

Technical Bulletin # 1026A

Product Description

CHOCKFAST Orange combined with 620TS Hardener produces a low exotherm, slow curing chocking compound that can be used effectively where the higher exotherm of CHOCKFAST Orange would be a disadvantage. This is often the case on large pours around strut and stern tube bearings, rudder and pintle bearings or other similarly installed bearings. This system is intended only for applications with comparatively thick layers of resin and low heat sink capacity. It is currently only type approved by Bureau Veritas.

NOTE: This resin/hardener system is not intended for general chocking use. Its compressive strength and modulus are too low for general chocking but is fully acceptable with shaft bearing because of their light load.

Application Instructions

The CHOCKFAST Orange resin and 620TS hardener must be ordered separately. CHOCKFAST Orange resin is supplied in either 3.4 kg (7.5 lb) or 7 kg (15.4 lb.) units. The 620TS Hardener comes only in ½ gallon cans and contains 1.62 kg (3.6 lbs) of hardener. The ratio of Chockfast Orange resin to 620TS Hardener is 100:22.6 by weight.

To determine the total number of units of Chockfast Resin required divide the void area around the bearing by the volume per unit shown below. To determine the total number of hardener units required multiply the total number of Chockfast Resin units times Hardener Volume below then divide the total by 0.4541 gallons, 104.9 in³ or 1719 cc as required.

Unit	Resin Volume	Hardener Volume	Volume of Chockfast Orange Resin & 620 Hardener per Unit		
7.5 lb	0.53 gal	0.206 gal	0.736 gal	170 in ³	2785.8 cc
15 lb.	1.052 gal	0.41 gal	1.46 gal	337.3 in ³	5526.7 cc

Pour off and add the amount of hardener shown in the table below with each unit of Chockfast Orange depending on its size. Mix the resin and hardener for 3 to 4 minutes using a Jiffy mixing blade and variable speed drill turning no faster than 350 RPM. Pour or pump epoxy into place and allow to cure. As this is a slow curing system, complete cure will take a minimum of 48 hours to a maximum of 72 hours depending on total volume at 21°C (70°F).

Unit	620 Hardener Required	Volume in Cups (US)	Volume in Cups (Metric)	Volume in Liters	Volume in cc's
7.5 lb	0.206 gal / Unit of CFO	3.3	3.1	0.78	779.8
15 lb.	0.41 gal / Unit of CFO	6.56	6.2	1.55	1552

Physical Properties

COMPRESSIVE STRENGTH	87 MPa (12,619 psi)	ASTM C-581
COMPRESSIVE MODULUS OF ELASTICITY	2758 MPa (481,675 psi)	ASTM C-582
LINEAR SHRINKAGE	0.00006 in/in (0.006%)	ASTM D-2568
FLEXURAL STRENGTH	68.5 MPa (9,939 psi)	ASTM C-582
FLEXURAL MODULUS OF ELASTICITY	3082.7 MPa (447,000 psi)	ASTM C-582

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TENSILE STRENGTH	30.3 MPa (4,395 psi)
BARCOL HARDNESS	35
FIRE RESISTANCE	Self Extinguishing
SPECIFIC GRAVITY	1.48

ASTM D-640

Product Information

COVERAGE	See table above
CURE TIME (approximate)	96 hours @ 13°C (55°F) 48 hours @ 21°C (70°F) 24 hours @ 32°C (90°F)
POT LIFE	30 min. @ 21°C (70°F)
CLEAN UP	PRT-59 or similar epoxy solvent
PACKAGING per Unit	See table above
SHELF LIFE	2 years

Date 02/2014

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