

LOCTITE® SF 7693

Known as LOCTITE® Cold Galvanizing Compound
December 2014

PRODUCT DESCRIPTION

LOCTITE® SF 7693 provides the following product characteristics:

Technology	Epoxy
Chemical Type	Epoxy resin
Appearance (uncured)	Gray liquid
Cure	Air dry
Application	Coating
Specific Benefit	<ul style="list-style-type: none">• Excellent adhesion• Contains no CFC's• Does not contain methylene chloride• Resistant to salt corrosion and water• Easily sprayed onto all metal surfaces• Flexible coating - will not yellow, chalk, crack or peel

LOCTITE® SF 7693 is a liquid aerosol compound containing 92% zinc in the dried film. Electrochemically bonds zinc to iron and steel to protect against rust and corrosion creepage. It provides protection better than or equal to hot dip galvanizing and is an ideal touch up for damaged, galvanizing metals and welded seams. It may be topcoated with conventional metal primers or finish coats. Typical applications include fabricated metal, welds, structural steel, wrought iron, damaged galvanized surfaces, fences, gutters, guard rails, bridges, air conditioning, and refrigeration units. It also provides general maintenance of metal structures, equipment and machinery in: food plants, refineries, power plants, highways, transmission towers, marine, utility, farm, metal fabricating and structural iron industries.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Specific Gravity @ 25 °C 1.16
Flash Point - See SDS

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. Surface Preparation:

1. Proper surface preparation contributes to maximum service life of coatings. All contaminants (mill scale, rust, rust scale, chemicals, grease, oil, wax, weld splatter, old paint or other foreign matter) must be removed down to bare metal.
2. New Galvanized Metal:
Oils, greases, and waxes may be removed with mineral spirits or xylol. Stronger aromatic solvents such as xylol are recommended to remove silicone surface treatments. Silicates or white rust should be removed by sanding or sweep-blast. Do not use acetic acid or vinegar for surface preparation of galvanized metal. Keep surfaces free of moisture until coated with LOCTITE® SF 7693. Spot reblast to remove any contamination - solvent wiping is not satisfactory.
3. Previously Coated Surfaces:
If coated surface has been scratched or penetrated to expose substrate, it should be treated as new galvanized metal. Previously coated surfaces in good condition should be treated to ensure a clean, dry surface, free of contaminants.
4. Metal (iron or steel):
Round off all rough welds, rivet heads and weld splatters. There are several methods of surface preparation depending upon the surface condition of the metal. Contaminants may be removed by wire brushing, chipping, scraping or sanding. If more effective cleaning is needed, power tools can be used. Mill scale may be removed with acid. After treatment, surface must be rinsed thoroughly. Grease and other soluble materials can be removed with solvents such as mineral spirits or by steam cleaning. If surface is particularly contaminated, several different methods of sand-blasting could be used.

2. Application Method:

1. Shake can well until agitator ball is free (approximately 2 minutes). Continue to shake can during use.
2. Best results are obtained when sprayed above 15°C. Spray from a distance of 30 to 40 cm. Apply a heavy, wet coat to obtain proper thickness with bare areas or pinholes. Double lap spray all welds, corners, edges, etc.
3. When finished spraying, clear valve by turning can upside down and pressing button. If clogging occurs, remove button and clean slot and orifice with fine wire.

4. NOTE: Not recommended for immersion in acid or alkaline solutions or in areas where these solutions might be spilled.

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

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

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 0.2