Technical Data Sheet

LOCTITE® PC 7226™ EUR

Known as NORDBAK PNEU-WEAR (Europe)
January 2020

PRODUCT DESCRIPTION

LOCTITE® PC 7226™ EUR provides the following product characteristics:

Technology	Epoxy
Chemical Type	Epoxy
Appearance (Resin)	Grey
Appearance (Mixed)	Grey
Components	Two components - requires mixing
Mix Ratio, by weight - Resin : Hardener	4 : 1
Mix Ratio, (by volume) Resin : Hardener	4 : 1
Cure	Room temperature cure after mixing
Application Temperature	15 to 40°C (59 to 104°F)
Application	Europe - Coating
Service Temperature	120°C (248°F)
Specific Benefits	• Resurfacing and repairing of worn or corroded metal parts • Protecting metal surfaces against chemicals, abrasive and corrosive agents • Ceramic - filled for outstanding resistance to abrasion • Non sag - provides abrasion resistance on over-head and vertical surfaces

LOCTITE® PC 7226™ EUR is a small ceramic bead filled two-part epoxy putty, designed to protect equipment from fine particle abrasion. This product is typically used in applications with an operating range of -30 °C to 120 °C. Typical applications include transport elbows and transitions, pump liners and impellers, chute linings and hoppers, cyclone and separator bodies, fan blades and housing, and dust collectors and exhausters. Designed to provide protective lining in pneumatic conveying systems and repairing and providing abrasion resistance in elbows, slurry pumps, hoppers, cyclones, dust collectors.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Part A:

Density @ 25 °C, ISO 1675, g/cm³	2.0
Viscosity	Paste

Part B:

Density @ 25 °C, ISO 1675, g/cm³	2.1
Viscosity	Paste

Mixed:

Density @ 25 °C, ISO 1675, g/cm³	2.0
Viscosity	Paste

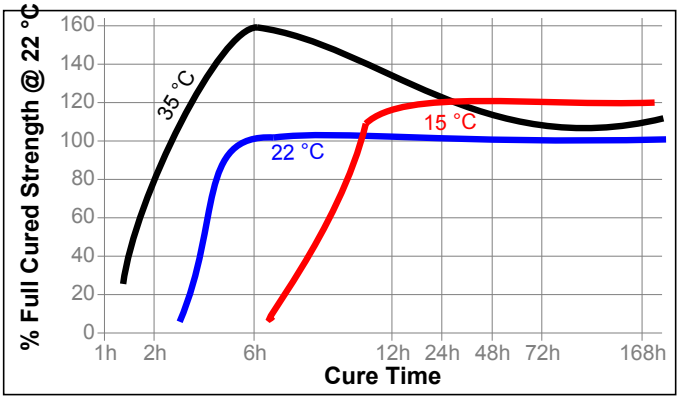
TYPICAL CURING PERFORMANCE

Curing Properties

Gel Time @ 25 °C, minutes	65
Recoat Time @ 25 °C, hours	12

Cure Speed vs. Temperature

The graph below shows the shear strength developed with time on grit blasted mild steel and aluminum lap shears and tested according to ISO 4587.



TYPICAL PROPERTIES OF CURED MATERIAL

Cured for 1 week @ 22 °C

Physical Properties:

Glass Transition Temperature (Tg), °C , ISO 11357-2,	56
Coefficient of Thermal Expansion, ISO 11359-2,:	
Below Tg	59×10^{-06}
Above Tg	154×10^{-06}
Hardness (Shore D), ASTM D2240	84
Volume Shrinkage, ASTM D 792, %	13

Electrical Properties:

Dielectric strength, ASTM D149, kV/mm,	2.75

Adhesive Properties:

Tensile Lap Shear Strength, :

Mild steel (grit blasted)	N/mm²	6.0
	(psi)	(870)
Stainless steel	N/mm²	2.8
	(psi)	(406)

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).

Directions For Use:

Surface Preparation

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

1. Remove dirt, oil, grease etc with a suitable cleaner, e.g. high pressure water cleaning system using Loctite® 7840™.
2. All skip welds, weld splatter, buckshot, and other surface roughness must be ground down and smoothed; undercuts and pinholes must be ground smooth and filled. All projections, sharp edges, high points and fillets must be ground smooth to a radius of at least 3mm and all corners must be likewise rounded to maximize product performance.
3. Blast all surfaces to be coated with a sharp edged angular grit to a depth of profile of 75 to 100 microns (3 to 4 mils), and a degree of cleanliness of Near White Metal (SIS SA 2½ /SSPC-SP 10). For immersion service, a degree of cleanliness of White Metal (SIS SA 3/SSPC-SP 5) is required.
4. After blasting, metal surfaces should be cleaned, e.g. with Loctite® SF 7063™ or Loctite® SF 7070™, and be coated before any oxidation or contamination takes place .
5. Metal that has been in contact with salt solutions, e.g. seawater, should be grit blasted and high-pressure water blasted, 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. Ambient and substrate temperature range: 15 to 40 °C (59 to 104 °F).
2. Relative humidity: <85 %; substrate temperature must always be 3 °C higher than the dew point.
3. Film thickness per coat: minimum 6 mm (0.24 in).
4. Apply material to prepared surface by first forcing a thin layer deep into the texture of the substrate.
5. Then immediately build up to the desired finished thickness.

Inspection

1. Visually inspect for pinholes and misses just after application.
2. Once the coating has cured, repeat visual inspection to confirm it is free from pinholes, misses and mechanical damages.
3. Control thickness of the coating, especially in the critical points.
4. Perform a test with a holiday detector to confirm coating continuity.

Caution: Use an approved, positive-pressure, supplied air respirator when welding or torch cutting near cured compound. **Do Not** use open flame on compound.

Color

Color variation is possible between the batches and will not affect the performance of the product.

Coverage

To achieve a 6 mm (.24 in) thickness, the coverage rate will be 0.1 m² (1.08 ft²) for 1 kg (2.2 lb), 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® SF 7063™ or a solvent such as acetone or isopropyl alcohol. Once cured, the material can only be removed mechanically

Technical Tips for Working With Epoxies

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).

Not for product specifications

The technical data contained herein are intended as reference only. Please contact your local quality department for assistance and recommendations on specifications for this product.

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/mm² 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

Reference 0