

LOCTITE[®] PC 6291[™]

Known as LOCTITE[®] Fixmaster[®] Crack Filler
January 2015

PRODUCT DESCRIPTION

LOCTITE[®] PC 6291[™] provides the following product characteristics:

Technology	Epoxy
Appearance (Mixture)	Gray liquid
Cure	Room temperature cure after mixing
Components	Three components - requires mixing
Application	Repair
Specific Benefit	• Easily mixed with a drill and mixing blade • 100 % solids epoxy system • No solvents • Excellent workability • Low shrinkage properties • One coat coverage

LOCTITE[®] PC 6291[™] is a three-component system consisting of a two-part 100% solids epoxy and an aggregate and is designed for filling cracks, pinholes and anchor bolt holes. This product can also be used as a skim coat for mildly spalled areas, sealing and smoothing. This product can be applied to vertical and horizontal surfaces. LOCTITE[®] PC 6291[™] is low odor and adheres well to damp as well as dry concrete and masonry surfaces. This product is recommended for use as one-coat coverage for properly prepared surfaces of concrete, masonry, wood and previously coated surfaces. Typical applications areas include warehouses, production facilities, utility rooms and shipping and receiving areas.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Part A:

Weight per volume	kg/L	1.12 to 1.18
	(lbs/gal)	(9.4 to 9.8 ^{LMS})

Viscosity, Brookfield, 21 °C, mPa·s (cP):
Spindle 7., speed 50 rpm, 40,000 to 50,000^{LMS}

Part B:

Weight per volume	kg/L	0.94 to 1.0
	(lbs/gal)	(7.8 to 8.3 ^{LMS})

Viscosity, Brookfield, 21 °C, mPa·s (cP):
Spindle 1, speed 50 rpm, 20 to 30^{LMS}

Mixed:

Viscosity, Brookfield, 21 °C, mPa·s (cP):
Spindle 7, speed 50 rpm 25,000 to 35,000^{LMS}

Recoat Time @ 21 °C, hours 6 to 8
Pot life @ 21 °C, hours 2
Coverage 3.7 m² @ 0.32 cm thick/11.4 liters
(40 ft² @ 0.125 inch thick/3 gallon)

Flash Point - See SDS

TYPICAL CURING PERFORMANCE

Curing Properties

Gel Time @ 21 °C, minutes 60 to 78^{LMS}
Cure Time @ 21 °C, hours 24 to 32^{LMS}

TYPICAL PROPERTIES OF CURED MATERIAL

Cured @ 25 °C except where noted
Compressive Shear Strength, ASTM N/mm² 42.6
D-695 (ISO 604) (psi) (6,170)

Physical Properties:

Shore Hardness, ISO 868, Durometer D 80
Water Absorption, 24-hours, % 0.3
Tensile Strength, ISO 37 N/mm² 12.5
(psi) (1,810)
Elongation, ISO 37, % 10

Bond Strength to Quarry Tile N/mm² >6.9
(psi) (>1,000)

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:**1. Surface Preparation:**

- 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.
- 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.
- Previously painted surfaces should be completely stripped of peeling or degraded paint.
- Wood surface must be clean and sound. Remove any oils and dirt from the surface using a degreasing solvent or strong detergent.

2. Mixing:

- Thoroughly mix contents of can with an electric or air mixer using a Jiffy® mixing blade or equal. After premixing both components, pour contents into an appropriate sized mixing container and mix for 2 to 3 minutes until thoroughly blended.
- Once the epoxy is mixed, add small amounts of aggregate and mix thoroughly into epoxy until fully wetted. Continue to add small amounts of aggregate while mixing until all aggregate is incorporated into epoxy material
- **Note:** For 18.9 liter (5 gallon) pails, a 18.9 liter (5 gallon) Jiffy® mixer is recommended

3. Application Method:

- Apply material using a trowel or a putty knife, removing all excess material.
- For an exceptionally smooth finish, the product may be smoothed by hand using a small amount of water sprinkled onto the surface.
- If desired, the product may be sanded after 8 hours.

Loctite Material Specification^{LMS}

LMS dated August 8, 2011 (Resin) and LMS dated August 8, 2011 (Activator). Test reports for each batch are available for the indicated properties. LMS test reports include selected QC test parameters considered appropriate to specifications for customer use. Additionally, comprehensive controls are in place to assure product quality and consistency. Special customer specification requirements may be coordinated through Henkel Loctite Quality.

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

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

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