



LOCTITE® PC 7222

March 2017

Product description

LOCTITE® PC 7222 provides the following product characteristics:

Technology	Epoxy
Chemical type	Epoxy
Appearance (resin)	Grey viscous liquid
Appearance (hardener)	Grey
Appearance (Mixed)	Gray paste
Components	Two components - requires mixing
Mix Ratio, by weight -Part A: Part B	2 : 1
Mix Ratio, by volume -Part A: Part B	2 : 1
Cure	Room temperature cure
Application	North America - Metal repair
Specific benefits	• Non sag - provides abrasion resistance on over-head and vertical surfaces • Renews worn surfaces fast - reduces downtime • Small ceramic bead filled - resists fine particle sliding abrasion, prolongs equipment life

LOCTITE® PC 7222 contains ceramic fibers, giving this trowelable putty excellent wear and abrasion resistance with a smooth, low friction finish. It is ideal for filling pits and other irregularities in metal surfaces. This product is typically used in applications with an operating range of -30°C to 105°C (-20°F to 225°F). Typical applications include providing a smooth, protective abrasion resistant coating, on or in pipes, pumps elbows, transitions, butterfly valves, deflection plates, turbine blades and tanks.

Typical properties of uncured material

Resin:

Density @ 21°C	1.64
Viscosity, brookfield - RVDV, 25°C, mPa·s (cP):	1,300,000 to 2,200,000
Spindle TF, speed 2.5 rpm	

Hardener:

Density @ 21°C	1.77
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Mixed properties:

Density @ 21°C	1.72
Flash point - see SDS	

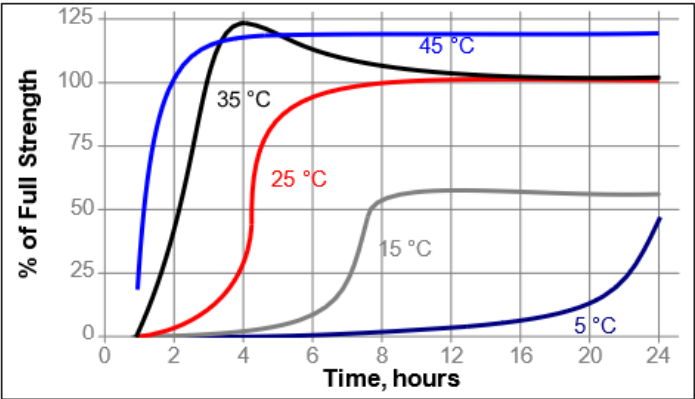
Typical curing performance

Curing properties

Gel time @25°C, minutes	45 to 55
Working life, minutes	30

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:

Tensile strength, ISO 527-2	N/mm ² (psi)	21 (3,020)
Tensile modulus, ASTM D638	N/mm ² (psi)	11380 (1,650,420)
Compressive strength, ISO 604	N/mm ² (psi)	72 (10,360)
Compressive modulus, ISO 604	N/mm ² (psi)	6780 (983,480)
Flexural strength , ASTM D790	N/mm ² (psi)	60 (8,730)
Flexural modulus	N/mm ² (psi)	3940 (571,400)



Shore hardness, ISO 868 , Shore D	85
Glass Transition Temperature, ASTM E 1640, °C	66
Coefficient of thermal conductivity ASTM F 433, W/(m·K)	0.83
Elongation, ISO 527-2, %	0.34
Volume shrinkage, %	4.5
Coefficient of thermal expansion, ISO 11359-2, K ⁻¹	
Below Tg	34×10 ⁻⁰⁶
Above Tg	107×10 ⁻⁰⁶
Abrasion resistance, ASTM D4060: mg	74
1 kg load, CS-10 wheels, weight of material lost	

Electrical properties:

Volume resistivity, IEC 60093, Ω·cm	0.72×10 ¹⁵
Surface resistivity, IEC 60093, Ω	1.7×10 ¹⁵

Typical performance of cured material**Shear strength**

Lap shear strength:

Grit blasted mild steel (GBMS)	N/mm ² (psi)	16.8 (2,440)
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Typical environmental resistance

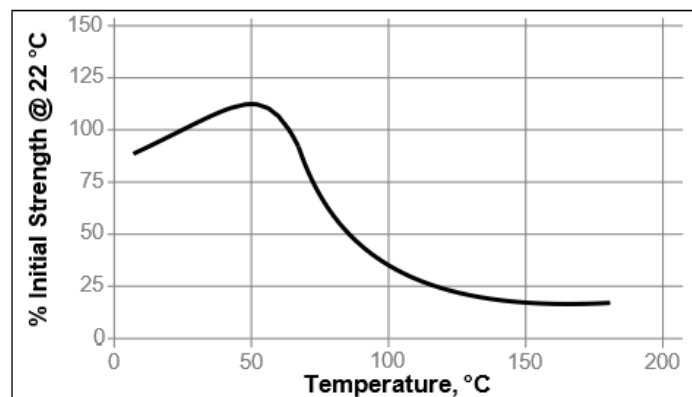
Cured for 72 hours @ 21 °C

Lap shear strength:

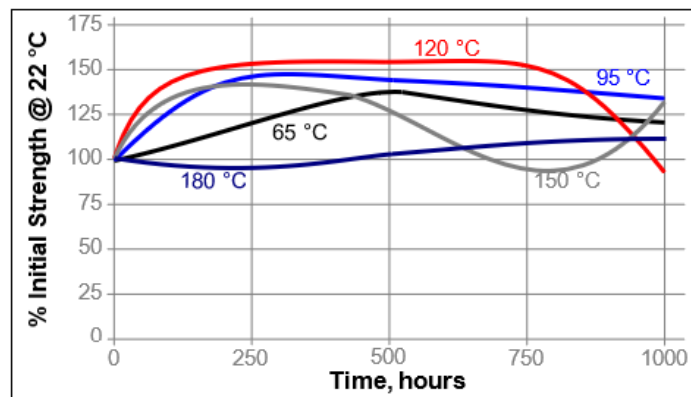
Grit blasted mild steel (GBMS)

Hot strength

Tested at temperature

**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 Material Safety Data Sheet.

Surface preparation

Proper surface preparation is critical to the long-term performance of this product.

Directions for use

1. Remove dirt, oil, grease, etc. with a suitable cleaner, e.g. high pressure water cleaning system using Loctite® SF 7840™ (Loctite® Natural Blue® cleaner/degreaser).
2. Blast all surfaces to be coated with a sharp edged angular grit to a depth of profile of to microns and a degree of cleanliness of Near White Metal (SIS SA 2½ /SSPC-SP 10).
3. After blasting, metal surfaces should be cleaned with waterless cleaner, e.g. with Loctite® SF 7611™ (Loctite® Pro Strength Parts Cleaner), and be coated before any oxidation or contamination takes place.
4. Metal that has been in contact with salt solutions, e.g. seawater, should be grit blasted, high-pressure water blasted, and 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

1. Mix resin and hardener according to mix ratios listed or transfer entire kit onto a clean and dry mixing surface and mix material vigorously until a uniform color is obtained.
 2. Apply material to prepared surface by first forcing a thin layer deep into the texture of the substrate.
 3. Then immediately build up to the desired finished thickness.
- If using to rebuild shaft, the following applies:
 - Machine the worn area down 3mm (0.125 in) to produce a square shoulder on part. The material is stronger with a square edge versus a feathered edge.
 - Machine a spiral cut in bottom of area to be repaired to provide mechanical keying into surface.
 - Apply excess product to ensure small shrinkage during cure does not produce depression.
 - Machine the surface to original dimensions prior to full cure, as the product is very wear resistant.

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.

Coverage

To achieve a 6 mm (.25 in) thickness, the coverage rate will be 342cm² (53in²) for 0.45kg (1lb), 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. Loctite® 7070™ or a solvent such as acetone or isopropyl alcohol. Once cured, the material can only be removed mechanically.

Technical tips for working with epoxies

Environmental conditions

- Relative humidity: <85%
- Ambient temperature: >15°C (60°F) and rising
- Substrate temperature must always be 3°C (7°F) higher than the dew point to avoid condensing moisture on parts.

Working time and cure speed 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 the specifications of this product.

Storage

Store product in the unopened container in a dry location. Storage information may be indicated on the product package labeling.

Optimal storage: 8 - 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

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

Disclaimer

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Reference 0.2

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