Technical Data Sheet

LOCTITE® PC 7352

April 2021

PRODUCT DESCRIPTION

LOCTITE® PC 7352 provides the following product characteristics:

Technology	Polyurea
Chemical Type	Polyurea
Appearance (resin)	Black liquid
Appearance (hardener)	Opaque straw yellow liquid
Appearance (mixed)	Black paste
Components	Two components – resin & hardener
Mix Ratio, by weight - Resin : Hardener	100 : 56
Application Temperature	10°C to 30˚C (50°F to 86°F)
Mix Ratio, by volume - Resin : Hardener	100 : 50
Cure	Room temperature cure after mixing
Application	Rubber repairs
Specific Benefits	• Resurfacing and repairing of worn or damaged rubber parts • Flexible • Fast curing • Application on vertical position • High abrasion resistance

LOCTITE® PC 7352 is a 100% solid, room temperature curing, two component Polyurea compound. When cured it is a tough and resilient adhesive. This product offers an excellent balance of thixotropic behavior and fast cure. Its fast cure is specially designed for on-site repairs. Typical applications include repair and rebuild conveyor belts and liners in mills, pumps, feeder bowls, hoppers, and chutes.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Resin:

Specific Gravity @ 23 °C	1.08
Viscosity, Brookfield - RVT,25°C,mPa·s (cP):	
Spindle 7, speed 20 rpm	61,000

Hardener:

Specific Gravity @ 23 °C	1.2
Viscosity, Brookfield - RVT,25°C,mPa·s (cP):	
Spindle 7, speed 20 rpm	6,700

Mixed Properties:

Specific Gravity @ 23 °C	1.12

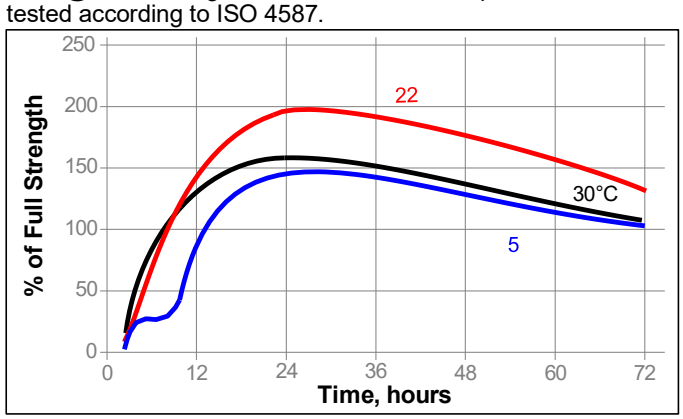
TYPICAL CURING PERFORMANCE

Cured @ 23°C, 50% RH

Gel Time, ASTM D2471, minutes	18

Cure Speed vs. Temperature

The graph below shows the shear strength developed with time @ 23°C on grit blasted mild steel lap shears and tested according to ISO 4587.



TYPICAL PERFORMANCE OF CURED MATERIAL

Cured for 1 week @23°C

Physical Properties

Shore Hardness, ISO 868, Durometer A		51
Elongation, ISO 37, %		375
Tensile Strength, ISO 37	N/mm²	14.3
	(psi)	(2,100)
Tensile Modulus, ISO 37	N/mm²	1.5
	(psi)	(220)
Tear Strength, ISO 34-1, Type 1 Specimens	N/mm²	18.2
	(psi)	(2,600)

Abrasion Properties

Taber Abrasion Resistance, ASTM D4060		
1 kg load, H-18 wheels, 1,000 cycles Weight of material lost (dry)	mg	220
1 kg load, CS 10 wheels, 1,000 cycles Weight of material lost (dry)	mg	15

Adhesive Properties

Lap Shear Strength, ISO 4587		
Grit Blasted Mild Steel	N/mm²	3.5
	(psi)	(500)
Nitrile Rubber with Etching	N/mm²	1.5
	(psi)	(220)
Neoprene with Etching	N/mm²	0.5
	(psi)	(73)

TYPICAL ENVIRONMENTAL RESISTANCE

Chemical/Solvent Resistance
Cured for 1 week @ 23ºC

Tables below show chemical resistance @ 23°C. Tested on product specimens, immersed up to 5,000 hours @ 23 °C in fluids indicated.

Acids

36 % Hydrochloric Acid	Spill, splash
10 % Nitric Acid	Spill, splash
5 % Phosphoric Acid	Continuous long term immersion
10 % Sulfuric Acid	Continuous long term immersion
36 % Ammonium Sulphate	Continuous long term immersion

Alkalis

25 % Ammonium Hydroxide	Short term or intermittent immersion

Solvents

100 % Deionized Water	Continuous long term immersion
10 % Salt Water	Continuous long term immersion
100 % MEK	Spill, splash

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).

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. Cut away loose and damaged pieces of the rubber to be repaired.
2. Remove dirt, oil, grease, etc. from rubber with a suitable cleaner, e.g. TEROSON® VR 40 or TERSON® VR 10.
3. Abrade the repair area with an abrasive wheel or wire wheel to roughen the bond surface. Avoid overheating and melting the rubber during grinding.
4. Aggressively clean the prepared surfaces with LOCTITE® solvent based cleaner (i.e. TEROSON® VR 40 or TERSON® VR 10) and allow to dry.
5. Apply LOCTITE® Etching agent on clean rubber surface with a brush.
6. Let it act for 30 minutes at 25°C or 60 minutes at 10°C.

Application
1. Insert the cartridge into the application gun and push the plunger into the cylinders using light pressure on the trigger. Then, remove the cartridge cap and expel a small amount of adhesive to be sure both sides are flowing evenly and freely. Cut a piece of the static mixing nozzle to facilitate product flow. Attach the static mixing nozzle to the end of the cartridge.
2. Purge and dispose of the first 3 to 5 cm from the end of the mix nozzle, as it may not be sufficiently mixed. Work quickly as material will begin to cure in static mixer.
3. Work the adhesive onto the substrate with a spatula to allow maximum surface contact and adhesion.
4. It is not necessary to use all the adhesive in the cartridge in one application. Leave the static mixer on the cartridge when application is complete. The mixer serves as a seal and should be discarded and replaced with a fresh mixer for the next application.

Color
1. Color variation is possible between the batches and will not affect the performance of the product.

Clean-up
1. Immediately after use clean tools with a 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: 5 to 35 °C. Storage below 0 °C or greater than 40 °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. Please contact a Henkel representative for more information.

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

Disclaimer

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