

ACCU-CHOCK

Machine Base Precision Epoxy Grout

Product Description

ACCU-CHOCK is a two-component, high-performance, high early and ultimate strength epoxy machine chock for use in high bearing areas with negligible shrinkage and creep, fast cure and excellent flowability. The recommended application temperature range is between 60 °F - 95 °F (16 °C - 35 °C).

General Uses & Applications

- High stress machine base plate chock for use in heavy equipment industries such as wind farms, gas transmission, chemical processing and refineries, paper mills, steel rail and marine facilities
- New equipment installation and quick re-grouting of applications subject to chemical attack

Advantages & Features

- Designed for use in dynamic and high-impact shock loading
- Precision grouting with negligible shrinkage and creep
- High early strength
- Highest effective bearing area (over 98%)
- Low exotherm for deep pour capability
- Excellent oil and chemical resistance
- Superior flowability
- Ready to mix - pre-measured units
- Low toxicity
- Easy soap and water clean up
- Designed for dynamic and static loading
- Made in the USA

Availability: Adhesives Technology Corp. (ATC) products are available online and through select distributors serving all your construction needs. Please contact ATC for a distributor near you or visit www.atcepoxy.com to search for a distributor by zip code.



Color: Part A (Resin) Gray; Part B (Hardener) Clear, Mixed color - Concrete Gray

Storage & Shelf Life: For best results, store between 40 °F (4 °C) and 95 °F (35 °C). Shelf life is 24 months when stored in unopened containers in dry conditions.

Installation: Installation Instructions are available within this Technical Data Sheet (TDS). Due to occasional updates and revisions, always verify the most current usage. In order to achieve maximum results, proper installation is imperative.

Clean-Up: Always wear appropriate personal protective equipment such as safety glasses and gloves. Clean uncured materials from tools and equipment using a mild solvent, such as a citrus based product or denatured alcohol. Cured material may only be removed mechanically using a sander or grinder.

Limitations & Warnings:

- For professional use only
- Do not thin with solvents, as this will prevent cure
- Do not mix partial kits
- All metal surfaces that come in contact with ACCU-CHOCK should be sandblasted to white metal finish and wiped clean with solvent
- All concrete surface contaminations must be removed by mechanical means creating a surface profile of exposed sound aggregate.
- Typical grouting depth is 1 to 3 in.
- Maximum pour depth is 3 in. - contact ATC for pour depths greater than 3 in.
- Substrate temperature should be a minimum of 50 °F (10 °C)

Safety: Please refer to the Safety Data Sheet (SDS) for ACCU-CHOCK published on ATC's website or call for more information at 1-800-892-1880.

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TABLE 1: ACCU-CHOCK Packaging¹

Package Size	2.75 Gallon (10.4 L)
Part #	B2.75G-AC
Pallet Qty.	36
Pallet Weight (lb.)	1,590

1. Components are packaged separately inside one 5 gallon outer container.



B2.75G-AC

TABLE 2: ACCU-CHOCK performance to ASTM Standards^{1,2}

Property	ASTM Standard	Units	Results
Gel Time	C881	min	60
Viscosity	C881	cP	18,000
Compressive Strength	C579	psi (MPa)	16,250 (112)
Compressive Modulus	D695	psi (MPa)	2,300,000 (15,858)
Tensile Strength	C307	psi (MPa)	4,000 (27.6)
Tensile Modulus of Elasticity	C580	psi (MPa)	2,400,000 (16,547)
Bond Strength	C882	psi (MPa)	3,000 (20.7)
Flexural Strength	C580	psi (MPa)	6,000 (41.4)
Modulus of Elasticity	C580	psi (MPa)	2,400,000 (16,547)
Coefficient of Thermal Expansion	C531	in./in.-°F	18x10 ⁻⁶
Thermal Compatibility	C884	----	Pass
Shore D Hardness	D2240	----	90
Fire Resistance	D635	----	Self-Extinguishing
Water Absorption	C413	%	0.02
Shrinkage	C883	----	Pass
Linear Shrinkage on Cure	C531	%	0.02

1. Results based on testing conducted on are representative lot(s) of product. Average results will vary according to the tolerances of the given property.

2. Results may vary due to environmental factors such as temperature, moisture and type of substrate.

TABLE 3: ACCU-CHOCK CURE SCHEDULE¹

Temperature °F (°C)	Final Cure
60 (16)	60 hr
65 (18)	48 hr
70 (21)	36 hr
75 (24)	24 hr

1. Epoxy resins are temperature sensitive and care should be taken to condition all components between 65 °F - 85 °F (18 °C - 29 °C) for a minimum of 24 hrs. prior to mixing and placement. Temperatures colder than stated range increase viscosity of resins and inhibit mixing and flow of materials. Temperatures warmer than stated range decrease viscosity of resins, hasten the cure and reduce the working time. Mixing and curing at less than ideal temperatures, <60 °F (16 °C) or >95 °F (35 °C), will require special considerations.

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Surface Preparation

Concrete shall have reached its design strength and be dimensionally stable prior to placement of ACCU-CHOCK. All surface contamination must be removed by mechanical means, creating a surface profile of exposed sound aggregate that will provide a strong bond surface for the ACCU-CHOCK. All metal surfaces to come in contact with ACCU-CHOCK should be sandblasted to white metal finish and wiped clean with solvent. Items not intended to bond to chock, such as leveling screws, wedges and bolts must be protected with wax, caulk, duct tape or similar.

Forming

ATC recommends a minimum of two coats of industrial grade paste wax to facilitate removal of forms after cure. Forms should have 45 degree angle chamfer strips at all vertical corners and horizontal chock grade elevation in order to eliminate sharp corners. Caulk or similar sealant should be used to render the forms "watertight". Foundation bolts, shims and jacking bolts should be wrapped with 1/8 in. layer of weather stripping. Expansion joints shall be used every 4 feet in each direction to minimize the potential for cracking in ACCU-CHOCK. **NOTE:** MACHINERY MUST BE IN FINAL ALIGNMENT POSITION PRIOR TO POURING ACCU-CHOCK.

Mixing

Both Part A and Part B should be conditioned between 65 °F - 85 °F (18 °C - 29 °C) for at least 24 hours before use. Pour Part B into the Part A container and mix thoroughly for 3 to 4 minutes with a low speed drill at 300 rpm using a Jiffy Mixer. Keep the mixer completely submerged to prevent air entrainment. Scrape material completely from around the sides and bottom of the container with blade while mixing to ensure a complete and uniform mix.

Placement

Always pour ACCU-CHOCK from the lowest side of the chock area, which will force air to escape through the opposite corner. Continue to pour slowly until the entire chock area is filled and the chock over pour area is filled to a level approximately ½ in. above the bottom of the bedplate. DO NOT scrape unmixed settled material from container, place only what mixed material easily flows from container.

Post Cure

At the completion of the curing cycle, the temperature shall be lowered slowly, no more than 40 °F (4 °C) in 48 hours to avoid the possibility of damage due to sudden contraction.