



**TYPICAL PROPERTIES OF CURED MATERIAL**

Cured for 7 days @ 22°C

Shore Hardness, ISO 868 , Shore D	90
Linear Shrinkage, in/in	1.1
Volume Shrinkage, %	3.1
Water Absorption, %	2
Glass Transition Temperature, ISO 11359-2, °C	38
Coefficient of Thermal Expansion, ISO 11359-2, K <sup>-1</sup> :	
Above Tg	39×10 <sup>-06</sup>
Below Tg	115×10 <sup>-06</sup>
Tensile Strength, ISO 527-3	N/mm <sup>2</sup> 48 (psi) (7,000)
Tensile Modulus, ISO 527-3	N/mm <sup>2</sup> 4,700 (psi) (681,000)
Flexural strength , ASTM D790	N/mm <sup>2</sup> 78 (psi) (11,260)
Flexural modulus , ASTM D790	N/mm <sup>2</sup> 7,730 (psi) (1,120,500)

**Electrical Properties:**

Surface Resistivity, IEC 60093, ohms	1.9×10 <sup>17</sup>
Volume Resistivity, IEC 60093, ohm-cm	2.7×10 <sup>15</sup>

Cured for 7days 22 °C

**Physical Properties:**

Compressive Strength, ISO 604	N/mm <sup>2</sup> 132 (psi) (19,157)
Compressive Modulus, ASTM D695 (ISO 604)	N/mm <sup>2</sup> 9,428 (psi) (1,367,387)

**TYPICAL ENVIRONMENTAL RESISTANCE**

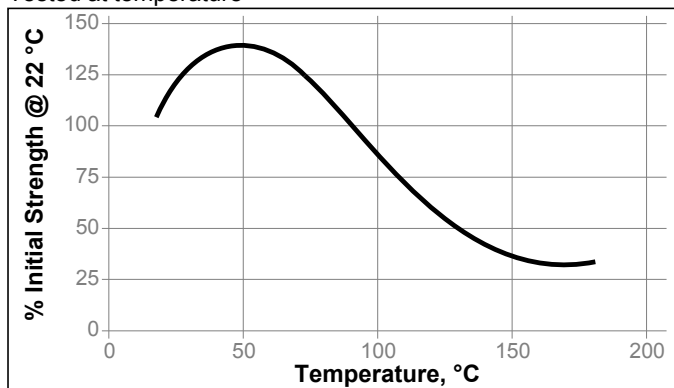
Cured for 7 days @ 22°C

Lap Shear Strength :

Grit Blasted Mild Steel (GBMS)

**Hot Strength**

Tested at temperature

**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****Preparation of Metallic Parts**

1. If a bond to the substrate is desired, all metallic parts that come in contact with LOCTITE® PC 9020I should be free of rust, dirt, grease, and oil.
2. If easier removal of worn liners is desired, coat the appropriate surfaces with a release agent such as grease or light oil.
3. Seal all gaps, hook holds, bottom joints, and protected threaded parts of shafts where necessary.

**Preparation of Backing Material**

LOCTITE® PC 9020I and substrate must be between 15 to 65C (60 to 150F) before use:

- Lower temperatures give longer working life, but higher viscosity making the material hard to pour.
- High temperatures reduce LOCTITE® PC 9020I working time to pour into crusher.

**Mixing:**

1. Pre-mix resin approximately 1 minute.
2. Shake hardener thoroughly mixing its contents.
3. While mixing resin, add hardener contents.
4. LOCTITE® PC 9020I is formulated for a color change indication when the hardener component is added to the resin, changing from yellowish-green to dark blue. As the product is mixed, dark blue streaks will appear in the product.
5. Continue mixing until the entire contents of the pail are dark blue, making sure to scrape the sides and bottom of the pail thoroughly until there are no signs of yellowish-green material.

**Application**

1. Pour mixture immediately after mixing. Pour at one place and allow LOCTITE® PC 9020I to fill the cavity and push out the air in front of it. Use dam (tin, cardboard, clay, etc.) to direct the flow when necessary. Unmixed resin (different color clinging to the sides and bottom) should not be drained into the crusher.
2. Succeeding kits may be mixed and poured individually as needed. LOCTITE® PC 9020I adheres to itself.

**Caution:** Use an approved, positive-pressure, supplied air respirator when welding or torch cutting near cured compound. **Do Not** use open flame on compound.

**Technical Tips for Working With Epoxies**

Working time and cure depends on temperature and mass:

- The higher the temperature, the faster the cure.
- The larger the mass of material, the faster the cure.

To speed the cure of epoxies at low temperatures:

- Store epoxy at room temperature.
- Pre-heat repair surface until warm to the touch.

To slow the cure of epoxies at high temperatures:

- Mix epoxy in small masses to prevent rapid curing.
- Cool resin/hardener component(s).



**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 Henkel representative.

**Conversions**

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

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

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

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

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

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

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

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

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

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

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

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

**Disclaimer**

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.

Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

**In case products are delivered by Henkel Belgium NV, Henkel Electronic Materials NV, Henkel Nederland BV, Henkel Technologies France SAS and Henkel France SA please additionally note the following:**

In case Henkel would be nevertheless held liable, on whatever legal ground, Henkel's liability will in no event exceed the amount of the concerned delivery.

**In case products are delivered by Henkel Colombiana, S.A.S. the following disclaimer is applicable:**

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. Henkel is 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.

Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal

injury caused by our negligence and any liability under any applicable mandatory product liability law.

**In case products are delivered by Henkel Corporation or Henkel Canada, Inc. the following disclaimer is applicable:**

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.

**Trademark usage**

Except as otherwise noted, all trademarks in this document are trademarks of Henkel Corporation in the U.S. and elsewhere. ® denotes a trademark registered in the U.S. Patent and Trademark Office.

Reference 0.0

