Technical Data Sheet

LOCTITE® PC 6330™

Known as LOCTITE® Fixmaster® Epoxy Floor Resurfacer™
September 2015

PRODUCT DESCRIPTION

LOCTITE® PC 6330™ provides the following product characteristics:

Technology	Epoxy
Chemical Type	Epoxy
Appearance (uncured)	Grey Liquid
Components	Three components - requires mixing
Mix Ratio, by volume - Resin : Hardener to Filler	2 : 1 to 3.3
Mix Ratio, by weight - Resin : Hardener to Filler	2.2 : 1 to 5
Cure	Room temperature cure
Application	Flooring
Specific Benefit	• Withstands extreme thermal shock, including steam cleaning • High compressive strength • Excellent chemical resistance against CIP cleaners, most inorganic acids, caustics, lubricants and some solvents • Less likely to crack under thermal shock and impact compared to harder, more brittle epoxies

LOCTITE® PC 6330™ is a trowel applied epoxy surfacing and leveling system. It is a three-part, flexible epoxy flooring material, normally applied over concrete, with excellent chemical and thermal shock resistance. Typical application areas include warehouses, shipping and receiving areas, production facilities, utility rooms, meat and poultry plants, dairies, citrus and bottling plants.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Resin:

Weight per volume	kg/L (lbs/gal)	1.14 (9.5)
Viscosity @ 25°C, mPa·s (cP)		700
Flash Point - See SDS		

Hardener:

Weight per volume	kg/L (lbs/gal)	1.03 (8.6)
Viscosity @ 25°C, mPa·s (cP)		300
Flash Point - See SDS		

Mixed:

Weight per volume	kg/L (lbs/gal)	1.11 (9.2)
Viscosity @ 25°C, mPa·s (cP)		630
Coverage	2.5 m² per 0.6 cm thickness (27 ft² per 0.25 in thickness)	
Flash Point - See SDS		

TYPICAL CURING PERFORMANCE

Curing Times

Property	**10°C(50F)**	**21°C(70F)**	**32°C(90F)**
Pot Life	60 min	50 min	25 min
Working time	120 min	100 min	80 min
Tack Free time	14 hrs	6 hrs	4 hrs
Hard Foot Traffic	60 hrs	20 hrs	10 hrs
Hard Truck Traffic	72 hrs	28 hrs	14 hrs

TYPICAL PROPERTIES OF CURED MATERIAL

Physical Properties:

Shore Hardness, ISO 868		75
Water Vapor Transmission Rate, ASTM E96, perms		0.03
Water absorption, ASTM D570, 24 hrs @ 23°C, %		0.3
Coefficient of Thermal Expansion, ISO 11359-2, K^{-1}:		
Below Tg		1.7×10^{-05}
Elongation, filled, ASTM C-307, %		3
Elongation, unfilled, ISO 527-2, %		10
Tensile Strength, ASTM C-307		
Compressive Strength, ISO 604	N/mm² (psi)	36 (5,170)
Flexural strength , ASTM D790	N/mm² (psi)	18 (2,550)

TYPICAL PERFORMANCE OF CURED MATERIAL

Bond Strength to Quarry Tile	N/mm² (psi)	>6.9 (>1,000)
Gardener Impact, ISO 6272-2	N·m (lb·in)	>18 (>160)

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. New concrete must be firm, clean, and free of any adverse moisture conditions. The surface must have an appropriate surface profile and be well-cured (30 days at temperatures over 21°C). Shot blasting, mechanical scarification, chemical means or sandblasting should be used to prepare the substrate. The substrate should have a pH of about 7.
2. New concrete should be allowed to cure for 28 days; however, if shorter times are required, a plastic shet test and calcium chloride test should be performed.
3. Older, uncoated concrete is prepared in the same manner as new concrete. Before preparation, the concrete must be thoroughly cleaned with a strong detergent cleaner to remove all grease and oils. All loose concrete must be removed.
4. Previously painted surfaces should be completely stripped of peeling or degraded paint.
5. Wood surface must be clean and sound. Remove any oils and dirt from the surface using a degreasing solvent or strong detergent.

Mixing:

1. Mix Part A and Part B components at slow speeds (<700 rpm) with a Jiffy® style mixer for at least thirty seconds, until uniform in color.
2. Add aggregate and tint and mix for another 30 seconds or until uniform in color and consistency.
3. Do not mix less than the prescribed amount and do not add any solvent.

Application:

1. The prepared mix may be applied by a screed box or bar to a 0.6 cm (0.25 inch) thickness and allowed to set for several minutes, before finish trowelling with a power trowel or by hand.
2. Do not over trowel.
3. Trowelling may be enhanced by using isopropyl alcohol sprayed lightly on the trowel.
4. After finish trowelling, the finish may be back-rolled with a short nap roller dipped in isopropyl alcohol to remove light trowel marks and to bring the resin to the surface.
5. A suitable aggregate can be broadcast into the floor resurfacer to provide a more antislip profile. Typical aggregate size used for antislip properties is 30-50 mesh silica sand. Exact size to be determined based on user requirements.

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).

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. 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.

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

Note:
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Reference 0.1