Technical Data Sheet

LOCTITE® PC 7230 L

August 2021

PRODUCT DESCRIPTION

LOCTITE® PC 7230 L provides the following product characteristics:

Technology	Epoxy
Chemical Type	Epoxy
Appearance (resin)	Paste grey
Appearance (hardener)	Paste black
Appearance (mixed)	Paste dark grey
Components	Two components – resin & hardener
Mix Ratio, by weight - resin : hardener	3.9 : 1
Mix Ratio, by volume - resin : hardener	4 : 1
Cure	Room temperature cure after mixing
Application	Coating
Application Temperature	15 to 40°C (59 to 104 °F)
Service Temperature (dry)	230°C (446 °F)
Specific Benefits	• Ceramic-filled for outstanding resistance to abrasion • Renews worn surfaces fast - reduces downtime • Extends wear life – resists sliding abrasive wear and eliminates costly wear part inventory • Non sag – provides abrasion resistance on overhead and vertical surfaces

LOCTITE® PC 7230 L is a two-component ceramic-filled epoxy paste coating that is solvent-free with increased temperature resistance (high temp products). LOCTITE® PC 7230 L is designed to protect, rebuild, and repair high wear areas of processing equipment under temperatures from -30 to 230 °C. LOCTITE® PC 7230 L requires post-curing for ultimate performance and temperature resistance. Typical applications include cyclone and separator bodies, dust collectors and exhausters, pump liners and impellers, fan blades and housings, chutes, and hoppers.

TYPICAL CURING PERFORMANCE

Cured @ 23°C, 50% RH

Gel Time, ASTM D2471, minutes	30
Cure Time, hours	7

TYPICAL PERFORMANCE OF CURED MATERIAL

Cured for 1 week @ 23°C

Physical Properties

Shore Hardness, Durometer D ISO 868		90
Compressive Strength,	N/mm² (psi)	104 (15,000)

TYPICAL ENVIRONMENTAL RESISTANCE

Dry Service Temperature Resistance, CSA-Z245.20-06/CSA-Z245.21-06 Rating 1, °C	230

Rating 1: cannot be removed cleanly
Rating 2: less than 50% can be removed

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:

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. Thoroughly clean and abrade surfaces (grit blast if possible), finally clean with Loctite 7063. The more thorough the degree of surface preparation the better the performance of the application.
2. On vertical or overhead areas, tack welding expanded metal mesh onto the metal substrate is recommended prior to application of LOCTITE® PC 7230 L High Temperature Wearing Compound.

Mixing:

1. Measure 4 parts resin to 1 part hardener by volume (3.9 to 1 by weight), transfer entire kit onto a clean and dry mixing surface and mix together until uniform in color.
2. If resin and hardener temperatures are 15°C (59ºF) or below, preheat resin only to about 30°C (86ºF) but not to exceed 40°C (104ºF).

Application:

1. Apply fully mixed material to the prepared surface.
2. Initially apply as a thin film to "wet" out the surface.
3. Build up to desired thickness (minimum 6mm(0.25in)), avoid air entrapment. .
4. At 25ºC (77ºF), the working time is 30 minutes and functional cure time is 7 hours, post cure at 150°C (302ºF) for 2 hours.

Coverage:
To achieve a 6 millimeter (0.25 in) thickness, the coverage rate will be 0.74 m² (7.96 ft²) for 10 kg (22 lb), excluding overthickness, repairs, etc.

Repairs:
Any voids, pinholes, 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 LOCTITE® solvent base cleaner. Once cured, the material can only be removed mechanically.

Storage
Store product in the unopened container in a dry location. Storage information may be indicated on the product container labeling.
Optimal Storage: below 8 to 21 °C. Storage 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.

Product Specification
The technical data contained herein are intended as reference only and are not considered specifications for the product. Product specifications are located on the Certificate of Analysis or please contact Henkel representative.

Approval and Certificate
Please contact a Henkel representative for related approval or certificate of this product.

Data Ranges
The data contained herein may be reported as a typical value. Values are based on actual test data and are verified on a periodic basis.
Temperature/Humidity Ranges: 23 °C / 50% RH = 23±2 °C / 50 ±5% RH

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

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