

LOCTITE® PC 7516

Known as LOCTITE® Nordbak® Trowel Mix
January 2016

PRODUCT DESCRIPTION

LOCTITE® PC 7516 provides the following product characteristics:

Technology	Epoxy
Chemical Type	Epoxy
Appearance (uncured)	Brown paste
Components	Two component - requires mixing
Cure	Room temperature cure
Application	Crusher repair products
Mix Ratio, by volume - Resin : Hardener	4 : 1
Mix Ratio, by weight - Resin : Hardener	4 : 1
Specific Benefit	• 100 % solids epoxy system • Reduces downtime • Tough and resilient • Eliminates dismantling process

LOCTITE® PC 7516 is a 100% solids epoxy paste that is ideal for backing mill liners in all types of mills under typical dry service temperatures of -30 to 80 °C (-20 to 180 °F). Its paste-like consistency eliminates the need for dismantling the mill or removing the grinding charge. It trowels easily in place in any area of a mill where backing material is required. It is particularly useful in backing head liners, division heads, and diaphragms. LOCTITE® PC 7516 also secures liner bolts in their holes.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Mixed:

Coverage	1.7 m ² per 18 kg kit (18 ft ² per 40 lb kit)
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TYPICAL CURING PERFORMANCE

Curing Properties

Working Time @ 25 °C, minutes	15
Cure Time @ 25 °C, hours	8

TYPICAL PROPERTIES OF CURED MATERIAL

Cured @ 25 °C

Physical Properties:

Shore Hardness, ISO 868, Durometer D	90
Compressive Strength, ISO 604	N/mm ² 110 (psi) (16,000)

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:

Preparation of Metallic Parts

1. All mill liners should be free of rust, dirt grease and oil.
2. Coat shell and bolt threads with grease for easy removal of liner when worn.

Application Method:

1. Condition LOCTITE® PC 7516 and liners at at temperature of 21 to 27 °C (70 to 80 °F) before use.
2. Measure 4 parts of resin and 1 part of hardener (by volume and weight) onto a board and mix until uniform in color.
3. Position liners away from the shell with help of handling bar. Apply to back and boltholes of liner. Tightening liner against shell evenly distributes the LOCTITE® PC 7516 between the two surfaces.
4. Finish by troweling material into openings between liners. It is recommended that metal flats be inserted into these spaces.
5. Immediately clean any contaminated skin or clothing with soap and water.
6. Commercial solvents such as acetone, xylene methyl ethyl ketone or isopropyl alcohol can be used to clean equipment before it cures.

Caution: Use a NIOSH-approved positive pressure supplied-air respirator when burning, welding, or torch cutting outdoors on or near cured compound. Use NIOSH-approved respirator for dusts and mists when grinding or machining cured compound

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

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

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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