Technical Data Sheet

LOCTITE® PC 7350

April 2017

PRODUCT DESCRIPTION

LOCTITE® PC 7350 provides the following product characteristics:

Technology	Urethane
Chemical Type	Polyurethane resin and Isocyanate
Appearance - Part A	Brown liquid, Black
Appearance - Part B	Yellow to Amber
Appearance - Mixed	Black
Components	Two components - requires mixing
Mix Ratio, by weight - Resin : Hardener	93 : 100
Mix Ratio, by volume - Resin : Hardener	1 : 1
Cure	Room temperature cure
Application	Conveyor belt / rubber repair
Specific Benefit	• Self-leveling • Easy to Use • Fast curing • Excellent adhesion • Excellent tear strength • Highly flexible • High peel strength

LOCTITE® PC 7350 is a 100 % solid, room temperature curing 2k polyurethane compound which cures to a tough, resilient adhesive. This product is an adhesive, sealant, and repair compound that offers an excellent balance of self-leveling and fast cure. This makes this product an excellent choice for on-site repairs, such as conveyor belts and other rubber parts. Typical applications included, but are not limited to, repairing or rebuilding liners in mills, pumps, feeder bowls, hoppers, chutes, and repairing cast urethane screens and liners.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Part A:

Specific Gravity, g/cm³	1.14
Viscosity, Brookfield - RV, 25 °C, mPa·s (cP):	
Spindle 6, speed 20 rpm	10,000 to 30,000

Part B:

Specific Gravity, g/cm³	1.05
Viscosity, Brookfield - RVDV, 25 °C, mPa·s (cP):	
Spindle 4, speed 20 rpm	3,000 to 8,000

TYPICAL CURING PERFORMANCE

Curing Properties

Cure Time @ 25 °C, hours	2
Gel Time @ 25 °C, minutes	7

TYPICAL PROPERTIES OF CURED MATERIAL

Cured @ 25 °C except where noted

Physical Properties:

Hardness (Shore A), ASTM D2240		87
Tensile Strength, ISO 37	N/mm²	11
	(psi)	1,600
Elongation, ISO 37, %		275
Tear Strength, ISO 34-1	N/mm	53
	(lb./in.)	(300)

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. For best performance, bond surfaces should be clean and free from dirt, grease, and other contaminants.
2. Cut away loose and damages pieces of the belt surfaces ensuring not to cut the reinforcement fabric.
3. Abrade the repair area with an abrasive wheel or wire wheel to roughen the bond surface. Avoid overheating the belt and melting the rubber during grinding.
4. Aggressively clean the prepared surfaces with Loctite® solvent based cleaner (i.e. SF 8220 Flex Cleaner or Teroson® D) and allow to dry.
5. For maximum performance use Loctite® Fixmaster® Etching Agent and allow to dry for 30 minutes at 25°C (77F) or 60 minutes at 10°C (50F).

Mixing:

1. **Cartridges:** Insert the cartridge into the application gun and start the plunger into the cylinders using light pressure on the trigger. Next, remove the cartridge cap and expel a small amount of adhesive to be sure both sides are flowing evenly and freely. Attach the static mixing nozzle and begin dispensing adhesive.

2. Purge and dispose of the first 3 - 5 cm from the end of the mix nozzle, as it may not be sufficiently mixed.
3. Work quickly as material will begin to cure in static mixer.
4. **Cans:** Pour the hardener into the resin and mix thoroughly until uniform in color and consistency (1 - 2 minutes). Once mixed, pour out of can onto repair surface to maximize work life.

Application Method:

1. Apply the urethane onto the substrate and work in with plastic spatula to allow maximum surface contact and adhesion.
2. **Cartridges:** It is not necessary to use all the urethane in the cartridge in one application. Leave the static mixer on the cartridge when the application is complete. The mixer serves as a seal and should be discarded and replace with fresh mixer for the next application.

NOTE: LOCTITE® PC 7350 cures very quickly at high temperatures, reducing adequate working time and possibly causing premature curing.

Coverage

To achieve a 6 mm (.25 in) thickness, the coverage rate will be 567 cm² (88 in²) for 400 ml cartridges excluding overthickness, repairs, etc.

Repairs

Any voids, pinholes, or 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 suitable cleaner, e.g. Loctite® SF 7611™ or a solvent such as acetone or isopropyl alcohol. Once cured, the material can only be removed mechanically

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. 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

(°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:

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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