



LOCTITE® 7255™

April 2009

PRODUCT DESCRIPTION

LOCTITE® 7255™ provides the following product characteristics:

Technology	Epoxy
Chemical Type	Epoxy
Appearance (Resin)	Green liquid ^{LMS}
Appearance (Hardener)	Blue liquid ^{LMS}
Appearance (Mixed)	Brilliant green liquid
Components	Two part - Resin & Hardener
Mix Ratio, by volume - Resin : Hardener	100 : 50
Mix Ratio, by weight - Resin : Hardener	100 : 50
Cure	Room temperature cure after mixing
Application	Coating
Product Benefits	• Smooth sprayable consistency • Gloss finish to reduce friction, turbulence and cavitation • Excellent adhesion
Specific Application	• Resurfacing and repairing of worn or corroded metal parts • Protecting metal surfaces against abrasive and corrosive agents

LOCTITE® 7255™ sprayable ceramic is a solvent-free ceramic filled two part epoxy coating. It is designed to protect metal surfaces against abrasive and corrosive agents. It can be used as smooth, protective coating on metal surfaces or as a low friction top coat over Loctite® Nordbak® wear resistant compounds. Typical applications are repairing and protecting of heat exchangers, condensers, lining tanks, chutes, valve bodies or pump impellers and housings.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Resin

Specific Gravity @ 25 °C	1.5
Viscosity, Brookfield - DVT, 25 °C, mPa·s (cP):	
Spindle 7, speed 100 rpm	12,000
Viscosity, Plate to Plate, mPa·s (cP):	
Temperature: 25 °C, Shear Rate: 0.3 s ⁻¹	70,000 to 120,000 ^{LMS}
Temperature: 25 °C, Shear Rate: 40 s ⁻¹	3,500 to 6,500 ^{LMS}

Hardener

Specific Gravity @ 25 °C	1.5
Viscosity, Brookfield - DVT, 25 °C, mPa·s (cP):	
Spindle 7, speed 100 rpm	2,700
Viscosity, Plate to Plate, mPa·s (cP):	
Temperature: 25 °C, Shear Rate: 0.3 s ⁻¹	12,000 to 31,000 ^{LMS}
Temperature: 25 °C, Shear Rate: 40 s ⁻¹	700 to 2,000 ^{LMS}

Mixed

Specific Gravity @ 25 °C	1.5
Viscosity, Brookfield - DVT, 25 °C, mPa·s (cP):	
Spindle 7, speed 100 rpm	5,000
Vertical Sag Resistance, 25 °C, ISO 16862, µm:	700
Flash Point - See MSDS	

TYPICAL CURING PERFORMANCE

Pot life (200 g mass), ISO 9514, minutes:	40 to 70 ^{LMS}
Recoat time @ 25 °C ISO 4587 hours:	1 to 3

Surface Drying Time - ISO 1517

@ 15 °C, hours	7
@ 22 °C, hours	4
@ 35 °C, minutes	90
@ 45 °C, minutes	70

TYPICAL PROPERTIES OF CURED MATERIAL

Cured for 7 days @ 22 °C

Physical Properties:

Glass Transition Temperature, °C:	
(Tg) by TMA ISO 11359-2	63
Shore Hardness, ISO 868, Durometer D	86
Compressive Strength, ISO 604	N/mm ² 106 (psi) (15,400)
Compressive Modulus, ISO 604	N/mm ² 3,260 (psi) (472,700)

Electrical Properties:

Dielectric Strength, IEC 60243-1, kV/mm	13
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TYPICAL PERFORMANCE OF CURED MATERIAL

Cured for 7 days @ 22 °C

Lap Shear Strength, ISO 4587:	
Mild Steel (grit blasted)	N/mm ² 31 (psi) (4,500)
Taber Wear Resistance, Weight Lost, mg:	
Wheels H 18, 1 Kg load, 1,000 cycles	45
Cathodic Disbondment, Penetration, mm:	0
(ASTM G 95, 90 day test)	
Dry Service Temperature Resistance, °C	110
(CSA-Z245.20-06/CSA-Z245.21-06 Rating 1)	
Wet Service Temperature Resistance, °C	90
(CSA-Z245.20-06/CSA-Z245.21-06 Rating 1)	



TYPICAL ENVIRONMENTAL RESISTANCE

Cured for 7 days @ 22 °C

Chemical Resistance

Tables below show chemical resistance @ 22°C. Tested on product specimens, immersed up to 5,000 hours @ 22°C in fluids indicated.

Acids

10 % hydrochloric	Continuous long term immersion
36 % hydrochloric	Continuous long term immersion
10 % sulphuric	Continuous long term immersion
10 % nitric	Short term or intermittent immersion
5 % phosphoric	Continuous long term immersion

Alkalis

40 % sodium hydroxide	Continuous long term immersion
25 % ammonium hydroxide	Continuous long term immersion
36 % ammonium sulphate	Continuous long term immersion
30 % hydrogen peroxide	Spill, splash with immediate cleanup

Solvents

Deionized Water	Continuous long term immersion
10% Salt Water	Continuous long term immersion
Methanol	Spill, splash with immediate cleanup
Methylethylketone (MEK)	Spill, splash with immediate cleanup
Xylene	Spill, splash with immediate cleanup

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:**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.

- Remove dirt, oil, grease etc with a suitable cleaner, e.g. high pressure water cleaning system using Loctite® 7840™ or Loctite® Natural Blue® cleaner/degreaser.
- All skip welds, weld splatter, buckshot, and other surface roughness must be ground down and smoothed; undercuts and pinholes must be ground smooth and filled. All projections, sharp edges, high points and fillets must be ground smooth to a radius of at least 3mm and all corners must be likewise rounded to maximize product performance.
- Blast all surfaces to be coated with a sharp edged angular grit to a depth of profile of 75 to 100 microns, and a degree of cleanliness of Near White Metal (SIS SA 2½ /SSPC-SP 10). For immersion service, a degree of cleanliness of White Metal (SIS SA 3/SSPC-SP 5) is required.
- After blasting, metal surfaces should be cleaned, e.g. with Loctite® 7063™ or Loctite® ODC Free Cleaner and Degreaser, and be coated before any oxidation or contamination takes place.

- Metal that has been in contact with salt solutions, e.g. seawater, should be grit blasted and high-pressure water blasted, left for 24 hours to allow any salts in the metal to sweat to the surface. A test for chloride contamination should be performed. The procedure should be repeated until chloride concentration on the surface is below 40 ppm.

Application

- Film thickness per coat: 200 to 300 microns.
- Ambient and substrate temperature range: 10 to 40 °C.
- Relative humidity: <85 %; substrate temperature must always be 3 °C higher than the dew point.
- Bulk Spray System:
 - two component abrasion resistant airless equipments with a minimum compression ratio of 60:1.
 - Nozzle 3 to 4 mm; fan width 50 to 60°, depending on the structure to be coated.
 - Spraying pressure: 210 bar minimum. Product temperature: ≥25 °C.
- For Cartridge system:
 - Pre-heat cartridges to 50°C.
 - Set product pressure to approximately 2 bar and air pressure to approximately 5 bar.

Multiple coat application may be carried out, once the film has gelled, but not cured beyond the maximum recoat time. If this time has elapsed, light abrasive blasting is required, followed by a solvent wash to remove any abrasive residues

Coverage rate

To achieve a 250 micron thickness, the coverage rate will be 2.7 m² / kg, excluding overthicknesses, outpattern sprayed product, etc

Inspection

- Visually inspect for pinholes and misses just after application.
- Once the coating has cured, repeat visual inspection to confirm freedom from pinholes, misses and mechanical damages.
- Control thickness of the coating, especially in the critical points.
- Perform a test with a holiday detector to confirm coating continuity.

Repairs

Any misses, pinholes, low thickness areas found in the coating should be repaired by lightly abrading, cleaning and applying further product

Clean-up

1. Immediately after use clean tools with suitable cleaner, e.g. Loctite® 7063™ or Loctite® ODC Free Cleaner and Degreaser. Once cured, the material can only be removed mechanically.

Loctite Material Specification^{LMS}

LMS dated February 19, 2009 (Resin) and LMS dated December 13, 2008 (Hardener). 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. Material removed from containers may be contaminated during use. Do not return liquid to original container. 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.

Henkel cannot assume responsibility for product which has been contaminated or stored under conditions other than those recommended. If additional information is required, please contact your local Technical Service Center or Customer Service Representative.

Conversions

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$

$\text{kV/mm} \times 25.4 = \text{V/mil}$

$\text{mm} / 25.4 = \text{inches}$

$\mu\text{m} / 25.4 = \text{mil}$

$\text{N} \times 0.225 = \text{lb}$

$\text{N/mm} \times 5.71 = \text{lb/in}$

$\text{N/mm}^2 \times 145 = \text{psi}$

$\text{MPa} \times 145 = \text{psi}$

$\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$

$\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$

$\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$

$\text{mPa}\cdot\text{s} = \text{cP}$

Note

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Reference 0.0