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Product Bulletin Sheet

7234 Nordbak High Temperature Brushable Ceramic Grey

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PRODUCT DESCRIPTION

Loctite 7234 Nordbak High Temperature Brushable Ceramic Grey is an ultra smooth, silicone carbide filled epoxy that provides a high gloss, low friction coating designed to protect against abrasion and cavitation, and reduce turbulence. Temperature range -30° to $+205^{\circ}\text{C}$.

Special Features:

- Silicon carbide filled – to provide maximum protection.
- Ultra-smooth brushable consistency.
- Gloss finish to reduce friction, turbulence and cavitation
- Can be used alone, or as a low friction top coat over Loctite wearing compounds
- Easy to mix and use – reduces downtime.
- Excellent adhesion – forms a permanent bond.

TYPICAL APPLICATIONS

- Providing a smooth, protective, abrasion resistant coating.
- Repairing heat exchangers and condensers.
- Lining tanks and chutes.
- Resurfacing and repairing rudders and pintel housings.
- Repairing: valve bodies, pump impellers and housings.

PROPERTIES OF UNCURED MIXED MATERIAL

	Typical Value
Appearance	Grey Flowable Liquid
Mix Ratio (R:H) by Volume	2.75:1
by Weight	4.8:1
Coverage	1.2 m ² @ .5 mm Thick per 1kg. 13 ft ² @ .020" Thick per 1kg.

TYPICAL CURING PERFORMANCE

Curing Properties

(@ 25°C unless noted)
Working Life, minutes
Cure Time, hours

Typical Value
30
See Cure Notes

TYPICAL PROPERTIES OF CURED MATERIAL

(@ 25°C unless noted)

Physical Properties	Typical Value
Maximum Operating Temperature °C	205

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 Material Safety Data Sheet, (MSDS).

DIRECTIONS FOR USE

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.

- 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.

Mixing:

Read the label directions before you begin. When using High Temperature Brushable Ceramic the entire kit must be mixed at one time. Add all hardener contents to resin container and mix vigorously until uniform in colour.

Application:

- Apply fully mixed material to the prepared surface
- High Temperature Brushable Ceramic should be brushed on 0.5 mm thick for best results.
- High Temperature Brushable Ceramic will bond securely to itself, however, be certain surface is clean, dry and in sound condition with no loose or flaky contaminants present.

Cure Cycle:

Cure time will depend on ambient temperatures. At 20°C, curing time will occur in 4 to 6 hours. The lower the temperature, the longer the cure. After compound has hardened, heat the surface to about 65°C for 30 minutes to ensure full cure and positive bonding.

For service above 150°C: Allow 8 hours cure at 23°C or higher. Then heat for at least 3 hours at 150°C, followed by 3 hours at 205°C or peak operating temperature.

If heating procedure is impossible before putting the High Temperature Brushable Ceramic into service, the following method is recommended:

- Preheat the resin to at least 40°C. Mix and apply in the manner recommend.
- Once gelled, heat the applied High Temperature Brushable Ceramic by waving a gas torch over the surface for at least one hour at 40-50°C.
- Then, using temperature crayons as indicators, raise the temperature of the coated substrate to between 150°C, and 260°C, maintain this temperature for at least 2 hours.
- The High Temperature Brushable Ceramic will then have a high enough degree of cure to begin service. It will continue to cure during normal operating temperatures until a full cure is obtained.

Storage

Product shall be ideally stored in a cool, dry location in unopened containers at a temperature between 8°C to 28°C unless otherwise labelled. Optimal storage is at the lower half of this temperature range. To prevent contamination of unused product, do not return any material to its original container. For further specific shelf life information, contact Loctite UK Technical Service.

Note

The data contained herein are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof. In light of the foregoing, **Loctite Corporation specifically disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Loctite Corporation's products. Loctite Corporation specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits.** The discussion herein of various processes or compositions is not to be interpreted as representation that they are free from domination of patents owned by others or as a license under any Loctite Corporation patents that may cover such processes or compositions. We recommend that each prospective user test his proposed application before repetitive use, using this data as a guide. One or more United States or foreign patents or patent applications may cover this product.