

Technical Bulletin # 1024E

Bulletin Description

The following CHOCKFAST surface preparation, mixing, pouring and storing procedures have been written as an aid for contractors and end users applying CHOCKFAST on a job site. If the application procedures are not adhered to it is recommended that the user contact ITW Performance Polymers or the local ITW Performance Polymers distributor for alternate methods. The nearest distributor can be located on our web page at www.chockfast.com. All procedures in this bulletin apply to CHOCKFAST RED and CHOCKFAST RED SG unless stated otherwise.

CHOCKFAST RED- fast curing, high compressive and tensile strength grout that can be applied 50mm (2 in.) to 46cm (18 in.) in thickness.

CHOCKFAST RED SG- fast curing, high compressive and tensile strength grout that can be applied 25mm (1 in.) to 100mm (4 in.) in thickness.

Grout Storage

All grout materials should be stored in a dry, shaded area in original unopened containers.

Recommended storage temperatures are 16° - 35° C (65° - 95°F).

The materials have a shelf life of 2 years.

The grouting materials should be preconditioned to a minimum of 19° - 27° C (65° - 80°F) for 24 to 48 hours before mixing and application.

Construct a shelter over the foundation to protect the work area from the elements particularly during cold, wet or very hot conditions.

Foundation Preparation

New concrete needs to be 21 to 28 days fully cured. It must also have a minimum compressive strength of 210 kg/cm² (3000 psi) and minimum tensile strength of 21 kg/cm² (300 psi). In order to insure a good bond of epoxy to the concrete, check that hydration has ceased.

The concrete should be chipped to remove all laitance and 50% of the fractured coarse aggregate exposed to provide a rough bonding surface for the epoxy. A ¾ chisel bit is the preferred tool. A bushing tool should not be used. Dowels should be installed on new exposed concrete to prevent edge lifting.

The concrete foundation should be dry and oil free before the pouring of grout.

Form as for concrete using good quality form material. Fit 30mm x 45mm (1-3/16 in. x 1-3/4 in.) chamfer pieces. Wax or grease all surfaces of forming in contact with resin. Seal all gaps with suitable mastic or putty.

Sleeve all foundation bolts in way of resin to prevent adhesion and to allow bolt stretch.

Construct head boxes if resin has to flow more than one meter (3 ft).

Preparation Of Baseplate or Soleplates

All 90 angles on steel work in contact with the epoxy should be rounded to reduce stress concentrations in the grout. Round shim stock is preferred.

Surfaces of base plates or soleplates in contact with grout should be sandblasted to a clean, oil free, dry surface. Epoxy primer can be applied to the clean metal surfaces to prevent rusting.

Mixing And Pouring

Remove lid from resin/hardener container and pour the hardener into the resin. Mix with a low speed drill and Jiffy Mixer blade for 3 minutes.

Chockfast Red should be mixed in a 15 –20 rpm mortar mixer capable of holding a minimum of 90.6 liters (3.2 cu ft).

Add the pre-mixed liquids to mortar mixer and one bag of aggregate. Progressively add the remaining bags of aggregate assuring a homogeneous mix. **Mixing is complete when aggregate is wet** (for the first mix ½ a bag of aggregate should be withheld to facilitate the “wetting out of the mixer”).

Subsequent mixes should contain 4 bags. Never reduce aggregate by more than half a bag to improve flow.

It is important to mix the grout until the 4 bags of aggregate have been “**wetted out**”. Over mixing will encourage the entrapment of air.

Pour the Chockfast Red as soon as possible after mixing. Protect newly poured Chockfast Red from sudden temperature changes and direct sunlight.

Additional layers of Chockfast can be poured providing the initial pour has returned to an ambient temperature and the surface has been roughened up to provide a mechanical bond.

Product Information

	CHOCKFAST Red	CHOCKFAST Red SG
POT LIFE	2-3 hours @ 21°C (70°F)	40 minutes @ 21°C (70°F)
CURE TIME (approximate)	54 hours @ 16°C (60°F)	
	36 hours @ 21°C (70°F)	48 hours @ 16°C (60°F)
	36 hours @ 21°C (70°F)	24 hours @ 21°C (70°F)
	18 hours @ 32°C (90°F)	

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