

# LOCTITE<sup>®</sup> PC 7218<sup>™</sup>

Known as LOCTITE<sup>®</sup> 7218 NORDBAK WEARING COMPOUND  
November 2019

## PRODUCT DESCRIPTION

LOCTITE<sup>®</sup> PC 7218<sup>™</sup> provides the following product characteristics:

|                                                    |                                                                                                                                                                                                                                                                                                                                                             |
|----------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <b>Technology</b>                                  | Epoxy                                                                                                                                                                                                                                                                                                                                                       |
| <b>Chemical Type</b>                               | Epoxy                                                                                                                                                                                                                                                                                                                                                       |
| <b>Appearance (Resin)</b>                          | Grey                                                                                                                                                                                                                                                                                                                                                        |
| <b>Appearance - Mixed</b>                          | Grey                                                                                                                                                                                                                                                                                                                                                        |
| <b>Components</b>                                  | Two part - Resin & Hardener                                                                                                                                                                                                                                                                                                                                 |
| <b>Mix Ratio, (by weight)<br/>Resin : Hardener</b> | 2 : 1                                                                                                                                                                                                                                                                                                                                                       |
| <b>Mix Ratio, (by volume)<br/>Resin : Hardener</b> | 2 : 1                                                                                                                                                                                                                                                                                                                                                       |
| <b>Cure</b>                                        | Room temperature cure after mixing                                                                                                                                                                                                                                                                                                                          |
| <b>Application</b>                                 | Coating / Wearing Compound                                                                                                                                                                                                                                                                                                                                  |
| <b>Application<br/>Temperature</b>                 | 10 to 40°C (50 to 104°F)                                                                                                                                                                                                                                                                                                                                    |
| <b>Service Temperature</b>                         | 120°C (248°F)                                                                                                                                                                                                                                                                                                                                               |
| <b>Specific Benefits</b>                           | <ul style="list-style-type: none"> <li>• Resurfacing and repairing of worn or corroded metal parts</li> <li>• Protecting metal surfaces against chemicals, abrasive and corrosive agents</li> <li>• Ceramic - filled for outstanding resistance to abrasion</li> <li>• Non sag - provides abrasion resistance on over-head and vertical surfaces</li> </ul> |

LOCTITE<sup>®</sup> PC 7218<sup>™</sup> is a two-part ceramic filled epoxy paste designed to protect, rebuild and repair high wear areas of processing equipment. This product is typically used in applications with an operating range of -30 °C to 120 °C. Typical applications include cyclone and separator bodies, dust collectors and exhausters, pump liners and impellers, fan blades and housings, chutes and hoppers, elbows and transition points.

## TYPICAL PROPERTIES OF UNCURED MATERIAL

### Part A:

|                                              |       |
|----------------------------------------------|-------|
| Density @ 25 °C, ISO 1675, g/cm <sup>3</sup> | 2.3   |
| Viscosity                                    | Paste |

### Part B:

|                                              |       |
|----------------------------------------------|-------|
| Density @ 25 °C, ISO 1675, g/cm <sup>3</sup> | 2.4   |
| Viscosity                                    | Paste |

### Mixed:

|                                              |       |
|----------------------------------------------|-------|
| Density @ 25 °C, ISO 1675, g/cm <sup>3</sup> | 2.3   |
| Viscosity                                    | Paste |

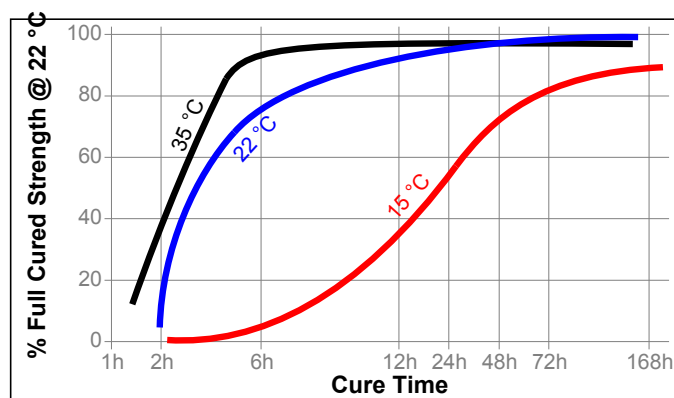
## TYPICAL CURING PERFORMANCE

### Curing Properties

|                              |    |
|------------------------------|----|
| Gel Time, ASTM D2471 minutes | 87 |
| Recoat Time @ 25 °C, hours   | 1  |

### 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 7 days @ 22 °C

**Physical Properties:**

|                                                                  |                     |
|------------------------------------------------------------------|---------------------|
| Glass Transition Temperature (Tg), °C<br>TMA, ISO 11359-2        | 77                  |
| Coefficient of Thermal Expansion, ISO 11359-2, K <sup>-1</sup> : |                     |
| Below Tg                                                         | 23×10 <sup>-6</sup> |
| Above Tg                                                         | 74×10 <sup>-6</sup> |
| Hardness (Shore D), ASTM D2240                                   | 90                  |
| Volume Shrinkage, ASTM D 792, %                                  | 2.1                 |

**Electrical Properties:**

|                                        |      |
|----------------------------------------|------|
| Dielectric strength, ASTM D149, kV/mm, | 3.39 |
|----------------------------------------|------|

**Adhesive Properties:**

|                               |                                        |
|-------------------------------|----------------------------------------|
| Lap Shear Strength, ISO 4587: |                                        |
| Mild steel (grit blasted)     | N/mm <sup>2</sup> 7.6<br>(psi) (1,102) |
| Stainless steel               | N/mm <sup>2</sup> 8.4<br>(psi) (1,218) |

**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® SF 7840™.
2. All skip welds, weld spatter, buckshot, and other surface roughness must be ground down; undercuts and pinholes must be ground and filled. All projections, sharp edges, high points and fillets must be ground 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 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. Film thickness per coat: minimum 6 mm (0.24 in).
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.

**Inspection**

- Visually inspect for pinholes and misses just after application.
- Once the coating has cured, repeat visual inspection to confirm absence of pinholes, voids or damaged areas..
- Control thickness of the coating, especially in the critical areas.
- 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 m<sup>2</sup> (1.08 ft<sup>2</sup>) 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 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 or warm resin/hardener component(s) prior to mixing. Never use open flame.
- Pre-heat repair surface until warm to the touch.
- Tent working area to achieve suitable environmental conditions.

To slow the cure of epoxies at high temperatures:

- Store epoxy at room temperature or cool resin/hardener component(s) prior to mixing.
- Work during cool, morning hours and shade area from direct sun.

### Not for product specifications

The technical data contained herein are intended as reference only and are not considered specifications for the product.

Product specifications are located on the Certificate of Analysis or please contact Henkel representative.

### 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

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$   
 $\text{kV/mm} \times 25.4 = \text{V/mil}$   
 $\text{mm} / 25.4 = \text{inches}$   
 $\mu\text{m} / 25.4 = \text{mil}$   
 $\text{N} \times 0.225 = \text{lb}$   
 $\text{N/mm} \times 5.71 = \text{lb/in}$   
 $\text{N/mm}^2 \times 145 = \text{psi}$   
 $\text{MPa} \times 145 = \text{psi}$   
 $\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$   
 $\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$   
 $\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$   
 $\text{mPa}\cdot\text{s} = \text{cP}$

### 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 0.0