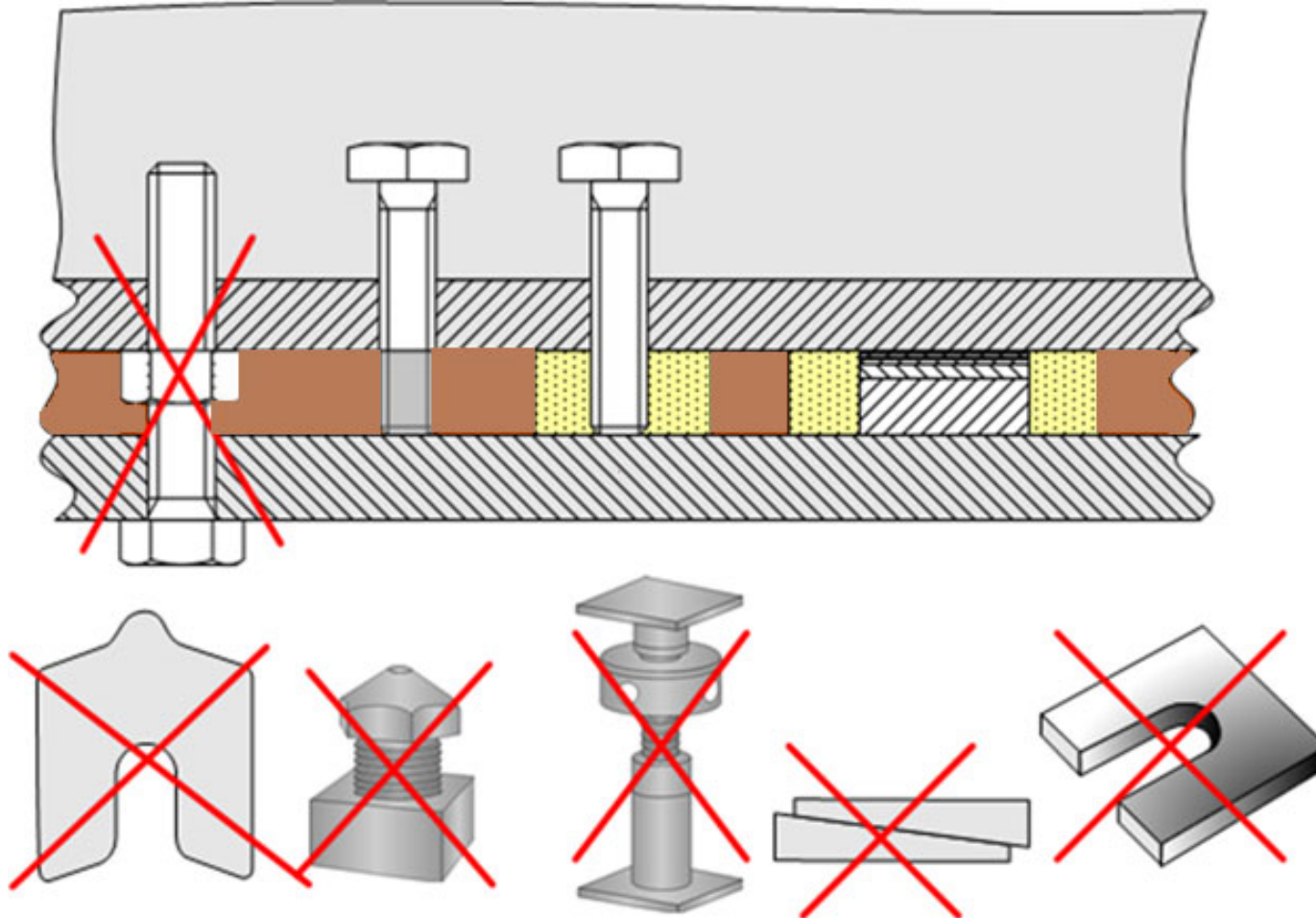


Do This

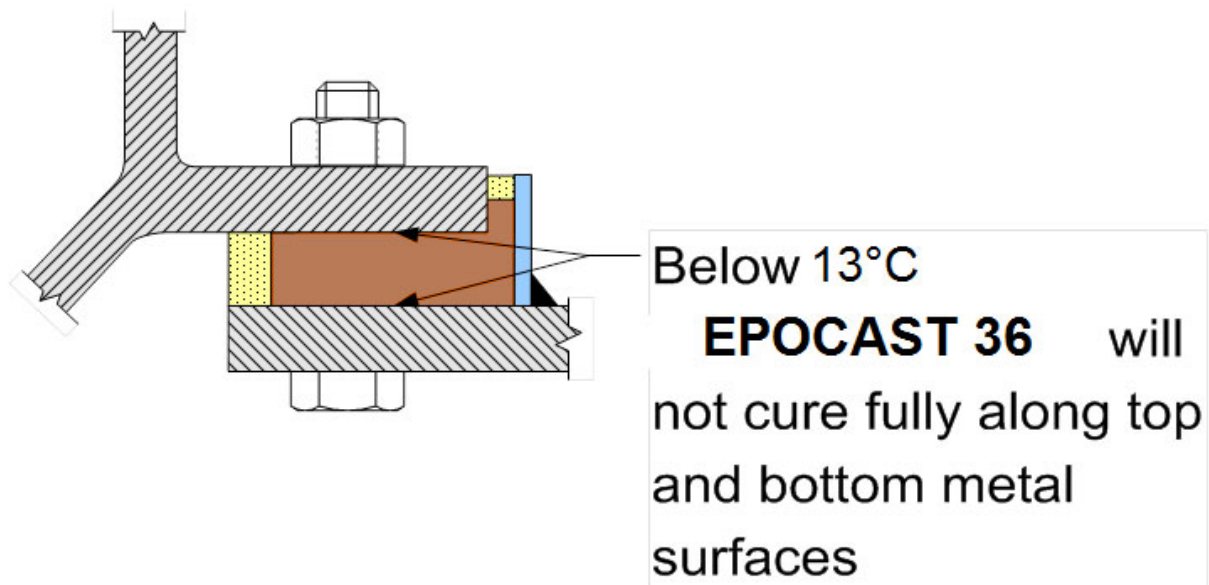


*The **EPOCAST 36®** in the overpour area must remain cool and liquid to feed material back under the engine bed if needed. To do this, the overpour must be small and kept cool with a heavy metal front dam.*

## DO Use the Right Alignment Tools

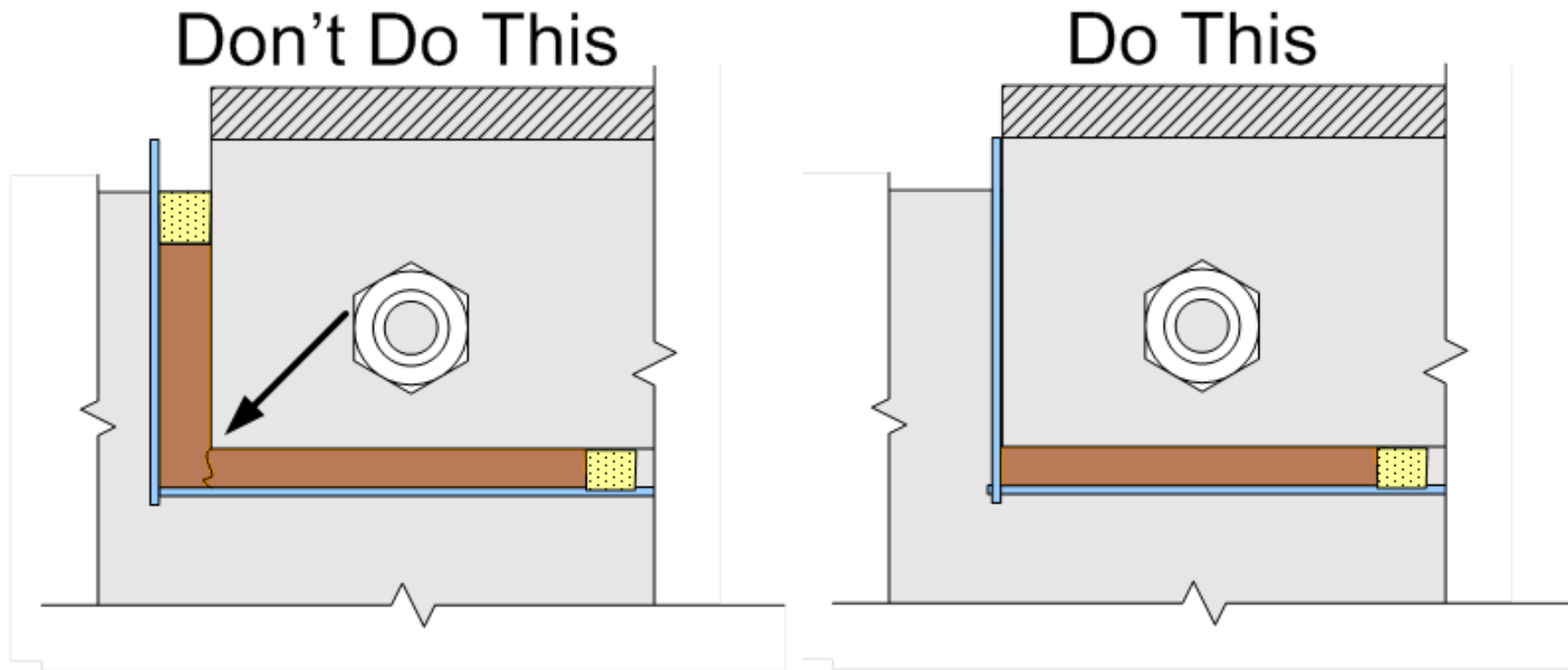


**Note - EPOCAST will not cure below 13 °C**



**EPOCAST 36®** resin can be re-awakened and will restart its curing process when its temperature reaches 13°C.

## DO NOT Chock Around a Corner

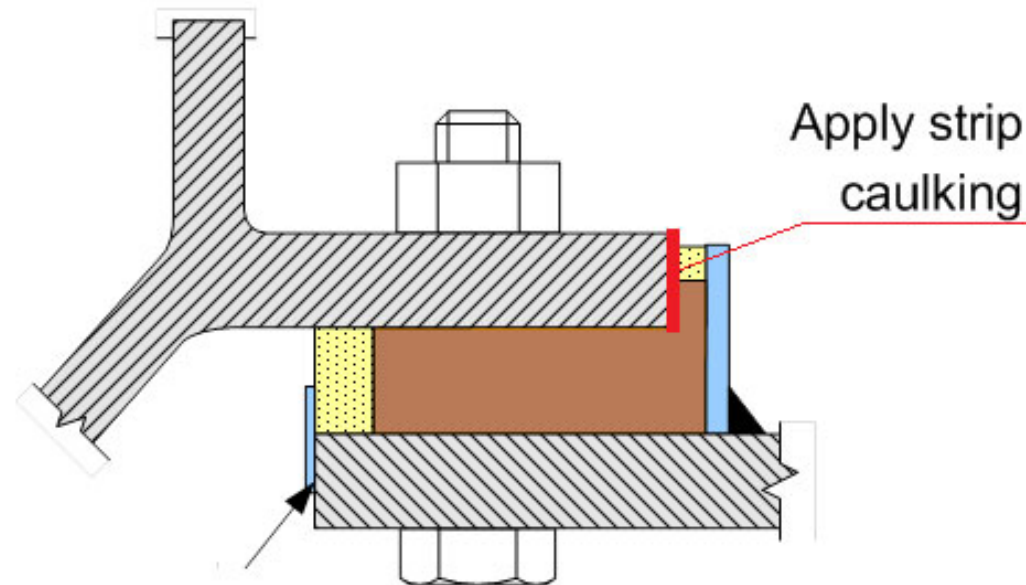


*Do NOT pour EPOCAST 36 around a corner. It will always lead to cracking because the corner acts like a wedge.*

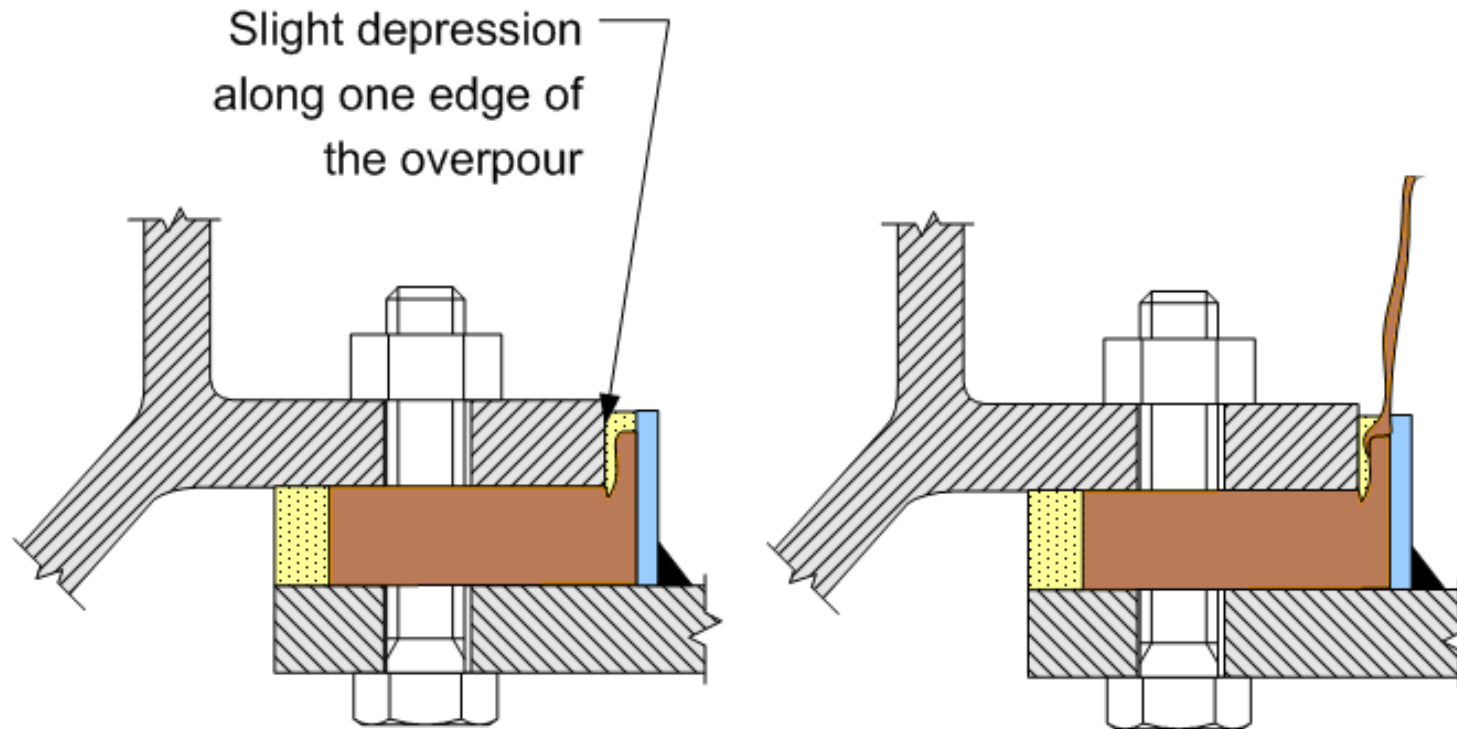
## Round up sharp edges

*Use self adhesive tape ~3mm thick on vertical side of overpour in case of: epoxy could grab too much on that surface*

- *near stoppers*
- *if 2 overpours are to be required*



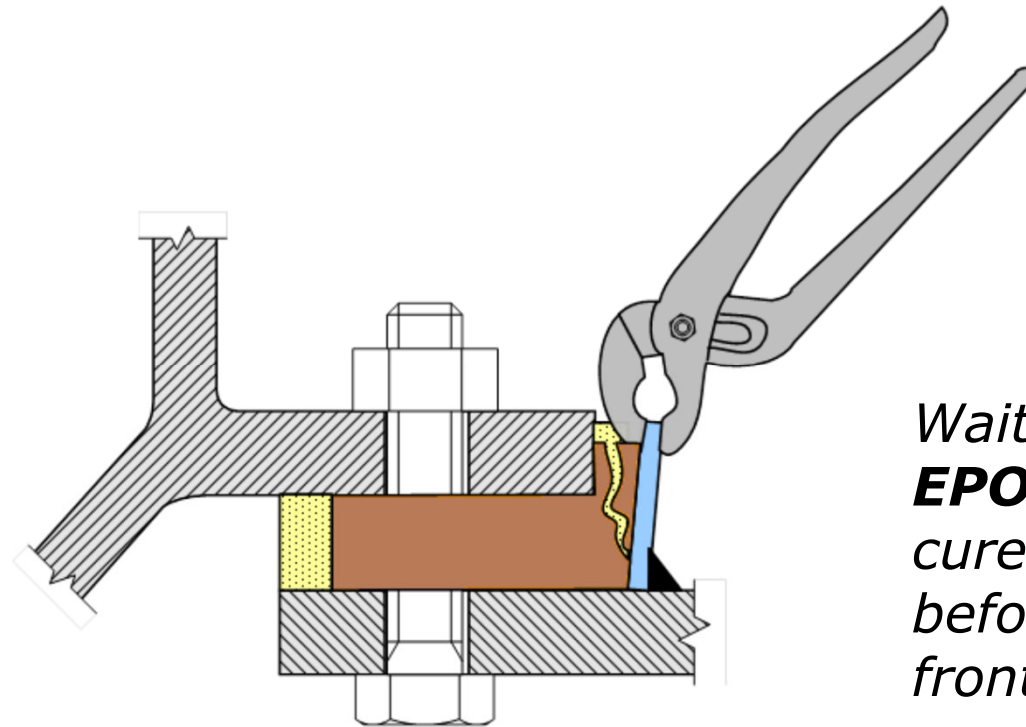
## DO Top off All Chocks



*Sometimes the inside edge of the overpour will be drawn down slightly. Do not be concerned about this. Just top off the overpour area with some more **EPOCAST 36®**.*



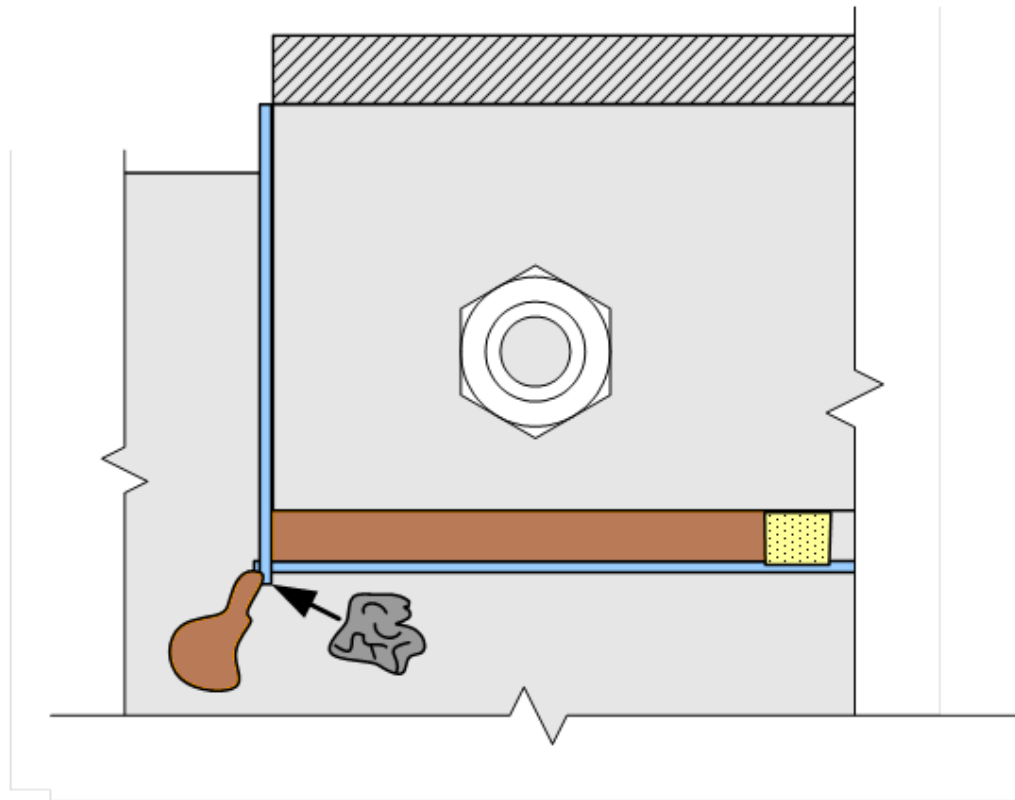
## DO NOT Remove the Dams Until EPOCAST 36® is Fully Cured



*Wait until the  
**EPOCAST 36®** has  
cured completely  
before removing the  
front metal dam or  
you could break the  
chock.*



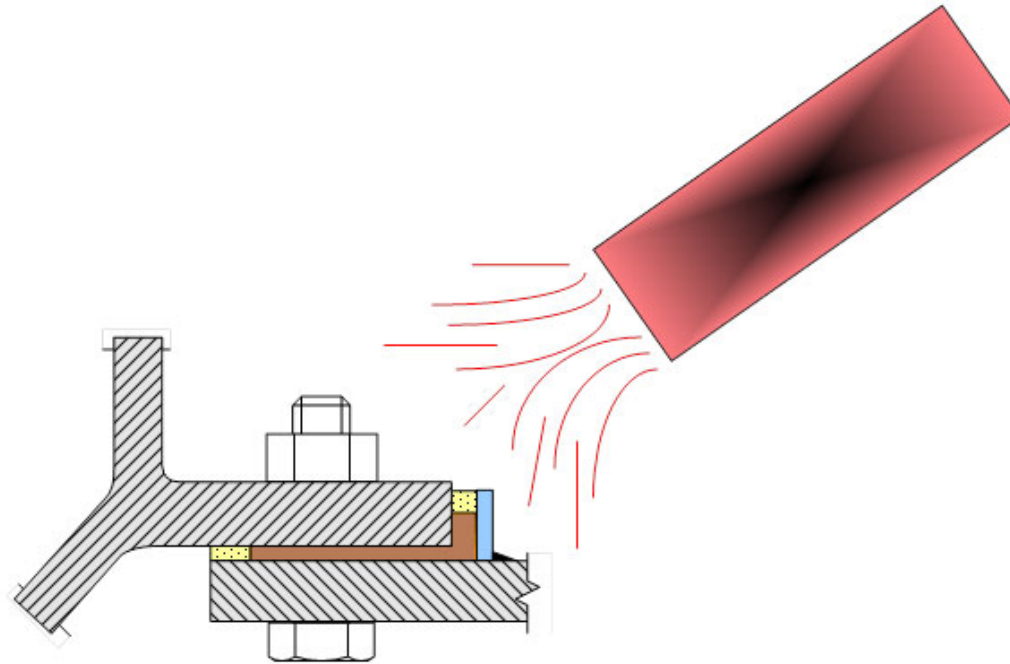
## DO Prepare for Leaks



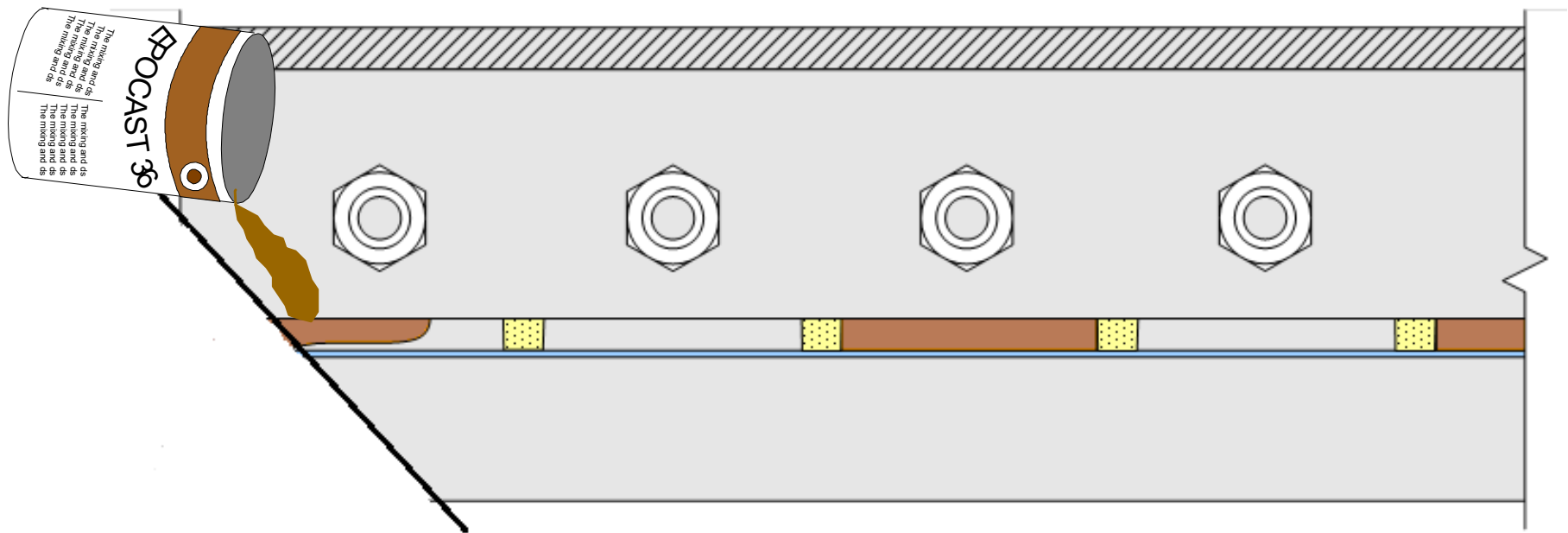
*Have non-hardening putty on hand for sealing small leaks that may appear.*

*It is also a good idea to spray all areas adjacent to a chock with Release Agent to make clean up easier.*

**DO NOT Add Heat to A Chock Until the  
EPOCAST 36® Has Gelled**

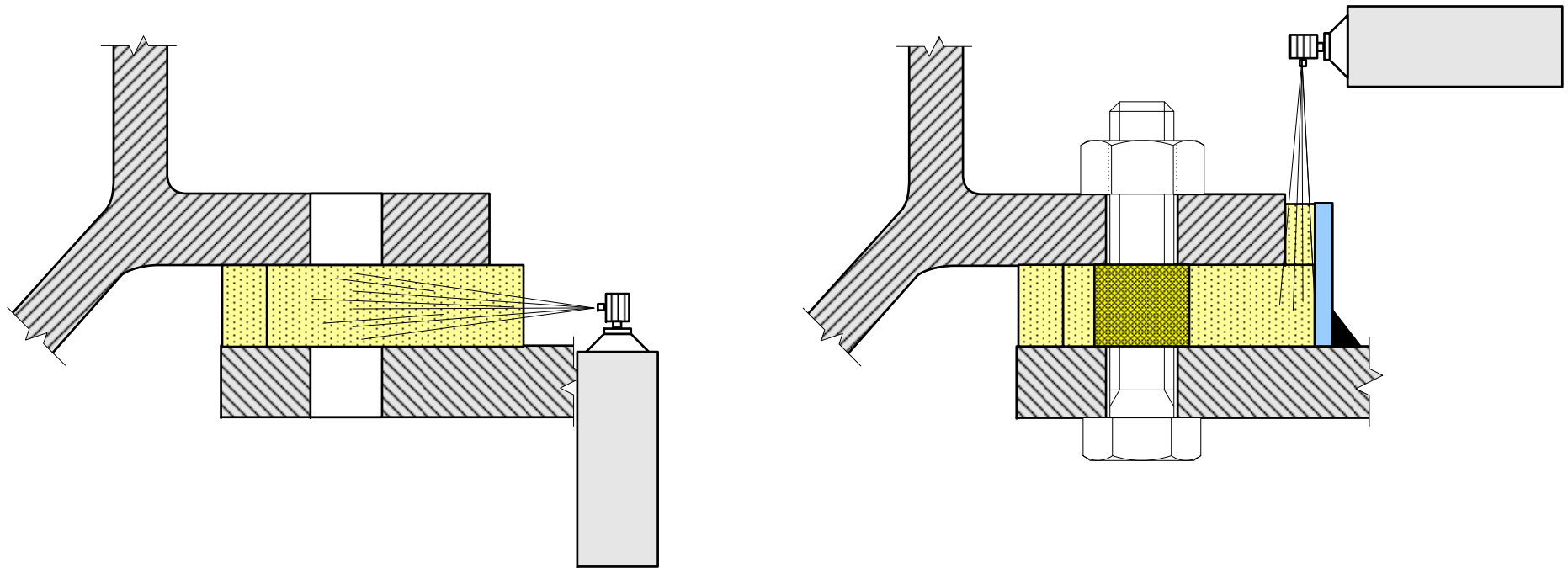


## DO Pour Alternate Chocks



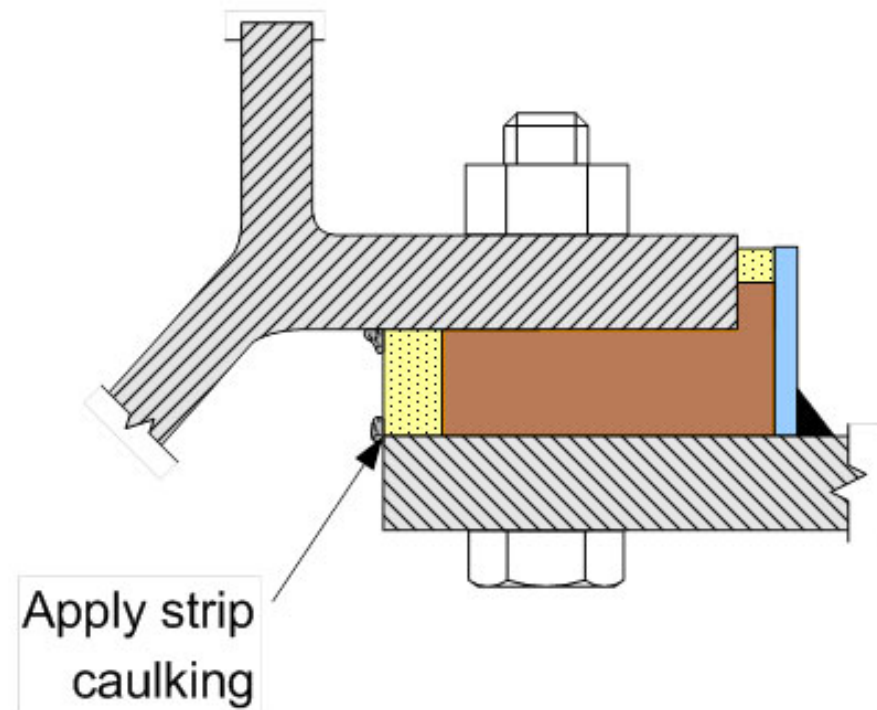
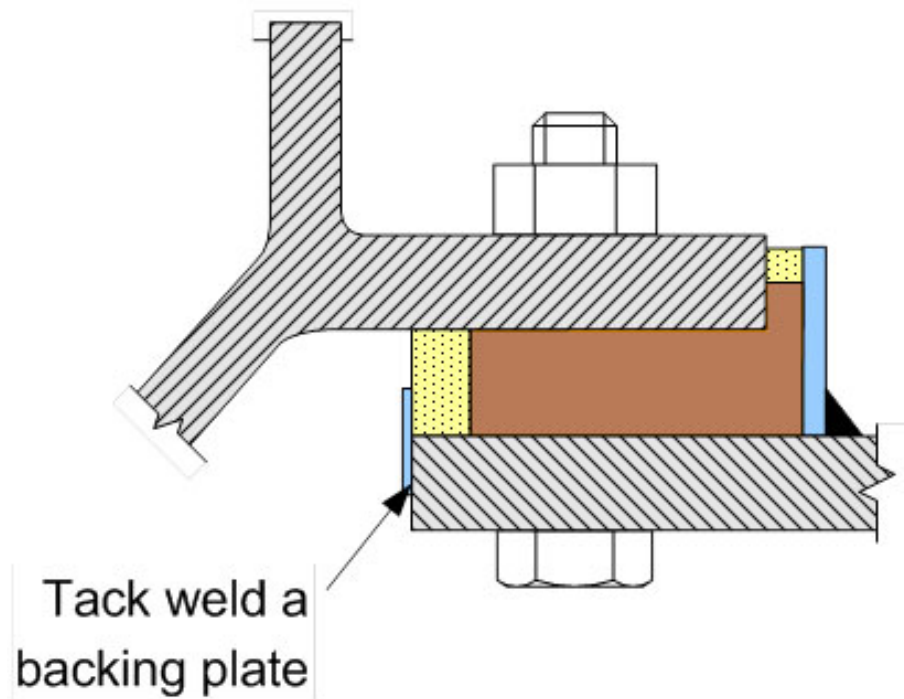
*If overheating the **EPOCAST 36®** is a concern, fill every other chock, wait until they are cool then fill the remainder of the chocks.*

## DO NOT Forget the Release Agent

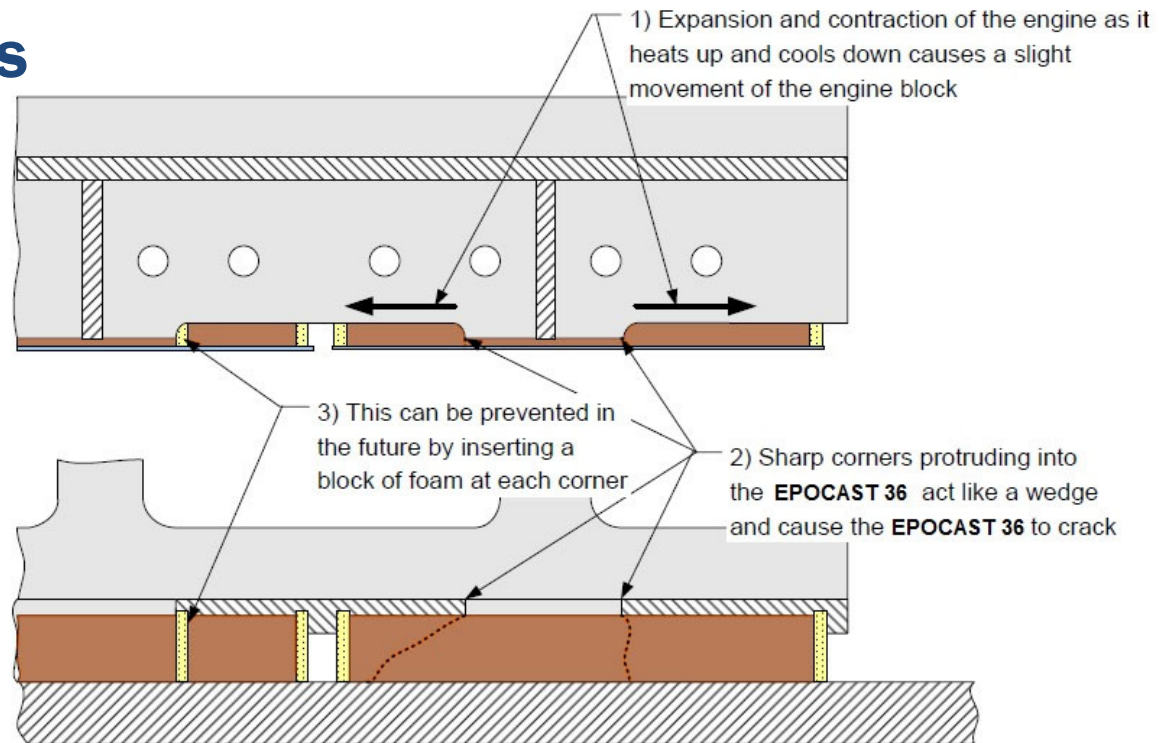


*Make sure the Release Agent is dry before pouring*

## DO Make Sure the Dams Don't Move



## Treat internal edges with foam rubber



***For large Chocks and or large chocks in summertime conditions with more than 3 units of EPOCAST 36 ® (4,0 ltrs.) inside.***

*If in doubt for large chock dimensions and high chock heights, please chose a smaller temperature down step for preheating temperature as shown on*

*- EPOCAST MARINE HANDBOOK, mixing and pouring guide item No. 2.3.2, page 19 to control the chemical exothermal reaction temperature.*



# CHOCKING WITH EPOCAST 36®



*General: Every reasonable effort is made to insure the technical information and recommendations on these data pages are true and accurate to the best of our knowledge at the date of issuance. However, this information is subject to change without notice. Prior versions of this publication are invalid with the release of this version. Products and information are intended for use by qualified applicators that have the required background, technical knowledge, and equipment to perform said tasks in a satisfactory manner. Consult your local distributor for product availability, additional product information, and technical support. Warranty: ITW Performance Polymers, a division of Illinois Tool Works Inc., warrants that its products meet their printed specifications. This is the sole warranty. This warranty expires one year after product shipment. Warranty Claims: If any product fails to meet the above, ITW Performance Polymers will, at its option, either replace the product or refund the purchase price. ITW Performance Polymers will have no other liability for breach of warranty, negligence, or otherwise. All warranty claims must be made in writing within one year of the date of shipment. No other claims will be considered. Disclaimer: ITW Performance Polymers makes no other warranty, expressed or implied, and specifically disclaims any warranty of merchantability or fitness for a particular purpose. Suggestions concerning the use of products are not warranties. The purchaser assumes the responsibility for determining suitability of products and appropriate use. ITW Performance Polymers' sole liability, for breach of warranty, negligence or otherwise, shall be the replacement of product or refund of the purchase price, at ITW Performance Polymers' election. Under no circumstances shall ITW Performance Polymers be liable for any indirect, incidental or consequential damages. Modification of Warranty: No distributor or sales representative has the authority to change the above provisions. No change in the above provisions will be valid unless in writing and signed by an officer or the Technical Director of ITW Performance Polymers. No term of any purchase order shall serve to modify any provision of this document. Mediation and Arbitration: If any dispute arises relating to products or product warranties, either the purchaser or ITW Performance Polymers may a) initiate mediation under the then current Center for Public Resources (CPR) Model Procedure for Mediation of Business Disputes, or b) initiate a non-binding arbitration under the rules of the American Arbitration Association for the resolution of commercial disputes.*

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