

TECHNICAL DATA SHEET

DESCRIPTION

Pro-Poxy Chock is a 100% solids, VOC compliant, two component, high strength, pourable epoxy machine chock. Pro-Poxy Chock is designed to replace steel chocks for maintaining permanent alignment of machinery and equipment. Pro-Poxy Chock exhibits excellent resistance to heavy loading, vibration and chemicals while providing an exceptional degree of high strength and physical properties. Pro-Poxy Chock has excellent flowability where tight tolerances are present.

USE

Pro-Poxy Chock is specifically formulated, designed and engineered for use as a chocking compound under heavy vibrating equipment such as internal combustion gas engine compressors, engines, turbines, pumps, reduction gears, generators, skid mounted equipment, crane rails, or as replacement for steel chocks.

FEATURES

- Non-shrink
- Approved by the American Bureau of Shipping
- Chemical resistant
- Excellent flowability
- Low thermal conductivity
- Aggregate free 100% epoxy
- Provides 100% bearing area to base plates
- Provides permanent alignment of machinery and equipment

PROPERTIES

Gel Time: (60g mass) 45 minutes @ 73°F (23°C)

Final Cure: @ 60°F (16°C) = 48 hrs

65°F (18°C) = 36 hrs

70°F (21°C) = 24 hrs

75°F (24°C) = 18 hrs

Compressive Strength (ASTM C 942)

19,000 psi (131 MPa)

Compressive Strength (ASTM C 579)

18,000 psi (131 MPa)

Compressive Modulus (ASTM C 579)

2,450,000 psi (16,892MPa)

Tensile Strength (ASTM C 307): 5,000 psi (34.4 MPa)

Flexural Strength (ASTM C 580): 6,300 psi (43.4 MPa)

Modulus of Elasticity (ASTM C 580)

2, 800,000 psi (19,305 MPa)

Bond Strength (ASTM C 882): 3,000 psi (20.6 MPa)

Liner Shrinkage on Cure (ASTM C 531): 0.02%

Density (ASTM C 905): 110 lb/cu ft (1,800 kg/cu m)

Coefficient of Thermal Expansion (ASTM C 531)

17 X 10⁻⁶ in/in°F.

Hardness Shore (ASTM D 2240): D Scale = 90

Fire Resistance (ASTM D 635):

Self Extinguishing

Maximum Placement Depth: 2.5 inches (6.35 cm)

VOC

Pro-Poxy Chock has a VOC content of 0 g/L .

Compliant with all Canadian and U.S. VOC regulations including Federal EPA, OTC, LADCO, SCAQMD & CARB.

Estimating Guide

Yield of a 2.75 gallon (10.41 L) unit is 635 cu. in.

(10,405 cc) Yield when extended with 33 lbs (15 kg) of

Pro-Poxy Aggregate is 1100 cu. in. (18,025 cu cm)

Packaging

When extending Pro-Poxy Chock with Pro-Poxy Aggregate Extender (Product Code 141706), use 33lbs (15 kg) of aggregate per one unit of Pro-Poxy Chock.

Product	Product Code	Package	Size	
			Gallons	Liters
Pro-Poxy™ Chock	140481	Unit	2.75	10.4
Aggregate Extender	141706	100 lbs (45.36 kg)		

STORAGE

Pro-Poxy Chock should be stored in a dry temperature controlled environment between 40°F to 95°F (5°C to 35°C). Shelf life is two years if containers are unopened and undamaged. Low storage temperatures or significant temperature fluctuations may cause product to crystallize.

Surface Preparation:

Concrete must be a minimum of 28 days old. Do not place on damp or wet concrete. Grouting surfaces shall be free of grease, oils, waxes, chemicals and other impediments to adhesion. Concrete substrates shall be structurally sound, dry and should have a roughened profile (CSP 2-3) to maximize adhesion. All metal surfaces to come in contact with grout should be sandblasted to white metal finish to attain maximum bond strength and wiped clean with solvent, refer to SSPC-SP 6 (NACE 3) Commercial Blast Cleaning.

All steel surfaces exhibiting sharp edges should be smoothed or otherwise radiused prior to placement of Pro-Poxy™ Chock. Failure to smooth and or radius sharp edges may result in cracking. Items not intended to bond to grout, such as leveling screws, wedges and bolts, must be protected with wax, caulk, duct tape or similar products.

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Mixing:

Condition the temperature of the Pro-Poxy Chock to 65°F–85°F (18°C–29°C) for at least 12 hours prior to the time of mixing. Pour Part B into Part A container and mix for 3 minutes with a low speed drill motor (200 rpm max) keeping the mixer completely submerged at all times to avoid air entrainment. Carefully scrape and remove all material from sides during mixing to insure complete mixing.

Forming

Forms must be securely anchored and liquid tight. All Forms should be coated with a minimum of two coats of paste wax such as “Johnson’s” paste wax (car wax is not acceptable) or other suitable release agents. Forms should have a 45° angle chamfer strips at all vertical corners and around the perimeter of grout edges to eliminate all sharp edges and corners. Forms should be constructed so as to allow the use and placement of a head box to achieve a hydraulic head for ease of placement. Seal all cracks, crevices or any other places that may leak with a suitable caulk, sealant, or hydraulic cement.

MACHINERY MUST BE IN FINAL ALIGNMENT POSITION PRIOR TO POURING Pro-Poxy™ Chock .

NOTE: Large grouting areas may require expansion joints installed. Expansion joint material should be non-absorbent and chemical resistant such as Unitex Expansion joint. Expansion joints should be placed between 48-60 inches (122-152 cm) depending on the design and specifications of the project. For more details on placement and expansion joints spacing refer to the Unitex Epoxy Grout Guide. Unitex hard rubber Expansion Joint is available in 5’ and 10’ (1.52-3.05 m) lengths.

Placement:

Pour and place the Pro-Poxy Chock immediately after mixing, open areas may be poured directly into the cavity from the pail or other suitable containers. Use a head box when necessary to chase air from beneath base plates and sole plates to maintain a hydraulic head. Epoxy grouts are typically poured into the forms at one location to allow a uni-directional flow to displace air. Slowly pour until the entire chocking area is completely filled to a level of approximately ½ in. (1.3 cm) above the bottom of the base plate. Do not exceed the maximum placement thickness of 2 in. (5.08 cm) or 5.in (12.7 cm) when properly extended in one lift. If additional lifts are required they may be placed as soon as the preceding lift has set hard, but do not exceed 16 hours between lifts. Inspect forms frequently for leaks. Plug leaks with sealant, caulk, hydraulic cement, or putty.

Maximum Placement Depth Neat: 2 inches (6.35 cm)

Minimum Placement Depth Neat: 3/8 inch (1 cm)

Maximum placement with Pro Poxy aggregate is 5” (12.7 cm)

Minimum placement with Pro Poxy aggregate is 1” (2.54 cm)

When Poxy Chock is not placed under a baseplate the maximum is 1” neat and 2” when extended.

After placement maintain temperatures between 50° to 90°F (10° to 32°C).

Note: After forms have filled to the desired level, exposed horizontal surfaces of the grout may be finished using a suitable surfactant to reduce surface bubbling or foaming. Suitable surfactants are Unitex Citrus Clean, or WD-40. The surfactant should be lightly sprayed on a brush or plastic putty knife to smooth out the epoxy. Do not allow surfactant to puddle on the surface. This process may be performed as soon as the Pro-Poxy Chock levels out in the forms, until the grout has set hard.

Note: High temperatures will accelerate the setting time and low, cool temperatures will slow the setting time. As a general rule, the pot life of epoxy will be cut in half for each 10° to 15° increase in temperature above 75°F (24°C), the pot life will double for each 10° to 15° drop below 75°F (24°C).

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CLEAN UP

Clean all tools with xylene (xylol), toluene or Unitex Citrus Cleaner before the epoxy sets. Mortar mixers can be cleaned using two bags of 1/4-3/8 in. (0.64-0.95 cm) pea gravel with glycol. The glycol may be used several times before disposal. All tools must be cleaned up before the grout has set hard.

LIMITATIONS

FOR PROFESSIONAL USE ONLY

Minimum age of concrete must be 21-28 days from date of placement depending on curing and drying conditions. Concrete foundation shall be dry and have attained its design strength prior to application. Temperature of the substrate must be above 50°F (10°C) during installation and for initial cure period. Do not mix partial units. Always mix complete units.

PRECAUTIONS

READ SDS PRIOR TO USING PRODUCT

- Component A – Irritant
- Component B – Corrosive
- Product is a strong sensitizer
- Use with adequate ventilation
- Wear protective clothing, gloves and eye protection (goggles, safety glasses and/or face shield)
- Keep out of the reach of children
- Do not take internally
- In case of ingestion, seek medical help immediately
- May cause skin irritation upon contact, especially prolonged or repeated. If skin contact occurs, wash immediately with soap and water and seek medical help as needed.
- If eye contact occurs, flush immediately with clean water and seek medical help as needed
- Dispose of waste material in accordance with federal, state and local requirements
- Cured epoxy resins are innocuous

MANUFACTURER

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WARRANTY

Dayton Superior Corporation ("Dayton") warrants for 12 months from the date of manufacture or for the duration of the published product shelf life, whichever is less, that at the time of shipment by Dayton, the product is free of manufacturing defects and conforms to Dayton's product properties in force on the date of acceptance by Dayton of the order. Dayton shall only be liable under this warranty if the product has been applied, used, and stored in accordance with Dayton's instructions, especially surface preparation and installation, in force on the date of acceptance by Dayton of the order. The purchaser must examine the product when received and promptly notify Dayton in writing of any non-conformity before the product is used and no later than 30 days after such non-conformity is first discovered. If Dayton, in its sole discretion, determines that the product breached the above warranty, it will, in its sole discretion, replace the non-conforming product, refund the purchase price or issue a credit in the amount of the purchase price. This is the sole and exclusive remedy for breach of this warranty. Only a Dayton officer is authorized to modify this warranty. The information in this data sheet supersedes all other sales information received by the customer during the sales process. THE FOREGOING WARRANTY SHALL BE EXCLUSIVE AND IN LIEU OF ANY OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE, AND ALL OTHER WARRANTIES OTHERWISE ARISING BY OPERATION OF LAW, COURSE OF DEALING, CUSTOM, TRADE OR OTHERWISE.

Dayton shall not be liable in contract or in tort (including, without limitation, negligence, strict liability or otherwise) for loss of sales, revenues or profits; cost of capital or funds; business interruption or cost of downtime, loss of use, damage to or loss of use of other property (real or personal); failure to realize expected savings; frustration of economic or business expectations; claims by third parties (other than for bodily injury), or economic losses of any kind; or for any special, incidental, indirect, consequential, punitive or exemplary damages arising in any way out of the performance of, or failure to perform, its obligations under any contract for sale of product, even if Dayton could foresee or has been advised of the possibility of such damages. The Parties expressly agree that these limitations on damages are allocations of risk constituting, in part, the consideration for this contract, and also that such limitations shall survive the determination of any court of competent jurisdiction that any remedy provided in these terms or available at law fails of its essential purpose.