

**PRODUCT DESCRIPTION**

LOCTITE<sup>®</sup> PC 9402A is a 100% solids epoxy system for backing wear metal in gyratory and 7 foot cone crushers under typical dry service temperatures of -28°C to 104°C (-20°F to 220°F).

**Advantages:**

The product needs no melting or special equipment, and has high hydrolytic stability (low water absorption), high volumetric stability that eliminates formation of gaps between backing and liners or support structures. It is easy and safe to use.

**DIRECTIONS FOR USE****Preparation of metallic parts:**

- All metallic parts that come in contact with High Performance Backing Material should be free of rust, dirt, grease, and oil. Seal hook holes and bottom joints, and protect threaded parts of shafts where necessary. To facilitate easier removal of worn liners, coat crusher heads and mill shells with grease.

**Preparation of backing material:**

- High Performance Backing Material must be at 15-26°C (60-80°F) before use. Lower temperatures give longer working life, but higher viscosity (harder to pour), while higher temperatures reduces working time to pour into crusher.

**Mixing Instructions:**

1. Premix resin approximately one minute.
2. Shake hardener thoroughly mixing its contents.
3. While mixing resin add hardener contents.
4. Mix both components together for approximately 5 minutes.
5. Pour mixture immediately after mixing. Pour at one place and allow High Performance Backing Material 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.
6. Succeeding kits may be mixed and poured individually as needed. High Performance Backing Material adheres to itself.

**Caution!** use approved, positive-pressure, supplied-air respirator when welding or torch cutting near cured compound. **DO NOT** use open flame on compound. See other cautions on Material Safety Data Sheet.

**TECHNICAL TIPS FOR WORKING WITH EPOXIES**

**Working time and cure time depends on temperature and mass:**

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

**PROPERTIES OF UNCURED MIXED MATERIAL**

	Typical Value
Appearance	Red Liquid
Mix Ratio (R:H) by Volume	9.79:1
by Weight	100:5.6
Coverage	340 in <sup>3</sup> per 2 gallon kit 5,576 cm <sup>3</sup>

**TYPICAL CURING PERFORMANCE(@ 25°C unless noted)**

Curing Properties	Typical Value
Working Life, minutes	20
Cure Time, hours	8

**TYPICAL PROPERTIES OF CURED MATERIAL(@ 25°C)**

Physical Properties	Typical Value
Tensile Strength, ASTM D638, psi	6,200
Impact Strength, ASTM D256, Method B, lb/in	2.7
Compressive Strength, ASTM D695, psi (N/mm <sup>2</sup> )	18,000 (124.1)
Hardness ASTM D-2240, Shore D	90

**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).**

**Storage**

Product shall be ideally stored in a cool, dry location in unopened containers at a temperature between 8°C to 28°C (46°F to 82°F) unless otherwise labeled. 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 your local Technical Service Center.

**Data Ranges**

The data contained herein may be reported as a typical value and/or range. Values are based on actual test data and are verified on a periodic basis.

**Note**

The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based

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