

LOCTITE[®] PC 7266[™]

Known as LOCTITE[®] Nordbak[®] Sprayable Coating 7266[™]
January 2015

PRODUCT DESCRIPTION

LOCTITE[®] PC 7266[™] provides the following product characteristics:

Technology	Epoxy
Chemical Type	Epoxy
Appearance (Resin)	Light blue liquid
Appearance (Hardener)	Transparent
Appearance (Mixture)	Brilliant blue liquid
Components	Two part - Resin & Hardener
Mix Ratio, by weight - Resin : Hardener	100 : 22
Cure	Room temperature cure after mixing
Application	Coating
Product Benefits	<ul style="list-style-type: none"> Smooth sprayable consistency Gloss finish to reduce friction and turbulence Excellent adhesion
Specific Application	<ul style="list-style-type: none"> Protecting metal surfaces against abrasive and corrosive agents

LOCTITE[®] PC 7266[™] sprayable epoxy is a solvent-free two part epoxy coating. It is designed to protect metal surfaces against abrasive and corrosive agents. It can be used as smooth, protective coating on metal surfaces. Typical applications are the protection of heat exchangers, condensers, lining tanks, valve bodies, pipes or pump impellers and housings.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Resin

Specific Gravity @ 25 °C	1.61
Viscosity, Cone & Plate, mPa·s (cP): Temperature: 25 °C, Shear Rate: 40 s ⁻¹	2,800

Hardener

Specific Gravity @ 25 °C	1.0
Viscosity, Cone & Plate, mPa·s (cP): Temperature: 25 °C, Shear Rate: 40 s ⁻¹	250

Mixed

Specific Gravity @ 25 °C	1.22
Viscosity, Cone & Plate, mPa·s (cP): Temperature: 25 °C, Shear Rate: 40 s ⁻¹	2,600
Vertical Sag Resistance, 25 °C, ISO 16862, µm:	<100
Flash Point - See SDS	

TYPICAL CURING PERFORMANCE

Pot life (200 g mass), ISO 9514, minutes:	40
Recoat time, @ 25 °C ISO 4587, hours:	1 to 4

Surface Drying Time - ISO 1517

@ 5 °C, hours	50
@ 15 °C, hours	5
@ 22 °C, hours	3.5
@ 35 °C, minutes	110
@ 45 °C, minutes	60

TYPICAL PROPERTIES OF CURED MATERIAL

Cured for 7 days @ 22 °C

Physical Properties:

Glass Transition Temperature, °C: (Tg) by TMA ISO 11359-2	77
Coefficient of Thermal Expansion, ISO 11359-2 K ⁻¹ : Below Tg	70×10 ⁻⁶
Above Tg	244×10 ⁻⁶
Shore Hardness, ISO 868, Durometer D	83
Compressive Strength, ISO 604	N/mm ² 110 (psi) (16,000)
Compressive Modulus, ISO 604	N/mm ² 1,725 (psi) (250,000)

TYPICAL PERFORMANCE OF CURED MATERIAL

Cured for 7 days @ 22 °C

Lap Shear Strength, ISO 4587: Mild Steel (grit blasted)	N/mm ² 21 (psi) (3,050)
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TYPICAL ENVIRONMENTAL RESISTANCE

Cured for 7 days @ 22 °C

Chemical Resistance

Tables below show chemical resistance @ 22°C. Tested on product specimens, immersed up to 1,000 hours @ 22°C in fluids indicated.

Acids

10 % hydrochloric	Continuous long term immersion
36 % hydrochloric	Spill, splash with immediate cleanup
10 % sulphuric	Short term or intermittent immersion
10 % nitric	Short term or intermittent immersion
5 % phosphoric	Short term or intermittent immersion

Alkalis

40 % sodium hydroxide	Continuous long term immersion
25 % ammonium hydroxide	Continuous long term immersion
36 % ammonium sulphate	Continuous long term immersion
30 % hydrogen peroxide	Short term or intermittent immersion

Solvents

Deionized Water	Continuous long term immersion
10% Salt Water	Continuous long term immersion
Methanol	Spill, splash with immediate cleanup
Methylethylketone (MEK)	Spill, splash with immediate cleanup
Xylene	Short term or intermittent immersion

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).

Clean-up

1. Immediately after use clean tools with suitable cleaner, e.g. Terostat® 8550 or a solvent such as acetone or isopropyl alcohol. Once cured, the material can only be removed mechanically.

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. Material removed from containers may be contaminated during use. Do not return liquid to original container. 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.

Henkel cannot assume responsibility for product which has been contaminated or stored under conditions other than those recommended. If additional information is required, please contact your local Technical Service Center or Customer Service Representative.

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.

- Remove dirt, oil, grease etc with a suitable cleaner, e.g. high pressure water cleaning system using Loctite® 7840™ or Loctite® Natural Blue® cleaner/degreaser.
- 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.
- 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.

- After blasting, metal surfaces should be cleaned, e.g. with Loctite® 7063™ or Loctite® ODC Free Cleaner and Degreaser, and be coated before any oxidation or contamination takes place.
- 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:

- Film thickness per coat: 75 to 100 microns (3 to 4 mils). Minimum of 2 coats is recommended to avoid any pin holes.
- Ambient and substrate temperature range: 15 to 30 °C (59 to 86 °F)
- Relative humidity: <85 %; substrate temperature must always be 3 °C (~5 °F) higher than the dew point.
- Suggested Spray Equipment:
 - HPLV spray system with a pressurized pot at 1 bar (14 psi) and inlet air pressure at 6 bar (87 psi) (Recommended for the 1kg (2.2 lb) kit)
 - Two component no premix equipment (Recommended for the 30 kg (66 lb) kit)

Multiple coat application may be carried out, once the film has gelled, but not cured beyond the maximum recoat time. If this time has elapsed, light abrasive blasting is required, followed by a solvent wash to remove any abrasive residues.

Coverage rate

To achieve a 100 micron (4 mil) thickness (1 coat), the coverage rate will be 8.2 m² / kg (40 ft² / lb), excluding overthicknesses, outpattern sprayed product, etc

Inspection

- Visually inspect for pinholes and misses just after application.
- Once the coating has cured, repeat visual inspection to confirm freedom 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.

Repairs

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

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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Henkel Americas
+860.571.5100

Henkel Europe
+49.89.320800.1800

Henkel Asia Pacific
+86.21.2891.8859

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