

LOCTITE® PC 7643™

Known as LOCTITE® Big Foot® Metal Primer™

April 2015

PRODUCT DESCRIPTION

LOCTITE® PC 7643™ provides the following product characteristics:

Technology	Epoxy
Appearance (Mixture)	gray
Components	Two component - requires mixing
Mix Ratio, by volume - Base : Hardener	3 : 1
Mix Ratio, by weight - Base : Hardener	5.25 : 1
Cure	Room temperature cure
Application	Surface preparation
Specific Benefit	<ul style="list-style-type: none"> • Superior resistance to chemicals and wear • Does not require induction time • Enhances adhesion properties to metal surfaces • Reduces corrosion to metal surfaces

LOCTITE® PC 7643™ is a two-component, epoxy-polyamide primer under typical dry service temperatures of -30 °C to +60 °C. It is recommended for increasing adhesion of Big Foot™ Flooring Products (anti-slip coatings) on metal surfaces, and for reducing corrosion on metal surfaces. LOCTITE® PC 7643™ is designed to be used in conjunction with Big Foot™ Flooring Products.

TYPICAL PROPERTIES OF UNCURED MATERIAL**Mixed:**

VOC, g/l	245
Volume of Solids, %	72
Coverage	26 m ² per 3.8 liter kit (285 ft ² /gal)

Flash Point - See SDS

TYPICAL CURING PERFORMANCE**Curing Properties**

Cure Time @ 21 °C, hours 4

Note:

Temperature and thickness of application affect dry time. Temperatures under 10 °C will result in a substantially longer cure time. Temperatures over 25 °C will result in a shorter cure time. The thicker the application, the longer the cure time.

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:**

LOCTITE® PC 7643™ can be applied to any clean, dry surface. Recommended methods of cleaning are as follows:

1. Remove all paint films, laitance, and unbonded particles, preferably by sandblasting.
2. Remove all oil, grease, dirt, wax or other contaminants by dissolving with a waterbased cleaner/degreaser.
3. Flush thoroughly with clean water and allow to dry.
4. After cleaning, all loose particles must be removed by brushing, air hosing or similar method.

Mixing:

1. Mechanically mix the resin using a suitable mixing blade, until it is homogenous.
2. Pour the hardener into the base component container. Mechanically mix (using same mixer blade), scraping material from the sides and bottom of the can. Mix thoroughly until uniform, approximately 3 minutes.
3. NO THINNERS MAY BE ADDED.

Application Method:

LOCTITE® PC 7643™ can be applied at surface temperatures between @ 10 to 50 °C (50 to 120 °F). Application is not recommended when surface temperature is above or below these temperatures. The Primer can be applied by roller or brush.

1. The Primer does not require an induction period and may be applied immediately after mixing.
2. The Primer should be applied to a minimum 0.5 to 0.75 mm dry film thickness.
3. Weld seams and edges should be stripe coated prior to the complete prime coat.
4. If the anti-slip application is delayed more than 72 hours, the surface may become contaminated and should be cleaned again before applying product.
5. Clean tools immediately after completing installation using an epoxy solvent such as xylene.

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. 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:

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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Reference 0.4