



Abrasion Resistance, ASTM D4060: mg 149  
1 Kg load, CS-10 wheels, Weight of Material Lost

#### Electrical Properties:

Volume Resistivity, IEC 60093, ohm-cm  $120 \times 10^{12}$   
Surface Resistivity, IEC 60093, ohms  $3.3 \times 10^{15}$

### TYPICAL PERFORMANCE OF CURED MATERIAL

#### Shear Strength

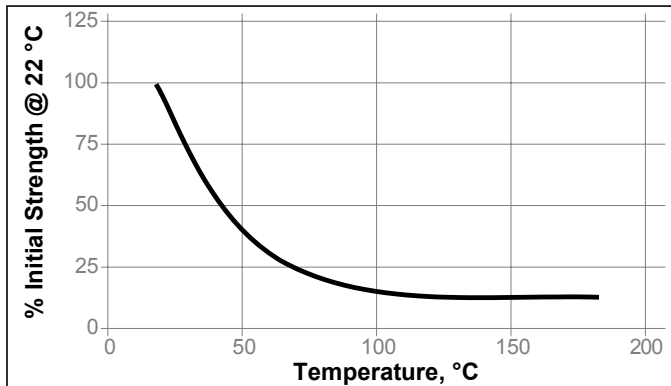
Lap Shear Strength, ISO 4587:  
Grit Blasted Mild Steel (GBMS) N/mm<sup>2</sup> 15  
(psi) (2,190)

### TYPICAL ENVIRONMENTAL RESISTANCE

Cured for 72 hours @ 21°C  
Lap Shear Strength, ISO 4587:  
Grit Blasted Mild Steel (GBMS)

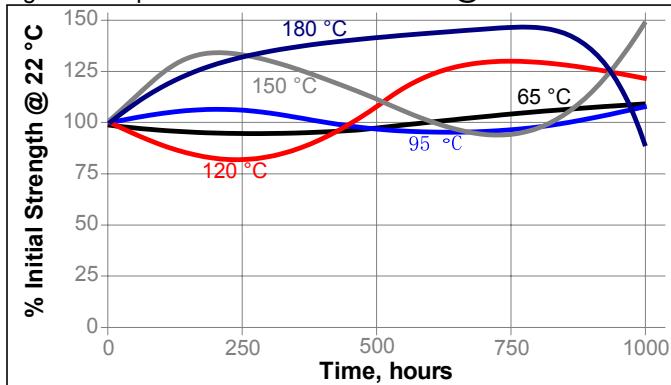
#### Hot Strength

Tested at temperature



#### Heat Aging

Aged at temperature indicated and tested @ 22 °C



### GENERAL INFORMATION

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials.

For safe handling information on this product, consult the Safety Data Sheet (SDS).

#### Surface Preparation

Proper surface preparation is critical to the long-term performance of this product. The exact requirements vary with severity of the application, expected service life, and initial substrate conditions

#### Directions for use:

1. Remove dirt, oil, grease, etc. with a suitable cleaner, e.g. high pressure water cleaning system using Loctite® SF 7840™ (Loctite® Natural Blue® cleaner/degreaser).
2. Blast all surfaces to be coated with a sharp edged angular grit to a depth of profile of 75 to 100 microns and a degree of cleanliness of Near White Metal (SIS SA 2½ /SSPC-SP 10).
3. After blasting, metal surfaces should be cleaned with waterless cleaner, e.g. with Loctite® SF 7611™ (Loctite® Pro Strength Parts Cleaner), and be coated before any oxidation or contamination takes place.
4. Metal that has been in contact with salt solutions, e.g. seawater, should be grit blasted, high-pressure water blasted, and left for 24 hours to allow any salts in the metal to sweat to the surface. A test for chloride contamination should be performed. The procedure should be repeated until chloride concentration on the surface is below 40 ppm.

#### Application

1. Mix resin and hardener according to mix ratios listed or transfer entire kit onto a clean and dry mixing surface and mix material vigorously until a uniform color is obtained.
2. Apply material to prepared surface by first forcing a thin layer deep into the texture of the substrate.
3. Then immediately build up to the desired finished thickness.
4. If using to rebuild shaft, the following applies:
  - Machine the worn area down 3 mm (0.125 in) to produce a square shoulder on part. The material is stronger with a square edge versus a feathered edge.
  - Machine a spiral cut in bottom of area to be repaired to provide mechanical keying into surface.
  - Apply excess product to ensure small shrinkage during cure does not produce depression.
  - Machine the surface to original dimensions prior to full cure, as the product is very wear-resistant.

#### Inspection

- Visually inspect for pinholes and misses just after application.
- Once the coating has cured, repeat visual inspection to confirm it is free from pinholes, misses and mechanical damages.
- Control thickness of the coating, especially in the critical points.

- Perform a test with a holiday detector to confirm coating continuity.

### Coverage

To achieve a 6 mm (.25 in) thickness, the coverage rate will be 370cm<sup>2</sup> (57in<sup>2</sup>) for 0.45kg (1lb), excluding overthickness, repairs, etc.

### Repairs

Any voids, pinholes, or low thickness areas found in the coating should be repaired by lightly abrading, cleaning, and applying further product.

### Clean-up

Immediately after use clean tools with suitable cleaner, e.g. Loctite® 7070™ or a solvent such as acetone or isopropyl alcohol. Once cured, the material can only be removed mechanically

### Technical Tips for Working With Epoxies

#### Environmental Conditions

- Relative humidity: <85%
- Ambient temperature: >15°C (60F) and rising
- Substrate temperature must always be 3°C (7F) higher than the dew point to avoid condensing moisture on parts.

Working time and cure depends on temperature and mass:

- The higher the temperature, the faster the cure.
- The larger the mass of material, the faster the cure.

To speed the cure of epoxies at low temperatures:

- Store epoxy at room temperature.
- Pre-heat repair surface until warm to the touch.

To slow the cure of epoxies at high temperatures:

- Mix epoxy in small masses to prevent rapid curing.
- Cool resin/hardener component(s).

### Loctite Material Specification<sup>LMS</sup>

LMS dated February 13, 2003 (Resin) and LMS dated July 3, 2001 (Hardener). Test reports for each batch are available for the indicated properties. LMS test reports include selected QC test parameters considered appropriate to specifications for customer use. Additionally, comprehensive controls are in place to assure product quality and consistency. Special customer specification requirements may be coordinated through Henkel Loctite Quality.

### Storage

Store product in the unopened container in a dry location. Storage information may be indicated on the product container labeling.

**Optimal Storage: 8 °C to 21 °C. Storage below 8 °C or greater than 28 °C can adversely affect product properties.**

Material removed from containers may be contaminated during use. Do not return product to the original container. Henkel Corporation cannot assume responsibility for product which has been contaminated or stored under conditions other than those previously indicated. If additional information is required, please contact your local Technical Service Center or Customer Service Representative.

### Conversions

(°C x 1.8) + 32 = °F  
kV/mm x 25.4 = V/mil  
mm / 25.4 = inches

µm / 25.4 = mil  
N x 0.225 = lb  
N/mm x 5.71 = lb/in  
N/mm<sup>2</sup> x 145 = psi  
MPa x 145 = psi  
N·m x 8.851 = lb·in  
N·m x 0.738 = lb·ft  
N·mm x 0.142 = oz·in  
mPa·s = cP

#### Note:

The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. The product can have a variety of different applications as well as differing application and working conditions in your environment that are beyond our control. Henkel is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product.

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Reference **N/A**