Technical Data Sheet

LOCTITE® PC 7219™

Known as NORDBAK HIGH IMPACT WEARING COMPOUND
December 2016

PRODUCT DESCRIPTION

LOCTITE® PC 7219™ provides the following product characteristics:

Technology	Epoxy
Chemical Type	Epoxy
Appearance (uncured)	Gray paste
Components	Two components - requires mixing
Mix Ratio, by weight - Resin : Hardener	2 : 1
Mix Ratio, (by volume) Resin : Hardener	2 : 1
Cure	Room temperature cure
Application	Abrasion resistance
Specific Application	• Dredge pump liners • Flumes and troughs • Pump impellers • Vibrating feeders • Material transfer chutes / hoppers
Specific Benefits	• Impact resistant • Ceramic - filled for outstanding resistance to abrasion • Renews worn surfaces fast - reduces downtime • Extends wear life - resists sliding abrasive wear and eliminates costly wear part inventory • Non sag - provides abrasion resistance on over-head and vertical surfaces

LOCTITE® PC 7219™ is a rubber modified ceramic filled two-component epoxy paste that offers wear resistance properties together with impact resistance. Temperature range -30 °C to +120 °C. LOCTITE® PC 7219™ is recommended for lining and protecting flumes, troughs, elbows, hoppers, discharge chutes and other processing equipment that is exposed to both abrasion and impact.

TYPICAL CURING PERFORMANCE

Curing Properties

Working Time @ 25 °C, minutes	30
Cure Time @ 25 °C, hours	6

TYPICAL PROPERTIES OF CURED MATERIAL

Cured for 1 week @ 25°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).

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. Thoroughly clean and abrade surfaces (grit blast if possible), finally clean with LOCTITE® 7063™. The more thorough the degree of surface preparation the better the performance of the application.
2. On vertical or overhead areas, it is recommended to tack expanded metal mesh to substrate before application of LOCTITE® PC 7219™ .

Application:

1. Measure 2 parts of resin and 1 part of hardener (by volume and weight) onto a board and mix until uniform in color.
2. If resin and hardener temperatures are 15°C or below, preheat resin to only about 30°C but not to exceed 40°C.
3. Apply fully mixed material to the prepared surface .
4. Initially apply as a thin film to "wet" out the surface.
5. Build up to desired thickness (minimum 6 mm), avoid air entrapment.
6. At 25 °C working time is 30 minutes and functional cure time is 7 hours.

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.

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

Coverage

To achieve a 6 mm (.25 in) thickness, the coverage rate will be 740cm² (0.8in²) for 1kg (2.2lb), 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. Teroson® PU 8550 or Bonderite C-MC 21130. 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 Henkel 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

Disclaimer

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