

PRODUCT DESCRIPTION

LOCTITE® PC 9331 Low Odor Wearing Compound is a two-compound epoxy designed to protect, rebuild, and repair high wear areas of processing equipment under typical dry service temperatures of -28° to +121°C (-20° to +250°F). Ceramic-filled for outstanding resistance to abrasion and corrosion. LOCTITE® PC 9331 is recommended for protecting and rebuilding chutes, pumps, pipe elbows, cyclones, and other material handling equipment.

Advantages:

- Renews worn surfaces fast - reduces downtime
- Extends wear life-resists sliding abrasive wear and eliminates costly wear part inventory
- Won't sag or shrink - provides abrasion resistance on overhead and irregular surfaces
- Easy mix and use

TYPICAL APPLICATIONS

- Transport elbows and transitions
- Cyclone and separator bodies
- Dust collectors and exhausters
- Pump liners and impellers
- Fan blades and housings
- Chute linings and hoppers
- Scrubbers
- Transition points
- Hoppers

PROPERTIES OF UNCURED MIXED MATERIAL

	Typical Value
Appearance	Thick Grey Paste
Mix Ratio (R:H) by Volume	2:1
by Weight	2:1
Coverage	0.8m ² @.63 cm thick per 25 lb 8.75 ft ² @ 1'4" thick per 25 lb

TYPICAL CURING PERFORMANCE

(@ 25°C unless noted)

Curing Properties	Typical Value
Working Life, minutes	30
Cure Time, hours	7

TYPICAL PROPERTIES OF CURED MATERIAL

(@ 25°C unless noted)

Physical Properties	Typical Value
Compressive Strength, ASTM D695, psi (N/mm ²)	16,000 (110.3)
Hardness ASTM D-2240, Shore D	90

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, (MSDS).

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.

1. On all vertical or overhead applications, tack welding expanded metal mesh onto the metal substrate is strongly recommended prior to application. LOCTITE® PC 9331 Clean, dry and abrade application surface. The more thorough the degree of surface preparation the better the performance of the application. If possible, it is recommended that the surface be grit blasted to a Near White Metal (SSPC-SP10/NACE No. 2) Standard. For less severe applications roughening the surface with hand tools is suitable.
2. Solvent cleaning with a residue-free solvent is recommended as the final step to aid in adhesion.

Mixing:

- Measure 2 parts resin to 1 part hardener by volume or transfer entire kit onto a clean and dry mixing surface and mix together until uniform in color. (If resin and hardener temperatures are 15°C (60°F) or below, preheat resin only to about 32°C (90°F) but not to exceed 38°C (100°F)

Application:

1. Apply fully mixed material to the prepared surface.
2. Initially apply the material in a very thin layer to "wet" out the surface and avoid air entrapment.
3. Apply the material to a minimum thickness of ¼"
4. At 25°C (77°F) the working time is 30 minutes. Working and cure time depend on temperature and mass; the higher the temperature, the larger the mass, the faster the cure.
5. Functional cure time is 7 hours at 25°C (77°F)
6. Caution! Use approved, positive-pressure, supplied-air respirator when welding or torch cutting near cured compound. Use approved self-contained breathing apparatus when burning, welding, or torch cutting indoors near cured compound. Use approved respirator for dusts and mists when grinding or machining cured compound. DO NOT use open flame on compound. See other cautions on Material Safety Data Sheet.

TECHNICAL TIPS FOR WORKING WITH EPOXIES**Working time and cure time depends on temperature and mass:**

- The higher the temperature, the faster the cure.
- The larger the mass of material mixed, 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).

Storage

Product shall be ideally stored in a cool, dry location in unopened containers at a temperature between 8°C to 28°C (46°F to 82°F) unless otherwise labeled. Optimal storage is at the lower half of this temperature range. To prevent contamination of unused product, do not return any material to its original container. For further specific shelf life information, contact your local Technical Service Center.

Data Ranges

The data contained herein may be reported as a typical value and/or range. Values are based on actual test data and are

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.

Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

In case products are delivered by Henkel Corporation, Resin Technology Group, Inc., or Henkel Canada, Inc. the following disclaimer is applicable:

The data contained herein are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and

use thereof. In light of the foregoing, **Henkel Corporation specifically disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Henkel Corporation's products. Henkel Corporation specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits.** The discussion herein of various processes or compositions is not to be interpreted as representation that they are free from domination of patents owned by others or as a license under any Henkel Corporation patents that may cover such processes or compositions. We recommend that each prospective user test his proposed application before repetitive use, using this data as a guide. This product may be covered by one or more United States or foreign patents or patent applications.

In case products are delivered by Henkel Belgium NV, Henkel

Electronic Materials NV, Henkel Nederland BV, Henkel Technologies

France SAS and Henkel France SA please additionally note the

following:

In case Henkel would be nevertheless held liable, on whatever legal ground, Henkel's liability will in no event exceed the amount of the concerned delivery.

In case products are delivered by Henkel Colombiana, S.A.S. the

following disclaimer is applicable:

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. Henkel is 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.

Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

Trademark usage

Except as otherwise noted, all trademarks in this document are trademarks of Henkel Corporation in the U.S. and elsewhere. ® denotes a trademark registered in the U.S. Patent and Trademark Office.