

# Rowan Resins 668BF Chock Grout

Revised September 03

## DESCRIPTION:

668BF chock grout was created specifically for use with Rowan Tri Chock Adjustable Epoxy chocking system. 668BF can also be used as a traditional poured in place epoxy chock. 668BF is a high modulus, high compressive strength material designed for use with critical alignment machinery.

With the ability to flow into place and conform to worn fretted surfaces, the use of 668BF High Strength Chock Grout can eliminate costly field machinery of irregular metal base.

## RECOMMENDED FOR:

- Applications for 668BF High Strength Chock Grout include reciprocating and rotating compressors, steam and gas turbines, and machinery requiring precision grouting.

## PACKAGING/ESTIMATING:

**Full Unit:** 63 lbs. (28.5 kg)  
**Yield:** 0.47ft<sup>3</sup> (0.013m<sup>3</sup>)  
 668B Grout Liquid One 9.06 lb. (4.11 kg) can  
 668B Grout Hardener One 1.50 lb. (0.68 kg) bottle  
 668B Grout Aggregate One 53 lb. (24.04 kg) bucket

## PERFORMANCE DATA:

### Compression Strength:

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

Temperature		24 Hour Room Temperature 7 Day Cure @ 73°F (23°C) Conditioned Test 1 Hour @ Test		16 Hours @ 140° F (60° C) Conditioned 1 Hour@ Test	
°F	°C	psi	MPa	psi	MPa
73	231	8,300	126	18,900	130
140	601	3,100	90	14,700	101
170	77	13,100	90	13,800	95
23	511	38,000	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 <sup>6</sup> 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)  
(668BF Test Method 160)

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

### Working Time

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

### Cure Time

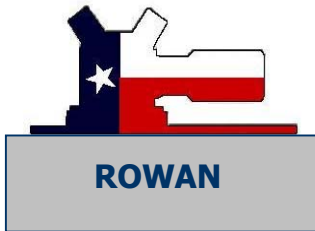
To obtain 10,000 psi (69 MPa)

Test Temperature		Time - Hours
°F	°C	
90	32	4 hours
73	23	6 hours
55	13	18 hours

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## Coefficient of Thermal Expansion

(ASTM C 351)

73° to 210°F	19 x 10 <sup>-6</sup> in/in/°F
23° to 100°C	34 x 10 <sup>-6</sup> cm/cm/°C

## Water Absorption

(ASTM C 4) 0.09%

## Bond Strength to Steel – Tension

°F	°C	psi	MPa
73	23	4,500	31
140	60	3,600	25
170	77	3,600	25
235	133	1,200	8

## Density

(ASTM C 905) 129 lbs/ft<sup>3</sup> (2,066 kg/m<sup>3</sup>)

## 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)

668B Grout Liquid

668B Grout Hardener

## Cure Rate

Comprehensive 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

## APPLICATION:

Consult the 668BF Chock Grout Installation Bulletin for details on the installation of 668BF chock grout.

Robt. L. Rowan & Assoc., Inc. recommends that the user request the services of local representative for a pre-job conference to plan the installation.

## LIMITATIONS:

668BF Chock Grout is a three-component epoxy grout formulated for industrial and professional use only and must be kept out of 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:

- 668BF – Material Safety Data Sheets
- 668BF – Installation Bulletin 668BF-I