

## LOCTITE® PC 7393

Known as LOCTITE® Fixmaster® Rapid Rubber Repair Kit  
May 2015

### PRODUCT DESCRIPTION

LOCTITE® PC 7393 provides the following product characteristics:

<b>Technology</b>	Urethane
Appearance - Part A	Brown liquid
Appearance - Part B	Opaque white
Components	Two component - requires mixing
Mix Ratio, by volume - Resin : Hardener	1 : 1
<b>Cure</b>	Room temperature cure
<b>Application</b>	Belt repair
Specific Benefit	<ul style="list-style-type: none"> <li>• Easy to Use</li> <li>• Fast curing</li> <li>• Waterproof</li> <li>• Highly flexible</li> <li>• High peel strength</li> <li>• Excellent adhesion</li> <li>• Excellent tear strength</li> <li>• Outstanding tensile strength</li> <li>• Will not fracture under stress</li> </ul>

LOCTITE® PC 7393 is designed to repair rubber, urethane, PVC, and other parts quickly and durably. Unique for its exceptional handling, curing and performance properties, LOCTITE® PC 7393 has the added advantage of the newest and most convenient packaging available. This high performance urethane was developed to repair critical operating equipment faster, more reliably and with greater ease than ever before. LOCTITE® PC 7393 is an adhesive, sealant and repair compound all in one convenient, self-mixing system. The system's no-measure, self-mixing features make it extremely convenient for fast, on-site repairs, especially to conveyor belts and other rubber parts exposed to weather and extreme wear. Extremely tough and fast curing, it forms permanent bonds to rubber, urethane, PVC, metal, glass, masonry and plastics. Typical applications include repairing or rebuilding rubber liners in mills, pumps, feeder bowls, hoppers, chutes, fans, and repairing cast urethane screens and liners. This product is typically used in applications with an operating range of -29 °C to +82 °C.

### TYPICAL PROPERTIES OF UNCURED MATERIAL

#### Part A:

Weight per volume	kg/L	1.14 to 1.16
	(lbs/gal)	(9.45 to 9.65)

Viscosity, Brookfield - RV, 25 °C, mPa·s (cP):

Spindle 3, speed 20, rpm, 5,000 to 9,000

#### Part B:

Weight per volume	kg/L	1.04 to 1.07
	(lbs/gal)	(8.65 to 8.9)

Viscosity, Brookfield - RVDV, 25 °C, mPa·s (cP):

Spindle 4, speed 20, rpm, 7,500 to 9,000

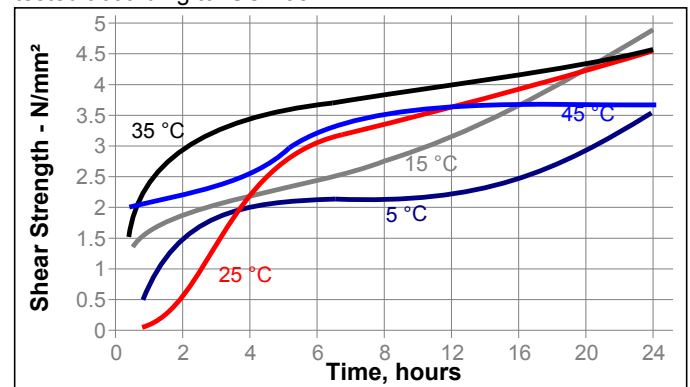
### TYPICAL CURING PERFORMANCE

#### Curing Properties

Cure Time @ 25 °C, hours	2
Gel Time @ 25 °C, seconds	55 to 60

#### Cure Speed vs. Temperature

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



### TYPICAL PROPERTIES OF CURED MATERIAL

Cured @ 25 °C except where noted

#### Physical Properties:

Abrasion Resistance, ASTM D4060: mg	5.4
1 Kg load, CS-10 wheels, Weight of Material Lost	
Shore Hardness, ISO 868, Shore A	86
Coefficient of Thermal Conductivity ASTM F 433, W/(m·K)	0.18

Glass Transition Temperature, ASTM E 1640, °C ≤-50  
 Coefficient of Thermal Expansion, ISO 11359-2, K<sup>-1</sup> 165×10<sup>06</sup>

**Electrical Properties:**

Volume Resistivity, IEC 60093, ohm-cm 1.2×10<sup>12</sup>  
 Surface Resistivity, IEC 60093, ohms 196×10<sup>12</sup>

**TYPICAL PERFORMANCE OF CURED MATERIAL****Shear Strength:**

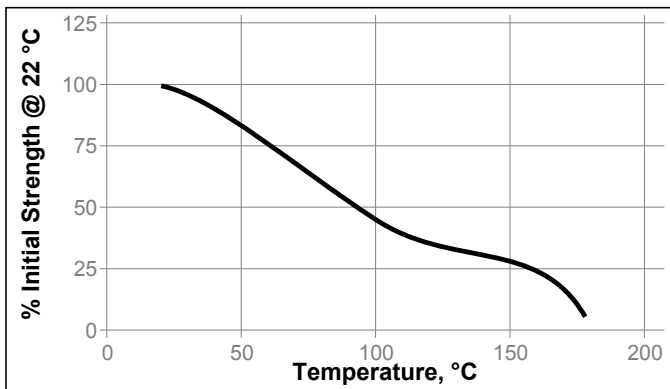
Lap Shear Strength, ISO 4587:  
 Grit Blasted Mild Steel (GBMS) N/mm<sup>2</sup> 3.7  
 (psi) (540)

**TYPICAL ENVIRONMENTAL RESISTANCE**

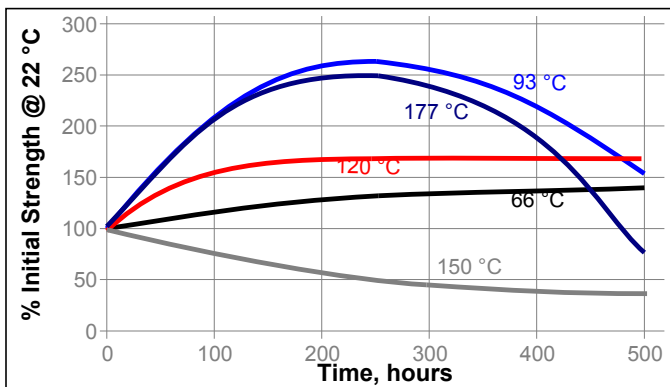
Cured for 72 hours @ 21 °C

**Shear Strength:**

Lap Shear Strength, ISO 4587:  
 Grit Blasted Mild Steel (GBMS)

**Hot Strength****Heat Aging**

Aged at temperature indicated and tested @ 22 °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:**

1. Aggressively clean surfaces to be repaired with Loctite® Fixmaster® Flex Cleaner and abrasive pad. If possible, use wire brush with cleaner.
2. Insert the cartridge into the application gun and start the plunger into the cylinders using light pressure on the trigger. Next, remove the cartridge cap and expel a small amount of adhesive to be sure both sides are flowing evenly and freely. Attach the static mixing nozzle to the end of the cartridge and begin dispensing the adhesive. Purge and dispose of the first 3 - 8 cm from the end of the mix nozzle, as it may not be sufficiently mixed..
3. Work quickly as material will begin to cure in static mixer.
4. Work the urethane onto the substrate to allow maximum surface contact and adhesion.
5. It is not necessary to use all the urethane in the cartridge in one application. Leave the static mixer on the cartridge when application is complete. The mixer serves as a seal and should be discarded and replaced with a fresh mixer for the next application.
6. **NOTE: LOCTITE® PC 7393 cures very quickly at high temperatures, reducing adequate working time and possibly causing premature curing. When applying LOCTITE® PC 7393 at temperatures above 25°C or to a warm surface, refrigerate material thoroughly before making the application. DO NOT REFRIGERATE CLEANER.**

**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/mm<sup>2</sup> 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

**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 0.1