Technical Data Sheet

LOCTITE® PC 7363

Known as LOCTITE® Nordbak® Ceramic Tile Adhesive
November 2015

PRODUCT DESCRIPTION

LOCTITE® PC 7363 provides the following product characteristics:

Technology	Epoxy
Chemical Type	Epoxy
Appearance (Resin)	Off-white[LMS]
Appearance (Hardener)	Off-white[LMS]
Appearance (Mixture)	White to grayish paste
Components	Two component - requires mixing
Mix Ratio, by volume - Resin : Hardener	1 : 1
Mix Ratio, by weight - Resin : Hardener	1 : 1.25
Cure	Room temperature cure
Application	Bonding
Specific Application	• Bonding ceramic tiles • Pact holes in pressure systems • Secure vertical anchor bolts • General purpose bonding
Specific Benefit	• Non-sag paste - allows application versatility for overhead and vertical surfaces • Easy to mix and use • Will not break or chip - withstands shock and impact • Adheres to most clean surfaces - versatile

LOCTITE® PC 7363 is a high strength epoxy for installing ceramic tiles quickly and securely. This two-component material is suitable for both horizontal and vertical applications and has excellent shock and impact resistance under typical dry service temperatures -29 °C to +93 °C.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Resin:

Weight Per Gallon, lbs/gal	12.1 to 12.9[LMS]
Viscosity, Brookfield - RV, 25 °C, mPa·s (cP):	
Spindle TF, speed 2.5 rpm	1,800,000 to 2,700,000[LMS]

Hardener:

Weight Per Gallon, lbs/gal	15.2 to 16.0[LMS]

Mixed:

Coverage	1.6 m² @ 0.32 cm thick/9.1 kg (20 ft² @ 0.125 in thick/20 lb)

TYPICAL CURING PERFORMANCE

Curing Properties

Gel Time @ 70 °C, minutes:	
100 g mass	12 to 22[LMS]
Cure Time @ 25 °C, hours	12
Working Time @ 25 °C, minutes	60

TYPICAL PROPERTIES OF CURED MATERIAL

Cured @ 25 °C

Physical Properties:

Shore Hardness, ISO 868, Durometer D		88
Compressive Strength, ISO 604	N/mm²	96.6
	(psi)	(14,000)

TYPICAL PERFORMANCE OF CURED MATERIAL

Adhesive Properties

Cured @ 25 °C

Lap Shear Strength, ISO 4587:

Aluminum (acid etched):

0.125 mm gap	N/mm²	34.5
	(psi)	(5,000)

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:

1. Ceramic tiles have the required surface roughness for high adhesion. Remove any dust or dirt with dry, oil free compressed air.
2. Mating metal surfaces need to be roughened by clean grit blasting or grinding. This is also recommended as a primary preparation step to remove oils, paint, coatings and corrosion. If possible, it is recommended that the metal surface be grit blasted to a near white metal ((SSPC-SP10/NACE No. 2) standard.
3. Once blasted or ground, flush the metal surface with an organic solvent or alternatively wipe surface with an organic solvent soaked lint-free wipe to remove particulates.
4. To avoid flash rust on metal, ensure the surface is at least 5°C above the dew point temperature.

Mixing:

1. Measure 1 part resin to 1 part hardener by volume or weight, transfer entire kit onto a clean and dry mixing surface and mix together until uniform in color.
2. If resin and hardener temperatures are 15 °C or below,

preheat resin only to about 32 °C but not to exceed 38 °C.

3. Apply adhesive to both surfaces and immediately press in place to push out air.

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).

Loctite Material Specification[LMS]

LMS dated July 2, 2002 (Resin) and LMS dated July 2, 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.

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

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.

Reference 1.4