



LOCTITE[®] 7500[™]

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PRODUCT DESCRIPTION

LOCTITE[®] 7500[™] provides the following product characteristics:

Technology	Aqueous Based
Chemical Type	Synthetic Latex Resin
Solvent	Glycol / Water
Appearance	Green / Black (dries to a matt black)
Components	One component - requires no mixing
Viscosity	Medium
Cure	Dries
Application	Coating
Specific Benefit	• Easy application by brush, roller or sponge • Converts and stops rust • Lead free

LOCTITE[®] 7500[™] is a non-toxic, aqueous liquid which dries at room temperature. It converts rust into a black, stable complex and forms a protective coating on exposed iron and steel surfaces. This product forms a suitable primer for most types of paints. It is good for all ferrous substrates. LOCTITE[®] 7500[™] applications include converting areas of rust on metal pipes, valves, fittings, storage tanks, fences, guard rails, conveyors, supports, heavy automotive equipment, overhead cranes, booms, agricultural equipment, etc.

TYPICAL PROPERTIES

Specific Gravity @ 25 °C	<1.3
Flash Point - See MSDS	
Viscosity, Brookfield - LVT, 25 °C, mPa·s (cP):	
Spindle 4, speed 20 rpm	2,000 to 4,000
Solids/Non-Volatile Content, %	35 to 50
Drying Time @ 20 °C, minutes	30
Recoat Time @ 20 °C, minutes	60
Recommended Time Before Painting with Top Coat, hours	72

TYPICAL PERFORMANCE

TUV Procedure, DIN 50017	Pass
Salt Spray Test, ASTM D714:	
500 hours	No obvious rusting

TYPICAL ENVIRONMENTAL RESISTANCE

Resistance to moisture, solvents & chemicals

LOCTITE[®] 7500[™] should be topcoated for many applications. Continuous exposure of LOCTITE[®] 7500[™] should not be used in applications involving continuous immersion in water or fluids. LOCTITE[®] 7500[™] should be topcoated with products known to be resistant to the environment expected.

Topcoat selection is dependent upon the environment to which the coating will be subjected. The following guidelines can be used. Topcoats are listed by their relative order of performance:

- Moisture/salt spray - high-build epoxies, coal tar epoxy catalysed urethanes, vinyls, chlorinated rubber.
- Solvent resistance - catalysed urethanes, coal tar epoxies, high build epoxy, vinyls.
- Acid resistance - catalysed urethanes, coal tar epoxies, high build epoxies.
- Alkali resistance - catalysed urethanes, coal tar epoxies, high build epoxies, chlorinated rubber.
- Oxidizing agent resistance - vinyls, catalysed urethanes.
- Abrasions - epoxies, urethanes, alkyds.

Where cratering, pitting or heavy surface profile is evident use coats of LOCTITE[®] 7500[™] followed by a high build primer topcoat with sufficient thickness to prevent pin-point corrosion. As with all paint systems, a test patch is recommended.

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).

Surface Preparation

Old Steel:

Loose or "flaky" rust must be removed. Only conversion of firmly bonded rust will result in durable protection. Oil, grease, old paint, mill scale, form oil, and water soluble surfaces and chlorides must be removed to allow LOCTITE[®] 7500[™] to react with surface

Loose rust, mill scales and oil paint should be removed preferably by power wirebrushing, (avoid over polishing of the surface) followed by rinsing with water to remove powder and solubles. Manual wirebrushing, chipping, scraping and particularly rotopeening can also be used. Oil, grease, and form oil should be removed before loose rust.

Rust Conversion Time and Appearance:

Two coats of LOCTITE[®] 7500[™] are recommended. On lightly rusted steel (that has been wirebrushed) the first coat will start to develop a black color within minutes. The second coat should dry to a black color with gloss varying from flat to satin. The second coat should be applied within 60 minutes of the first coat.

Application Conditions

LOCTITE® 7500™ may be applied when surface and air is between 10 °C minimum and rising and 30 °C maximum and falling. Reaction is slower at lower temperatures. If temperature is too hot, film may surface and bubble. High humidity is beneficial; it slows drying but assists rust conversion. LOCTITE® 7500™ should not be applied in conditions of condensing humidity (e.g. fog, dew), on ice, in rain or in heavy sea (salt) spray atmospheres. Steel surfaces may be damp but not wet (i.e. continuous visible film of water). Do not apply LOCTITE® 7500™ to surface in direct sunlight.

Directions for use

1. Shake the product thoroughly before use.
2. Ensure all surfaces are free of any dirt, oil, release agents or other contaminants.
3. Sanding is not required.
4. Pour into clean container for easy application by brushing or apply directly to surface and brush out.
5. If sandblasted, sufficient material should be applied to effectively cover the profile.
6. Apply liberally by brush, roller or sponge. An airless spray may also be used.
7. The use of gloves is recommended.
8. Spray application is recommended for larger areas.
9. Airless equipment is faster and provides more effective conversion and improved surface penetration.
10. Conventional air-spray equipment may be used but LOCTITE® 7500™ may require thinning to 10% with water for proper spraying. Never add solvent to LOCTITE® 7500™.
11. Application of 2 coats is recommended for maximum durability.
12. Uneven color indicates the need for additional coats for maximum protection. Recoat time is 60-120 minutes. Allow 24 hours minimum to dry before painting.
13. Brushes, rollers and other tools should be cleaned immediately with detergent and water. Flush spray equipment immediately after use with detergent and water. LOCTITE® 7500™ is difficult to remove when dry.
14. Once dried, strong solvents such as paint remover will be required to remove LOCTITE® 7500™ from equipment and clothes. Mechanical abrasion may be necessary.

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

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$
 $\text{kV/mm} \times 25.4 = \text{V/mil}$
 $\text{mm} / 25.4 = \text{inches}$
 $\mu\text{m} / 25.4 = \text{mil}$
 $\text{N} \times 0.225 = \text{lb}$
 $\text{N/mm} \times 5.71 = \text{lb/in}$
 $\text{N/mm}^2 \times 145 = \text{psi}$
 $\text{MPa} \times 145 = \text{psi}$
 $\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$
 $\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$
 $\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$
 $\text{mPa}\cdot\text{s} = \text{cP}$

Note

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, **Henkel Corporation specifically disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Henkel Corporation's products. Henkel 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 Henkel 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. This product may be covered by one or more United States or foreign patents or patent applications.

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Reference 1.0