

CEILCOTE® 668B CHOCK GROUT

Epoxy chock for mounting equipment

DESCRIPTION:

CEILCOTE® 668B chock grout was originally developed for applications where conventional epoxy grouts could not be used. CEILCOTE 668B chock grout maintains a high modulus and compressive strength over a wider elevated temperature range.

With the ability to flow into place and conform to worn fretted surfaces, the use of CEILCOTE 668B chock grout can eliminate costly field machinery of irregular metal bases or the special machining required to make tapered metal chocks.

Metal chocks are often required on top of machinery rails and soleplates to allow future field alignment adjustments. Metal chocks of standard dimensions are excellent and also a good engineering practice, however, where surfaces are not true, pourable CEILCOTE 668B chock grout can be used within the limitations of pourable epoxy chocks. This complements the use of CEILCOTE 648 foundation grouts which have been used for the grouting of machinery rails and soleplates for over 25 years.

RECOMMENDED FOR:

- Applications for CEILCOTE 668B chock grout include reciprocating gas compressors, steam and gas turbines, and machinery requiring precision grouting.

PACKAGING/ESTIMATING:

Full Unit: 60.6 lbs (27.5 kg)

Yield: 0.47 ft³ (0.013 m³)

CEILCOTE 668B Grout Liquid	One 9.06 lb (4.11 kg) can
CEILCOTE 668B Grout Hardener	One 1.50 lb (0.68 kg) bottle
CEILCOTE 668B Grout Hardener	One 50 lb (22.7 kg) bag

PERFORMANCE DATA¹:

Compressive Strength:

(ASTM C 579 Method B, Modified) 1-1/2" (38 mm) Cubes
24 Hour

Temperature °F °C	Room Temperature				
	7 Day Cure @ 73 °F (23 °C) Conditioned		16 Hours @ 140 °F (60 °C) Conditioned		
	Test 1 Hour @ Test Temperature		Test 1 Hour @ Test Temperature		
		psi	MPa	psi	MPa
73 23		18,300	126	18,900	130
140 60		13,100	90	14,700	101
170 77		13,100	90	13,800	95
235 113		8,000	55	8,400	58

Tensile Strength

(ASTM C 307)

Test Temperature

°F	°C	psi	MPa
73	23	2,600	17.9

Flexural Strength

(ASTM C 580)

Test Temperature

°F	°C	psi	MPa
73	23	6,200	43

Modulus of Elasticity

(ASTM C 580)

Test Temperature

°F	°C	x 10 ⁶ psi	GPa
73	23	2.3	16
110	43	2.2	15
125	52	2.1	15
140	60	2.1	15
155	68	2.0	14
170	77	1.7	12

Creep

(Cured per ASTM C 579-B)

(CEILCOTE Test Method 160)

Conditions				Creep @ 1 Year in/in (cm/cm)
°F	psi	°C	MPa	
140	600	60	4.1	0.8 x 10 ⁻³
140	900	60	6.2	1.3 x 10 ⁻³
140	1,200	60	8.3	1.9 x 10 ⁻³

Working Time		Time - Hours
Temperature		
°F	°C	
90	32	1/2 hour
73	23	1 hour
55	13	3 hours

Cure Time		Time - Hours
Test Temperature		
°F	°C	
To obtain 10,000 psi (69 MPa)		
90	32	4 hours
73	23	6 hours
55	13	18 hours

Cure Rate						
Compressive strength when cured at:						
Time (hours)	55 °F psi	13 °C MPa	73 °F psi	23 °C MPa	90 °F psi	32 °C MPa
8	—	—	14,500	100	18,600	128
16	9,500	66	17,000	117	19,000	131
24	14,000	97	18,000	124	19,200	132
48	15,300	106	18,800	130	19,200	132

Coefficient of Thermal Expansion
(ASTM C 531)
73° to 210 °F 19 x 10⁻⁶ in/in/°F
23° to 100 °C 34 x 10⁻⁶ cm/cm/°C

Water Absorption
(ASTM C 413)

0.09%

Bond Strength to Steel - Tension			
°F	°C	psi	MPa
73	23	5,300	36
140	60	3,500	24
170	77	3,200	22
235	113	1,200	8

Bond Strength to Steel - Shear			
°F	°C	psi	MPa
73	23	4,500	31
140	60	3,600	25
170	77	3,600	25
235	113	1,200	8

Density
(ASTM C 905) 129 lbs/ft³ (2,066 kg/m³)

Specific Gravity 2.06

Bond Strength to Concrete Stronger than Concrete

Impact Strength Better than Concrete

Abrasion Resistance Better than Concrete

Color Metallic Grey

Flash Points
(Pensky-Martens Closed Cup)
CEILCOTE 668B Grout Liquid Above 230 °F (110 °C)
CEILCOTE 668B Grout Hardener 210 °F (99 °C)

APPLICATION:

Consult the CEILCOTE 668B Chock Grout Installation Bulletin or the product bag for details on the installation of CEILCOTE 668B chock grout.

Master Builders recommends that the user request the services of the local representative for a pre-job conference to plan the installation.

LIMITATIONS:

CEILCOTE 668B Chock Grout is a three component epoxy grout formulated for industrial and professional use only and must be kept out of the reach of children. These products contain chemicals which may be COMBUSTIBLE and potentially HARMFUL to your health if not stored and used properly. Hazards can be significantly reduced by observing all precautions which are found on material safety data sheets, and product labels. Please read this literature carefully before using product.

RELATED BULLETINS:

CEILCOTE 668B - Material Safety Data Sheet
CEILCOTE 668B - Installation Bulletin 9I6

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