



## TS365 Marine Chocking Compound

TS365 Marine chocking compound is a two-part epoxy mixture with good performance of pouring. After curing, it has high compressive strength and compressive modulus of elasticity, also with excellent heat resistance, impact resistance and self-extinguishing away from fire.

TS365 can be applied for positioning during assembly of various marine equipment, such as main diesel engine, auxiliary machinery, stern tube, deck machinery, etc.

<b>Technology/Base</b>	Epoxy
<b>Type of Product</b>	Adhesive
<b>Components</b>	Two components
<b>Curing</b>	RT or heat cure
<b>Appearance/Color</b>	Part A (Resin): orange Part B (Hardener): colorless transparent Mixed: orange
<b>Consistency</b>	Fluid

### Features and Benefits

- Good flame resistance
- High compressive strength and compressive modulus of elasticity
- Low absorption of water and oil

### Curing Profile

Recommended cure:

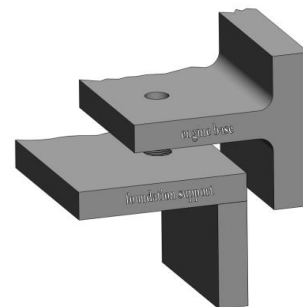
- 8 hours@60°C
- or
- 24 hours@23°C

Contact HB Fuller technical support for additional curing recommendations

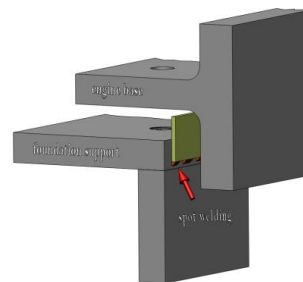
### Application Instructions

- **Materials required:** foam damming materials, metal dams, sealing adhesive, release agent, washing agent or acetone, heavy duty hand electric drill with an operating speed of 200 rpm, jiffy mixer, knife, infrared thermometer, heater (used when the temperature is below 13°C), protective gloves and goggles.
- **TS365 marine chocking compound:** try to store the adhesive at (23±2)°C for at least the last 12 hours before use.
- **Clean:** clean all surfaces that the adhesive will contact, they should be free from grease, oil, water, rust or paint.
- **Adjustment:** the machine's alignment and the casting cavities should be adjusted to the required size through the adjustable bolts, wedge blocks and

so on.

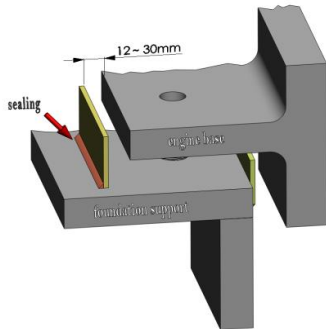


- **Damming:** Attach the iron behind between the body base and engine base to support the follow-up of foam sealing material.

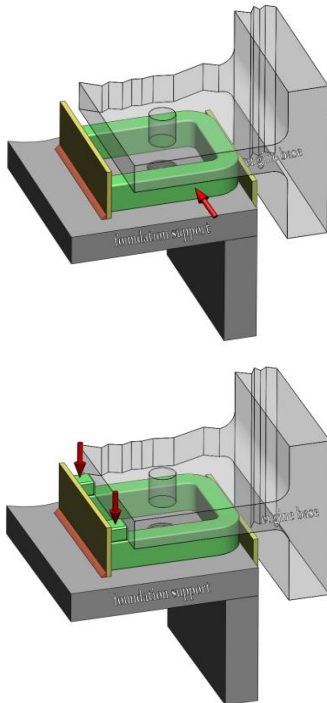


Attach the iron front between the body base and engine base to form the pouring area, the height and distance from the base should be accorded with limits shown. And leak the attachment with the

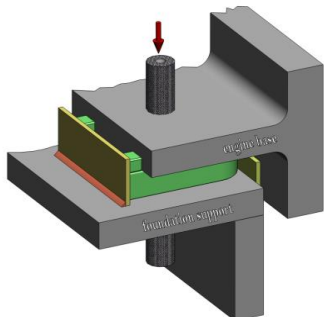
sealant adhesive.



Insert foam damming materials per chocking area.



Insert foam damming materials in bolt hole.



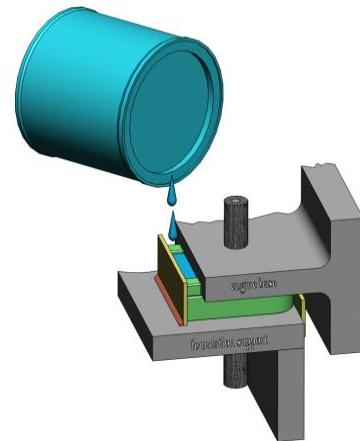
The general rule: form a blocking cavity with no leaks, the foam damming materials and sealant adhesive can be used.

● **Mixing:** according to the list instructions of “mixing ratio-temperature-thickness”, add appropriate hardener to the resin, and mixing with heavy duty

hand electric drill, usually less than 3 minutes.

Thickness	30 mm	50 mm	70 mm
Temperature			
<15°C	No reduction	2/4 reduction	3/4 reduction
15°C-19°C		3/4 reduction or full reduction	
20°C-23°C			
24°C-25°C	1/4 reduction or no reduction	full reduction	
25°C-30°C		full reduction	Layered pours

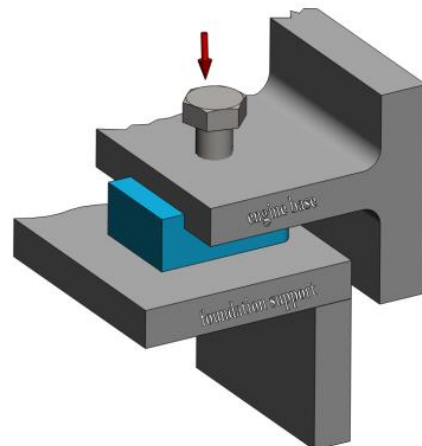
● **Pouring:** pour the mixture as soon as possible after mixing from the over pour area. Make sure the adhesive surface higher than the bottom of engine base at least 12 mm.



● **Samples:** pour the mixture about 300 g to the appropriate small box, after curing test Barcol hardness.

● **Curing:** It is appropriate when Barcol hardness of samples and chocks is higher than 35. Make sure the temperature is at least 13 °C , use heater if necessary.

● **After curing:** remove the iron dams, take the sharp edge off the over pour; adjust the adjustment bolts and wedge blocks; tighten the hold down bolts to the desired tension or torque.





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## **Storage Conditions**

Store in a cool, dry area at a room temperature.

Shelf life: 12 months in unopened containers.

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## **Typical Packaging**

Stock No.	Unit Size
23650202	8 kg/set

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## **Disposal Advice**

Please refer to the MSDS for disposal instructions.

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## **Safety Advice**

For complete safety and handling information, please refer to the appropriate Material Safety Data Sheets prior to using this product.

For technical assistance, please call +86-10-88795588.



Technical Data

Rheology	Value	Condition/Standard
Part A (Resin)	50,000~100,000 mPa • s	Brookfield DV2T Viscometer, 3 rpm, 23°C
Part B (Hardener)	26 mPa • s	Brookfield DV- II + Pro Viscometer, 0#, 23°C
Density		ISO 1675
Part A (Resin)	1.86 g/cm <sup>3</sup>	
Part B (Hardener)	0.97 g/cm <sup>3</sup>	
Mixed	1.78 g/cm <sup>3</sup>	
Curing		
Fixture Time	50~70 min	
Cure Temperature and Time	24 h@23°C or 8 h@60°C	
Cured Mechanical Properties (Curing 8h@60°C)		
Barcol Hardness	45~55	EN 59 (re. ASTM D2583)
Compressive Strength	138.3 MPa	ISO 604
Compressive Modulus of Elasticity	6756.3 MPa	ISO 604
Tensile Strength	47.4 MPa	ISO 527-2
Tensile Modulus of Elasticity	8784.2 MPa	ISO 527-2
Notch Impact Strength	2.5 kJ/m <sup>2</sup>	ISO 180
Water Absorption	0.267% (23°C)	ISO 175
Oil Absorption	0.039% (CD40, 23°C)	ISO175
Oil Absorption	0.033% (CH40, 23°C)	ISO175
Bending Strength	75.2 MPa	ISO 178
Bending Modulus	8054 MPa	ISO 178
Coefficient	37.1 ppm/°C	ASTM E228
Voluminal Shrinkage	0.58%	ISO 3521
Thermal Indication		
Glass Transition Temperature	121.3°C	ISO 11357-2
Burning Rate	0 mm/min	ASTM D635

Date Modified: 22/4/2020

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