

LOCTITE Nordbak® Fixmaster®

Surface Engineering Solutions

Repair, Rebuild & Protect Industrial Equipment



Excellence is our Passion

Loctite® Nordbak® and Fixmaster® composites REPAIR, REBUILD and PROTECT industrial equipment and surfaces, extending equipment life, improving efficiency, minimising down time and reducing cost.

Creating Partnerships

Loctite® branded products are foremost in the business of solving and preventing customer's problems. With Fixmaster® and Nordbak® composite technology providing the foundation, customers get more than a product – they get a partner who will work side-by-side with them to create and implement innovative solutions.

Focusing on Customer Support

Our highly experienced Fixmaster® and Nordbak® composite Application Engineers are committed to providing the highest level of technical support and assistance in the industry.

Our Application Engineers, working closely with local industrial suppliers and selected Engineering Service Agents, provide full process support, from maintenance assessment to implementation of solutions.

Our commitment to customer support includes;

- ✓ 'Hands-on' product application and technical support.
- ✓ On-site product and maintenance training.
- ✓ National distribution network and engineering service agents.
- ✓ Dedicated customer support phone line.
- ✓ Convenient website access to updated MSDS's, technical data, and product information.
- ✓ Preparation of documented 'Scope of Work' detailing case specific maintenance and or repair procedures.
- ✓ Fully equipped testing laboratories available for evaluating new or unique applications.
- ✓ Worldwide industry experience and resources.



Years of Industry Experience

The comprehensive range of Loctite®, Nordbak® and Fixmaster® products offer proven maintenance solutions to the problems caused by erosion, abrasion, corrosion, impingement, cavitation and mechanical damage.

This catalogue aims to give you an overview of the solutions available and provide you with easy to select product information. For further information call the Loctite® Customer Support Line listed below or visit our website.



1300 88 555 6
www.loctite.com.au



09 272 6710
www.loctite.co.nz



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Surface Engineering Solutions

Correct surface preparation is the most important factor affecting the total success of any surface treatment. Without suitable **SURFACE PROFILE** and **SURFACE CLEANLINESS** coating systems will quickly fail!



Creating a surface profile



Loctite® Natural Blue is suitable for pressure spraying, wipe down, ultrasonic and immersion cleaning processes

1.0 Surface Preparation

Loctite® Natural Blue Biodegradable Cleaner and Degreaser

P/N: 82249 (709ml) • P/N: 82251 (3.78ltr) • P/N: 82253 (18.9ltr)



709ml is diluted 1:1 ready for use.

A biodegradable, all-purpose, industrial strength, concentrated cleaner and degreaser

Typical Application:

Machinery * Equipment * Valves
Compressors * Bearings * Castings
Stampings * Concrete Floors
Asphalt * Exhaust Hoods * Highway Structures * Motors Forgings * Vehicles * Dies * Tanks Exterior Siding * Windows

Loctite® Hand Wipes

P/N: 34943 (75pck Tub)
P/N: 34944 (130pck Bucket)

Pre-moistened waterless towels which scrubs off the toughest grease and grime without rinsing and drying, Leaving no residues behind. Fortified with emollients and natural oils.



Did you know?

Surface Profile

Abrasive blasting not only removes visible surface rust and contaminates, but also creates a rugged, miniature mountain and valley finish. This surface roughness is known as Surface Profile.

Surface Profile is critical to coating performance as it improves adhesion by increasing surface area and providing a keyed anchor pattern.

Surface Profiles will vary depending on the type of abrasive particles, equipment and technique utilised. It is critical to achieve the correct profile depth specified for a particular coating.

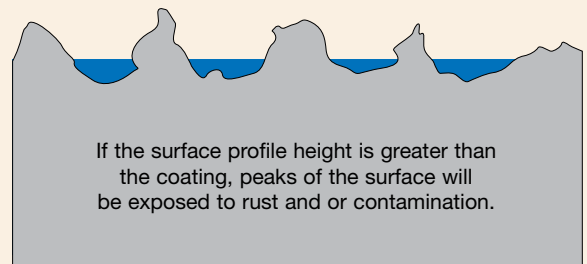
Inadequate quality control and lack of restriction of large abrasive particle sizes for thin coats can lead to peaks of the surface not being adequately covered. In addition more profile means using more product to cover the surface!

The diagrams right illustrates how profile must be matched to the product specification.

Surface Cleanliness

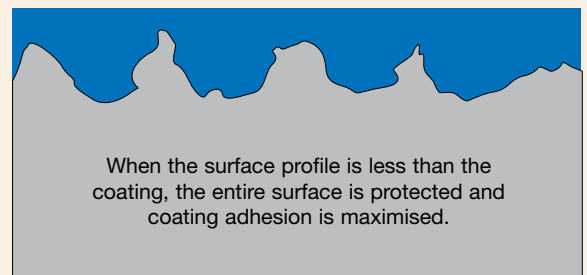
Chemical contaminants that are not readily visible, such as chlorides and sulphates, attract moisture through coating systems resulting in premature failure. Therefore it is fundamentally important to chemically clean all substrates with an industrial strength cleaner and degreaser such as Loctite® Natural Blue.

BAD PROFILE



If the surface profile height is greater than the coating, peaks of the surface will be exposed to rust and or contamination.

GOOD PROFILE



When the surface profile is less than the coating, the entire surface is protected and coating adhesion is maximised.

Loctite® Composites applications require a minimum 75 micron surface profile.

For further information about surface preparation refer to page 26 and consult your Loctite® Application Engineer.

Surface Engineering Solutions

Fixmaster® composites repair, rebuild and restore damaged machinery and equipment permanently and without the need for heat or welding. This technically advanced range includes putty or pourable formulations, for aluminum, steel or stainless steel.



Pouring moulds with Fixmaster® Aluminium Liquid



Repairing mechanical damage with Fixmaster® Steel Putty

- ✓ Non-shrinking.
- ✓ High compression strength.
- ✓ Can be machined and filed.
- ✓ Superior adhesion to metal, ceramic, wood, glass, and some plastics.
- ✓ Creates durable repairs.

Fixmaster® Superior Metal

P/N: 97473 (408gm kit)

P/N: 40900 (4kg kit)



High Compressive Strength & Temperature Rating

A ferro-silicon filled two-part epoxy ideal for renewing or protecting surfaces subject to corrosion, abrasion, and harsh environments. Its non-rust formula features outstanding compressive strength and is extremely resistant to abrasion and chemical attack under typical service temperatures of -29° to $+160^{\circ}\text{C}$.

Typical Applications:

- Rebuilding shafts, and bearing housings.
- Repairing leaks on pipes and welding joints.
- Repairing fuel and gas tank holes.
- Renewing stripped threads.
- Repairing cracked battery cases.
- Repairing leaking storage tanks.

Fixmaster® Steel Putty

P/N: 99913 (454gm kit)



General Purpose & Non-Sagging

The workhorse of the Fixmaster® line, this steel-filled, non-sagging, two-part epoxy cures to a metal like finish. Used for making cost-saving repairs on metal parts, under typical service temperatures of -29° to $+107^{\circ}\text{C}$, Steel Putty is our most recommended general-purpose epoxy.

Typical Applications:

- Sealing cracked castings, tanks, vessels, and valves.
- Patching non-structural defects in steel castings.
- Making models and jigs for holding odd shaped parts.
- Making metal dies.
- Resurfacing worn air seals.
- Re-profiling pitting caused by cavitation and or corrosion.

Fixmaster® Fast Set Steel Putty

P/N: 39917 (453gm kit)



Fast Cure Formula

A fast curing version of Steel Putty, this non-sagging two-part epoxy reaches a functional cure in about 10 minutes. Recommended for making fast and curable repairs to a variety of metals under typical dry service temperatures of -29° to $+93^{\circ}\text{C}$.

Typical Applications:

- Repairing fuel and gas tank holes.
- Renewing stripped threads.
- Repairing cracked battery cases.
- Repairing leaking storage tanks.
- Repairing leaks on pipes and welding joints.

Fixmaster® Aluminum Putty

P/N: 97463 (454gm kit)



Non-Sagging & Non-Corrosive

This non-sagging, two-part epoxy is easily mixed and moulded to form odd shapes if required. Heavily reinforced with aluminum powder, it cures to a non-rusting aluminum-like finish, ideal for repairing aluminum parts under typical service temperatures of -29° to +93°C.

Typical Applications:

- Repairing aluminum castings.
- Repairing worn aluminum parts.
- Making aluminum dies.

Fixmaster® Aluminum Liquid

P/N: 97453 (453gm kit)



Self-Levelling & Non-Corrosive

A pourable version of Aluminum Putty, this self-levelling and non-rusting, two-part epoxy is recommended for casting replacement aluminum parts and for making moulds and fixtures under typical service temperatures of -29° to +93°C.

Typical Applications:

- Filling or levelling equipment.
- Pouring moulds, parts and fixtures.
- Making aluminum forming dies.
- Casting aluminum parts.

Fixmaster® Underwater Repair Stick

P/N: 82093 (113gm)



Can be Applied Underwater

This putty-like material works on both wet and dry surfaces and can be set up underwater. Available in a conveniently packaged putty stick, the resin and hardener are pre-measured for consistent strength and easy application – simply cut off desired amount, knead and apply. Resistant to salt and chlorine, it is ideal for plumbing, irrigation and marine applications. Fully cures in one hour under typical dry service temperatures up to 149°C.

Typical Applications:

- Plugging and filling cracks, leaks and holes on pipes, fittings, tanks, valves and pumps especially in plumbing, irrigation and marine applications where applications are underwater.

Fixmaster® Stainless Steel Putty

P/N: 97443 (454gm kit)



Non-Sagging, Stainless Steel Finish

This stainless steel filled, two-part epoxy repairs parts and forms a non-rusting, very hard and durable finish on damaged surfaces. Designed for use where a stainless steel finish is desired under typical service temperatures of -29° to $+107^{\circ}\text{C}$.

Typical Applications:

- Renewing stainless steel pumps.
- Rebuilding stainless steel shafts.
- Repairing stainless steel castings.
- Making stainless steel moulds.
- Resurfacing stainless steel equipment.

Fixmaster® Wear Resistant Putty

P/N: 98743 (1.35kg kit)



Non-Sagging & Abrasion Resistant

Ceramic fibres give this trowelable non-rust putty, excellent wear and abrasion resistance properties under typical service temperatures of -29° to $+160^{\circ}\text{C}$. It cures to a smooth, low friction finish for equipment exposed to wear, erosion and cavitation.

Typical Applications:

- Re-profiling pitting caused by cavitation or corrosion.
- Rebuilding pipes, pumps, elbows, impellers, butterfly valves, deflection plates, and tanks.

Fixmaster® Metal Magic Steel™ Stick

P/N: 98853 (113gm)



10-Minute Functional Cure

An easy to use, steel-filled compound designed for emergency maintenance repairs on dry or damp surfaces. Available in a conveniently packaged putty stick, the resin and hardener are pre-measured for consistent strength and easy application – simply cut off desired amount, knead and apply. Cures to a metal-like finish in less than 10 minutes under typical dry service temperatures of -30° to $+121^{\circ}\text{C}$ and is certified to ANSI/NSF Standard 61 for use in commercial and residential potable water systems not exceeding 82°C .

Typical Applications:

- Sealing tanks.
- Smoothing welds.
- Stopping pipe and tank leaks.
- Repairing holes in elbows, cracks in castings, and holes in gas and fuel tanks.
- Filling oversized bolt holes.

Surface Engineering Solutions

Fixmaster® urethane repair materials can be troweled, cast or brush applied to rebuild or protect processing equipment. With tough, rubber-like properties, they protect and seal critical operating equipment from impact, abrasion, and corrosion. They are designed to repair conveyor belts and other damaged rubber equipment quickly and easily.



Applying a protective coating of Fixmaster® Flex 80 Liquid



Fixmaster® Rapid Rubber Repair is self mixing and achieves functional cure in 2 hours

3.0 Rubber Surface Repair & Rebuild

- ✓ Create durable and flexible repairs.
- ✓ Non-shrinking.
- ✓ Excellent weatherability – UV, humidity, and moisture resistant.
- ✓ Unaffected by oil, grease, and water.
- ✓ Forms strong bond to rubber, urethane, PVC, metal, glass, masonry and most plastics.
- ✓ Easy mix and application.

Fixmaster® Rapid Rubber Repair – Dual Cartridge

P/N: 96675 (400ml dual cartridge)



2 Hour Cure / Self-Mixing

This high performance two-part urethane was developed to repair critical operating equipment faster, more reliably and with greater ease than before. Fixmaster® Rapid Rubber Repair is an adhesive, sealant and repair compound all in one convenient, self-mixing system. Extremely tough and fast curing, it forms permanent bonds to rubber, urethane, PVC, metal, glass, masonry and plastics under typical dry service temperatures of -29° to +82.2°C. Its excellent flexibility and elongation properties make it suitable as a sealant in the most demanding environments.

And, the system's no-measure, self-mixing features make it extremely convenient for fast, on-site repairs, especially to conveyor belts and other rubber parts exposed to weather and extreme wear. (Includes 2 x Static Mixers)

Typical Applications:

- Repairing conveyor belts.
- Repairing or rebuilding rubber liners in mills, pumps, feeder bowls, hoppers, chutes, and fans.
- Repairing cast urethane screens and liners.
- Forming tough, flexible bonds to metal, rubber, masonry parts and a wide variety of substrates.

Fixmaster® Rapid Rubber Repair Kit

P/N: 96677



Kit includes Fixmaster® Rapid Rubber Repair (400ml dual cartridge), Fixmaster® Etching Agent (88.7ml), Fixmaster® Flex Primer & Cleaner (118ml), 2 x static-mixing nozzles, 2 x brushes, 2 x trowels.

Fixmaster® Rapid Rubber Repair Gun

P/N: 98783



Dual cartridge gun for use with Fixmaster® Rapid Rubber Repair 400ml cartridge.



Fixmaster® Rapid Rubber Repair Static Mixers

P/N: 39633 (6/bag)



Self-mixing dispensing nozzles for use with Fixmaster® Rapid Rubber Repair 400ml cartridge.

Fixmaster® Flex Primer & Cleaner

P/N: 39636 (118ml)



A one-part system designed to thoroughly clean and prime rubber, urethane and metal surfaces for application of Flex urethane products.

Special Features:

- Non-toxic.
- Dries rapidly.
- Leaves no residue.

Fixmaster® Flex Metal Primer

P/N: 98471 (93.8ml)



A one-part system designed to properly prime metal surfaces for application of Flex urethane products.

Special Features:

- Assures ultimate adhesion.
- Fast and easy to use.

Fixmaster® Etching Agent

P/N: 99626 (85.2ml)



A one-part system designed to properly prime rubber and other non-metallic surfaces for better adhesion of urethanes.

Special Features:

- Enhances bonding of urethanes.
- Fast and easy to use.

Fixmaster® Flex 80 Putty

P/N: 97423 (453gm kit)



High Tensile Strength & Trowelable

This trowelable two-part urethane rebuilds and repairs rubber parts and linings. It provides impact, abrasion, and corrosion resistant protection to processing and pneumatic conveying equipment. Recommended for applications where speed of cure is not critical under typical dry service temperatures of -29° to +82.2°C.

Typical Applications:

- Lining pipe elbows.
- Re-profiling pump liners.
- Repairing rubber couplings.
- Repairing rubber and urethane components.
- Adhering overlapping sheeting.
- Patching and repairing conveyor belts.
- Repair MSRL lined vessels.

Fixmaster® Urethane Sealant

P/N: 39916
(300ml cartridge)



Single Component & Paintable

A non-sagging, single component, polyurethane that cures to a flexible rubber and forms strong bonds to properly prepared concrete, masonry, glass, plastics, woods, aluminum and other metals under typical dry service temperatures of -40° to +82.2°C. Cured material has excellent adhesion, cohesion and elasticity and resists deterioration from weather, stress, movement, water and many chemicals.

Typical Applications:

- Forming expansion joints.
- Filling concrete cracks.
- Creating moisture barrier beneath pedestals.
- Installing skylights and roof flashing.
- Sealing seams, tanks, and chutes.
- Sealing chimney stacks in roofs.

Tips & Tricks

Fixmaster® & Nordbak® Curing Times

Working time and cure 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 composites at low temperature;

- Store composite at room temperature
- Pre-heat repair surface until warm to touch

To **slow the cure** of composites at high temperature

- Mix composites in small masses to prevent rapid curing
- Cool resin/hardener components.

Surface Engineering Solutions

Today's harsh industrial environments wreak havoc on concrete floors, columns, beams and other structures that can spell trouble for safety and performance. Fixmaster's® high strength floor repair products fill and restore concrete permanently, minimising disruption to production. Inhibits spalling corrosion.



Fixmaster® Magna-Crete's advanced formula cures in 1 hour



Filling concrete cracks with Fixmaster® Urethane Sealant

4.0 Concrete Surface Repair & Rebuild

- ✓ Bonds to concrete without use of special bonding agents.
- ✓ High compression strength – up to 103 N/mm² (15,000psi)
- ✓ Quick and permanent repairs.
- ✓ Non-shrink and freeze / thaw resistant.
- ✓ Resistant to chemical attack.

Fixmaster® Magna-Crete

P/N: 95555 (18.9ltr kit)



1 Hour Functional Cure

Fixmaster® Magna-Crete is a unique, two-component, rapid setting concrete repair and grouting system that outperforms conventional concrete repairs under typical service temperatures of -26°C to +1090°C. A high performance, magnesium phosphate-based system, Magna-Crete is ready for light service in as little as 60 minutes, and unlike concrete, it bonds to new and old concrete as well as most construction materials including wood, and steel. Because Magna-Crete does not use a water additive, this

repair system can be applied in temperatures from -26°C to +46°C without shrinkage and is freeze/thaw resistant.

Typical Applications:

- Repairing floors, ramps, loading docks, runways, and concrete pillars.
- Filling potholes.
- Anchoring machinery.
- Grouting bedplates and soleplates.
- Anchoring bolts and handrails.
- Repairing parking structure joints.
- Excellent for areas affected by spalling corrosion.

Fixmaster® Floor Fill

P/N: 99361 (4.54kg Kit)



Floor Fill

Fixmaster Floor Fill is a non-shrinking 100% solids epoxy based system for repairing holes in floors, spalled areas, ramps, stairs, cracks in floors and for use in grouting applications. Once cured it is stronger than concrete. Bonds to almost any clean substrate and provides chemical resistance under typical dry service temperature of -29° to +107°C.

Typical Applications:

- Repairing concrete floors, ramps, high impact areas.
- Repairing machine bed and pump foundations.
- Sealing and repairing chemical containment areas.
- Grouting.

Fixmaster® Crack Filler NS

P/N: 1108886 (8.06oz Kit)



Crack Filler

Fixmaster Crack Filler NS is a two component, 100% solid epoxy designed to fill cracks, small holes and mildly spalled areas. This product is non-sag making it ideal for horizontal and vertical applications. Fixmaster Crack Filler NS can be used for indoor and outdoor applications.

Typical Applications:

- Repairing holes and cracks in concrete

Nordbak® Wearing Compounds utilise the superior wear properties of ceramic and the convenience of two-part epoxies to protect equipment like pumps, condensers, elbows, chutes, and augers in harsh industrial environments. Available in trowelable and brushable formulations with special fillers for tough conditions. Nordbak® products stand up to every corrosion, abrasion, and wear problem you can encounter, and are ideal for all those large-scale repairs that have to last.



Protecting vital operating equipment with Nordbak® Wearing Compounds



Applying Nordbak® Brushable Ceramic to an impeller

- ✓ Provides superior protection from environmental impact.
- ✓ Eliminates and breaks corrosion / erosion cycle.
- ✓ Non-shrink and non-sag formulations.
- ✓ High compression strength.
- ✓ Broad chemical resistance.
- ✓ Broad range tailored to specific applications.

Nordbak® Wearing Compound

P/N: 41782 (10kg kit)



Resists Abrasion & Corrosion

A two-part epoxy designed to protect, rebuild, and repair high wear areas of processing equipment under typical service temperatures of -28° to $+180^{\circ}\text{C}$. Ceramic-filled for outstanding resistance to abrasion and corrosion, Wearing Compound is trowelable and non-sagging and therefore suitable for overhead and irregular surfaces.

Typical Applications:

- Relining pump housings.
- Reclaiming, protecting, and sealing against corrosion of;
 - Handling equipment.
 - Worn elbows.
 - Cyclone and separator bodies.
 - Dust collectors and exhausters.
 - Pump liners and volute.
 - Fan housings.
 - Chute linings and hoppers.

Nordbak® Fast Cure Wearing Compound

P/N: 96373 (6lb Kit)



Resists Abrasion & Corrosion

LOCTITE® Nordbak® Fast Cure Wearing Compound works in less than half the time of conventional curing epoxies to rebuild, repair, and protect processing equipment from hard sliding abrasion. Like standard Nordbak® Wearing Compound, this fast curing version is a two-component, ceramic-bead filled repair material for rebuilding and protecting chutes, pumps, elbows, cyclones, and other material handling equipment against wear and abrasion under typical dry service temperatures of -29° to $+107^{\circ}\text{C}$ (-20° to $+225^{\circ}\text{F}$).

Typical Applications:

- Quick turn applications
- Transport elbows and transitions
- Pump liners and volute
- Chute linings and hoppers
- Cyclone and separator bodies
- Fan housing
- Scrubbers
- Dust collectors and exhausters

Nordbak® High Impact Wearing Compound

P/N: 1174109 (11.35kg kit)



Resists Impact & Sliding Abrasion

A rubber-modified, two-part epoxy, that offers wear and impact resistance properties not usually found in epoxy formulations. With impact resistance superior to ceramic tile, this product is for applications where both sliding abrasion and impact are present, under typical dry service temperatures of -29° to $+121^{\circ}\text{C}$.

Typical Applications:

- Protection against impact and abrasion of;
 - Screen decks.
 - Dredge pump liners.
 - Vibrating feeder.
 - Drop boxes.
 - Chutes & troughs
 - Hoppers.

Nordbak® Pneu-Wear

P/N: 42089 (10kg kit)



Resists Fine Particle Abrasion.

A two-component epoxy, filled with small ceramic beads and silicon carbide for protecting processing equipment from fine particle abrasion. This trowelable and non-sag epoxy is recommended for rebuilding, repairing, and protecting pump housings, chutes, elbows, cyclones, and other material handling equipment against pneumatic abrasion under typical dry service temperatures of -29° to $+180^{\circ}\text{C}$. Pneu-Wear won't sag

or shrink, so is also suitable for providing abrasion resistance on overhead and vertical surfaces.

Typical Applications:

- Providing protective lining in pneumatic conveying systems.
- Repairing and providing abrasion resistance of;
 - Elbows.
 - Slurry pumps.
 - Cyclones.
 - Dust collectors.
 - Hoppers.
 - Fan housing and impeller hub.

Nordbak® Ultra High Temperature Pneu-Wear

P/N: 96332 (11.32kg kit)



Resists Fine Particle Abrasion at High Temperature

A high temperature version of Pneu-Wear designed for hot environments. This trowelable and non-sag, two-part epoxy, resists fine particle abrasion under typical dry service temperatures of -29° to $+288^{\circ}\text{C}$.

Typical Applications:

- Repairing and providing abrasion resistance of;
 - Pneumatic conveying systems.
 - Exhauster.
 - Chutes and hoppers.
 - Cyclones and pulverising mills.
 - Elbows.
 - Fan housing and impeller hub.
 - Scrubbers

Nordbak® Crusher Backing Compound

P/N: 36123 (10kg kit)



Typical Backing Applications

A 100% solids, two-part epoxy system designed for backing wear metal in crushers and grinding mills under typical dry service temperatures up to $+77^{\circ}\text{C}$. It is non-flammable, requires no melting or special equipment, and has high volumetric stability that eliminates formation of gaps between liners or support structures.

Typical Applications:

- Cone crushers and grinding mills up to seven foot.

Tips & Tricks

Wear Indicator

When applying two coats of Nordbak® Brushable Ceramic a different colour can be used for each - grey and white. When the first coat begins to wear the second coat colour will show through, providing an accurate visual indicator of wear.

Nordbak® Hi-Impact Crusher Backing Compound

P/N: 36122 (10kg kit)



Extreme Backing Application

Formulated to exhibit excellent resilience to impact while retaining high compression and tensile strength under typical dry service temperatures up to +105°C. It is non-flammable, requires no melting or special equipment, and has high volumetric stability that eliminates formation of gaps between backing liners and support structures.

Typical Applications:

- Cone crushers and grinding mills subjected to extreme impact.

Nordbak® Brushable Ceramic

P/N: 42372 – White (1kg kit)

P/N: 42377 – White (2kg kit)

P/N: 42087 – Grey (1kg kit)

P/N: 42076 – Grey (2kg kit)



Brushable Protective Coating

An ultra-smooth, ceramic reinforced epoxy that provides a high gloss, low friction coating to protect against turbulence, abrasion, and cavitation under typical dry service temperatures of -29° to +125°C. Used by itself, Brushable Ceramic is recommended for sealing and protecting equipment from corrosion and wear. It also works as a topcoat over Nordbak® Wearing Compound or Pneu-Wear for applications requiring surface rebuilding and lasting protection.

Alternative coat colours can be used to indicate wear. White is AS/NZS 4020-2002 approved for use in contact with drinking water.

Typical Applications:

- Providing a smooth, protective, abrasion resistant coating.
- Lining tanks and chutes.
- Resurfacing and repairing rudders and pintel housings.
- Resurfacing heat exchangers - butterfly valves
- Resurfacing condensers.
- Repairing cavitated pumps.
- Repairing cooling water pump impellers.

Loctite® 7255 Sprayable Ceramic

P/N 43269 – 900ml (single pack)

P/N 43269A – 900ml (3 pack)



Sprayable Ceramic Coating

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, under dry surface temperature up to 110°C and wet temperature up to 90°C. It can be used as a smooth, protective coating on metal surfaces or as a low friction top coat over Loctite® Nordbak® Wear Resistant Compounds.

Typical Applications

- Lining tanks and vessels.
- Resurfacing heat exchangers and condensers.
- Repairing valve bodies, pump impellers and casings.
- Efficient coating on complex surfaces.

Nordbak® High Temperature Brushable Ceramic

P/N: 42088 (1kg kit)



Brushable Protective Coating at High Temperature

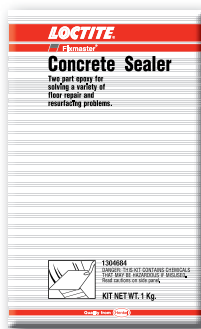
A brushable two-part epoxy designed to protect against turbulence, abrasion, and cavitation under extreme heat. Typical dry service temperatures of -29° to $+288^{\circ}\text{C}$.

Typical Applications:

- Protecting exhausters from cyclic heat and corrosion.
- Repairing heat exchangers and condensers.
- Lining tanks and chutes.
- Repairing butterfly valves.
- Lining scrubbers and vessels.

Loctite® Concrete Sealer

P/N: 1304684
(1kg kit)



Loctite Concrete Sealer

This is a two-part epoxy system for sealing and resurfacing concrete surface prior to a top coat with another Loctite® product.

Typical Applications:

- Chemical containment areas.
- ETP pits.
- Pump bases.
- Battery storage areas.

Nordbak® Chemical Resistant Coating

P/N: 96092
(5.43kg kit)



Chemical Resistant Brushable Coating

This advanced two-part epoxy is designed to protect equipment against extreme chemical attack and corrosion under typical dry service temperatures of -29° to $+160^{\circ}\text{C}$. It forms a smooth, glossy, low-friction finish that protects against turbulence and cavitation, and its low viscosity means it can be applied by brush or pressure sprayed.

Typical Applications:

- Resurfacing tube sheets, condensers, cooling pump impellers, butterfly valves, and cavitated pumps.
- Resurfacing and repairing rudders and pintel housings.
- Lining tanks and chutes.
- Lining chemical containment areas.
- Lining of pump bases.
- Lining of battery storage areas.

Case Histories – Metal Surface Repair & Rebuild

Pump Rebuild

Due to the condition of the split case pump (pictured right), replacement was considered the most viable option. However, using Fixmaster® and Nordbak® products the pump was repaired and returned to service with superior protection qualities and less cost.

Before any repairs commenced the surface was thoroughly prepared and a 'hold coat' applied to prevent flash rusting or further contamination.

Next, a wire frame was used to recreate the shape of the centre web surface which had totally eroded. This frame was then filled with **Loctite® Fixmaster® Wear**

Resistant Putty.

The wear ring channels were then rebuilt by applying **Loctite® Fixmaster® Superior Metal** to the effected area. Next the rings were secured into position and excess product that was displaced was removed and smoothed. When cured the rings, which were pre-coated with a release agent, were removed leaving perfectly engineered channels.

Finally pits were filled with **Loctite® Fixmaster® Wear Resistant Putty** and the entire surface sealed with **Loctite® Nordbak® Brushable Ceramic**, forming an ultra smooth low friction surface.



Pitting and erosion was clearly evident

Reclaiming totally eroded surface



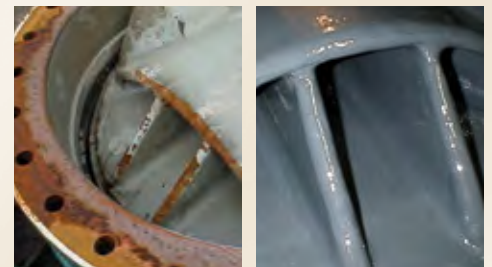
Butterfly Valve

A butterfly control valve at a Waste Water Treatment Plant was corroded and therefore unable to seal effectively.

The components were abrasive blasted and a 'hold coat' of **Loctite® Nordbak® Brushable Ceramic (White)** applied to seal the newly cleaned surface.

The rough and corroded edges of the valve were then re-profiled with **Loctite® Fixmaster® Wear Resistant Putty** before a final coat of **Loctite® Nordbak® Brushable Ceramic (Grey)** was applied. The two coat colours can be utilised as a wear indicator for any future repairs or maintenance.

The butterfly valve was returned to service within 1 day.



The corroded butterfly valve – before and after repair

Condenser Tube Sheet and Water Boxes

A condenser tube sheet and water box in a 210 MW thermal power plant was badly affected by corrosion and needed an immediate solution.

Epoxy coating done each year was not helping and aggravated the corrosion.

After proper cleaning and surface preparation, the affected areas were rebuilt with **Loctite® Fixmaster®**

Wear Resistant Putty and then coated with 2 coats of **Loctite® Nordbak® Brushable Ceramic**. The work was carried out during their annual shutdown.

The job has been running successfully for the last 3 years. Loctite's solution offered a significant advantage for the customer by increasing the life of the component and reducing the annual shutdown period.



Case Histories – Rubber Repair & Rebuild



Conveyor Belt

Without a functioning conveyor belt most industrial plants will incur downtime. That is why it is important to repair them as efficiently as possible.

Loctite® Fixmaster® Rapid Rubber is designed to repair damaged conveyor belts quickly and without the need for skilled labour. The two-part urethane is self-mixing and creates a durable repair within 2 hours of application.

Alternative methods of repair such as metal strips require creating even more holes and are time consuming.



The conveyor belt was returned to commission within 2 hours

Recovery of Vertical Pump Rotor Galiger D 2,5

The vertical pump rotor galiger D 2,5 is made of steel covered with rubber. The rubber wears out due to the use and the rotor has to be replaced. The cost of the new rotor is high and takes about 45 days to be delivered at the consumer's site. The useful life of the rotor is approximately 4 months.

Using **Loctite® Fixmaster® Flex 80 Putty** and **Loctite® Fixmaster® Flex Etching Agent**, the surface was cleaned very well, eliminating any residue of oiliness and impurities, then the product was applied according to technical information. The total period for curing was approximately 8 hours.

We have recovered the whole rubber part of the rotor and increased the useful life of the rotor. Thanks to the **Loctite® Solution**, the customer did not need to buy another rotor.



Caption

Decant Gate

The purpose of a wastewater decant gate is to manage the flow of treated water from the settling pond to lower ground ponds. The gate hinges, which are made of rubber, are prone to degradation due to repetitive use and exposure to chemical attack.

Initial quotes to repair the Decant Gate at a major rural Australian plant

totalled \$100k and required 3 weeks downtime. However the **Loctite® Fixmaster® Rapid Rubber Repair**, proved to create a durable repair in two days and at a fraction of the cost.



Rebuilding the decant gate hinge with **Loctite® Fixmaster® Rapid Rubber Repair**

Case Histories – Concrete Surface Repair & Rebuild

Rail Track Fill EDI Rail

A Rail Transport Manufacturing Facility was considering major excavation works to remove old, unused Rail Tracks and filling the voids with concrete to remove OH&S trip hazards.

Major concerns were: Avoiding production delays and controlling the dust during hazardous excavation work. Removing the old concrete, adding pining/keying for the new to old concrete and shutting down the area for weeks while the new concrete cured.

Loctite® Natural Blue Cleaner Degreaser was used to remove the dirt and grease followed by Fixmaster® Magna-Crete which is stronger than concrete, bonded to the old concrete and the steel tracks with fast curing, allowing next day

heavy vehicular traffic.

The Loctite® Fixmaster® Magna-Crete was applied by a Loctite certified applicator and removed the OH&S trip hazard without the need to remove the Rail Tracks. No dust, no need for any pining/keying and no production delays or any relocation cost.



Before

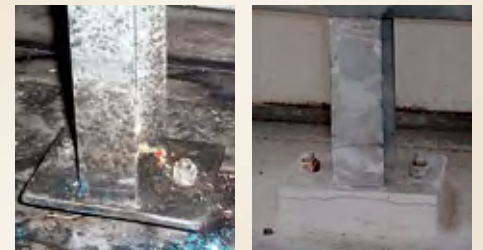


After

Low Temperatures

A major food manufacturing plant fitted guard rails within their cool room to prevent forklifts damaging the insulation walls. Originally concrete footings were installed but due to the low temperature environment (-9°C) they failed to fully cure.

With an application temperature range of -29°C to +46°C and one hour cure time, Loctite® Fixmaster® Magna-Crete proved to be the ideal product to repair the footings.



Culvert

A culvert is a concrete conduit through which water can flow under a road. The culvert picture right had deteriorated to a point where demolition and rebuilding was considered the most viable option of repair.

Estimated cost to demolish the culvert and rebuild was almost \$100k and would require traffic to be diverted for up to 8 weeks.

Using Loctite® Fixmaster® Magna-Crete the culvert's concrete walls were resurfaced and re-opened within 5 days without disruption to traffic.



Re-surfacing the culvert walls with Magna-Crete saved over 7 weeks labour

Did you know?

Concrete v's Fixmaster® Magna-Crete

Concrete is used for its compressive strength, however it is not suitable for repair of new/old concrete surfaces.

Concrete repairs are prone to delaminate and crack.

This table highlights differences between concrete and Fixmaster® Magna-Crete.

	Concrete	Fixmaster® Magna-Crete
Requires chemical bonding Agents to adhere to concrete	Yes	No
Minimum thickness required to achieve compressive strength	100mm	6mm
Curing time	28 days	1-24 hours
Chemical resistance	Low	High
Frees/thaw resistant	No	Yes

Case Histories – Conquering the Ultimate Test of Wear Resistance!

Bucket Reclaimer Repair

Bucket reclaimers are subject to excessive wear caused by the abrasive process of excavation. In particular, the inner wheel face (or diaphragm) and outer bucket walls are problematic, requiring protection to prevent structural failure.

Standard bucket reclaimer repair methods include welding, hard facing and wear liners, but all are time consuming to fabricate. Additionally, the above processes produce excessive heat which may damage the metal parts.

A major West Australian site sought the advice of Loctite® to provide an alternative repair method which would improve service life and reduce downtime.

Prior to application of Loctite® surface engineering composites the surface should be prepared to ensure optimal adhesion. In this case the bucket reclaimer surface was abrasive blasted, creating a surface profile minimum of 75 micron. A surface profile is critical to coating performance as it improves adhesion by increasing surface area and provides a keyed anchor pattern.

The Loctite® Nordbak® Wearing Compound was then mixed using a high torque power tool with a mixer attachment. After mixing the material was rubbed over the profile to wet the surface and prevent sagging on vertical applications. The balance of the material is then applied to desired thickness and trowelled to a smooth finish. Functional cure is achieved within 7 hours, so the reclaimer bucket was ready for work the next day.

Once cured the Loctite® Nordbak® Wearing Compound provides a

superior sacrificial surface that can be easily re-applied as required. Downtime and project planning has been significantly reduced as hot work permits and specialised labour are no longer required. Also this is a low weight solution compared with hard facing, less power is required to operate the reclaimer bucket. Most importantly the reclaimer bucket now has a longer service life due to the superior wearing properties of Loctite® Nordbak® Wearing Compound which features a hardness of 90 Shore D.



Reclaimer buckets are subject to excessive and constant wear

Case Histories – Protecting Surfaces

Exit Duct of Ball Mill

The exit duct of a mine ball mill was severely eroded and required immediate attention. Resurfacing using the traditional method was time consuming and required expertise.

The affected area was repaired on site with **Loctite® Nordbak® Wearing Compound**. The job was completed in minimum time, avoiding significant shutdown and labour costs.

The use of **Loctite® Nordbak® Wearing Compound** has increased the reliability of equipment. The frequency of repairs has been significantly reduced, minimising downtime and lowering costs.



Ball mill



Application of Loctite® Nordbak® Wearing Compound

Wear and Abrasion of Coal Pipe Bends in a Power Plant

The mill port outlet ducts get worn out because of continuous abrasion of pulverized coal. The previous method used to repair the coal pipe (pictured below) was patching from the outside.

The pipe bend was cleaned and resurfaced internally with **Loctite® Nordbak® Pneu Wear**. This has resulted in increasing the life of the pipe bend, minimising downtime and lowering costs.



The previous method used was patching from the outside.



Application of Loctite® Nordbak® Pneu Wear.

Surface Preparation Grades of Blast

A	Steel with mill scale layer intact and very minor, or no rusting		base metal colour appearing
B	Steel with spreading surface rust and the mill scale commenced flaking	2.5 (SP-10/N2)	Intensive blast clean leaving shading grey metal with only contaminates
C	Rusty steel with mill scale layer flaked and loose or lost but only minor occurrence of pitting	3 (SP-5/N1)	Complete blast clean with consistent metal colour all over and no visible contaminates
D	Very rusty steel with mill scale layer all rusted and extensive occurrence of pitting		
1	(SP-7/N4) Very light over clean with removal of loose surface contaminants		
2	(SP-6/N3) Substantial blast clean with wide spread, visible contaminate removal and		



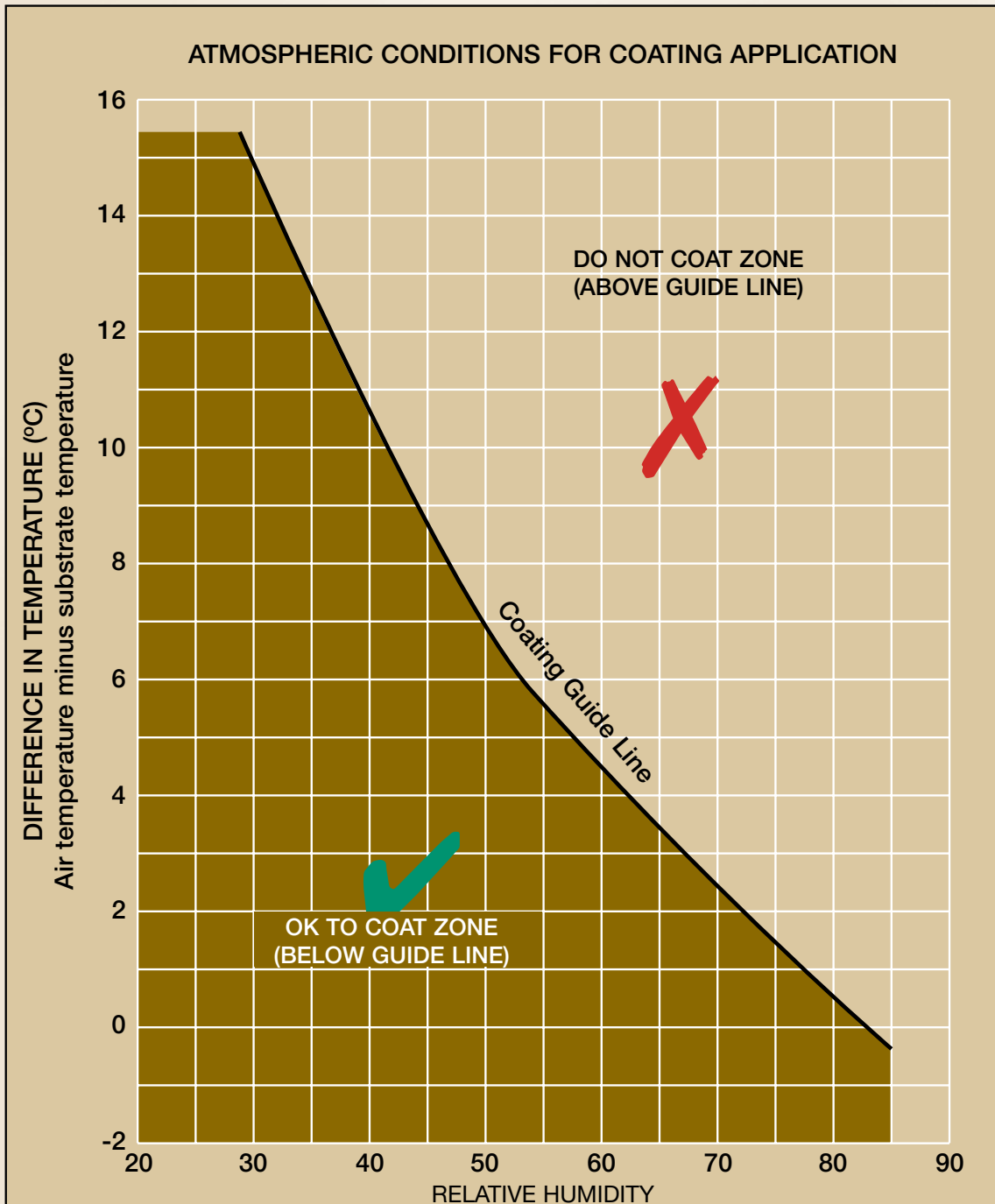
Climatic Conditions For Effective Coating

It is critical to the success of most coating systems, that the surface is completely free of moisture prior to and during paint application and curing.

DEWPOINT

Condensation of water (dew) from the atmosphere on to the surface will occur, given the right conditions.

For a given set of conditions, the temperature at which condensation will occur is called the Dewpoint. As long as the surface temperature is 3°C (or more) above the Dewpoint temperature, it is generally considered safe to paint as far as risk of condensation is concerned.



Loctite® Fixmaster® & Nordbak® – Properties Chart

Pg	Product	Item Number	Pack Size	Coverage @ 6mm Thickness	Colour	Dry Service Temperature Range	Compressive Strength • ASTM D695, N/mm ² (psi)	Elongation % ASTM D638
7	Fixmaster® Superior Metal	97473	408gm kit	210cm ²	Met. Grey	-29° to +160°C	124.09 (18,000)	–
7	Fixmaster® Steel Putty	99913	454gm kit	278cm ²	Met. Grey	-29° to +107°C	76.5 (11,100)	–
7	Fixmaster® Fast Set Steel Putty	39917	453gm kit	371cm ²	Met. Grey	-29° to +93°C	74.5 (10,800)	–
8	Fixmaster® Aluminum Putty	97463	454gm kit	464cm ²	Alum.	-29° to +93°C	77.9 (11,300)	–
8	Fixmaster® Aluminum Liquid	97453	453gm kit	278cm ³	Alum.	-29° to +93°C	117.2 (17,000)	–
8	Fixmaster® Underwater Repair Stick	82093	113g	40cm ²	Green/White Stick	-29° to +149°C	-	–
9	Fixmaster® Stainless Steel Putty	97443	454gm kit	232cm ²	Met. Grey	-29° to +107°C	82.7 (12,000)	–
9	Fixmaster® Wear Resistant Putty	98743	1.35kg kit	2259cm ²	Grey	-29° to +160°C	71 (10,360)	–
9	Fixmaster® Metal Magic Steel Stick	98853	113gm	40cm ²	Black	-30° to +121°C	82.7 (12,000)	-
11	Fixmaster® Rapid Rubber Repair - Dual Cartridge	96675 96677	400ml cartridge kit	568cm ³	Black	-29° to +82.2°C	–	360
13	Fixmaster® Flex 80 Putty	97423	453gm kit	604cm ²	Black	-29° to +82.2°C	–	350
13	Fixmaster® Urethane Sealant	39916	300ml	762cm ²	Grey	-40° to +82.2°C	–	1000
15	Fixmaster® Floor Fill	99361	10lb	0.36m ²	Grey	-29° to +107°C	103 (15,000)	–
15	Fixmaster® Magna-Crete	95555	18.9ltr kit	2.0m ²	Grey	-29° to +1093°C	89.6 (13,000)	–
15	Fixmaster® Crack Filler	1108886	8.6oz		Grey	-29°C to +57°C	67.12 (9800)	–
17	Nordbak® Wearing Compound	41782	10kg kit	0.8m ²	Grey	-28° to +180°C	110.3 (16,000)	–
17	Nordbak® Fast Cure Wearing Compound	96373	6lb	0.2m ²	Blue	-29°C to 107°C	68.5 (10,000)	–
17	Nordbak® High Impact Wearing Compound	1214823	11.35kg kit	0.8m ²	Grey	-29° to +121°C	82.7 (12,000)	–
18	Nordbak® Pneu-Wear	42089	10kg kit	0.8m ²	Grey	-29° to +180°C	85 (12270)	–
18	Nordbak® Ultra High Temperature Pneu-Wear	96332	11.32kg kit	0.8m ²	Grey	-29° to +288°C	–	–
18	Nordbak® Crusher Backing Compound	36123	10kg kit	0.72m ²	Blue	Max 77°C	106.9 (15,500)	–
19	Nordbak® Hi-Impact Crusher Backing Compound	36122	10kg kit	0.72m ²	Brown	-28°C to +104°C	75.8 (11,000)	–
19	Nordbak® Sprayable Ceramic - Dual Cartridge	43269	900ml kit	*1.3m ²	Green	-29° to +110°C	106 (15,400)	–
19	Nordbak® Brushable Ceramic (Grey)	42087 42076	1kg kit 2kg kit	*1.1m ² *2.2m ²	Grey	-29° to +125°C	70 (10,150)	–
20	Nordbak® High Temperature Brushable Ceramic	42088	1kg kit	*1.1m ²	Red	-29° to +288°C	110.3 (16,000)	–
20	Nordbak® Chemical Resistant Coating	96092	5.43kg kit	*6.8m ²	Grey	-29° to +160°C	62 (9,840)	–
20	Fixmaster® Concrete Sealer	1304684	1kg kit	*2.1m ²	White liquid	-29° to +107°C	–	–

6.0 Technical References

Pg	Product	Shear Strength ASTM D1002, N/mm ² (psi), 0.1mm gap and etch	Tensile Strength • ASTM D638	Hardness ASTM D-2240 Shore D	Working Time Minutes @ 25°C	Functional Cure (HRS @25°C)	Mix Ratio by volume	Mix Ratio by weight
7	Fixmaster® Superior Metal	12.4 (1,800)	27 (3,915)	86	20	6	4:1	7.25:1
8	Fixmaster® Steel Putty	11.7 (1,700)	33.4 (4,900)	85	30	6	2.5:1	6.25:1
8	Fixmaster® Fast Set Steel Putty	13.8 (2,000)	31.7 (4,600)	80	3	10 min	1:1	100:56.5
7	Fixmaster® Aluminum Putty	10.3 (1,500)	27.6 (4,000)	87	20	6	4:1	6.3:1
7	Fixmaster® Aluminum Liquid	15.2 (2,200)	41.4 (6,000)	85	20	6	5:1	9:1
8	Fixmaster® Underwater Repair Stick	-	-	-	3	10 min	-	-
9	Fixmaster® Stainless Steel Putty	9.0 (1,300)	31.7 (4,600)	85	20	6	4:1	9:1
9	Fixmaster® Wear Resistant Putty	10 (1,450)	33.8 (4,900)	85	30	6	2:1	2:1
9	Fixmaster® Metal Magic Steel™ Stick	4.8 (700)	17.2 (2,500)	80	3	10 min	-	-
11	Fixmaster® Rapid Rubber Repair - Dual Cartridge	-	9 (1,300)	82	1	2	1:1	-
13	Fixmaster® Flex 80 Putty	-	10.3 (1,500)	87	10	8	10:4	72:28
13	Fixmaster® Urethane Sealant	1.2 (170)	1.4 (200)	33 (Shore A)		3 days		
15	Fixmaster® Floor Fill	-	-	-	40 mins	1 day	4.6:1 to 9.8 filler	16.3:2 to 80.8 filler
15	Fixmaster® Magna-Crete	-	-	-	15	1	application specific	application specific
15	Fixmaster® Crack Filler	-	-	-	8	2	1:1	-
17	Nordbak® Wearing Compound	-	-	90	30	7	2:1	2:1
17	Nordbak® Fast Cure Wearing Compound	-	-	90	10	3	2:1	2:1
17	Nordbak® High Impact Wearing Compound	-	-	85	30	7	2:1	2:1
18	Nordbak® Pneu-Wear	34.5 (5,000)	-	85	30	7	4:1	4:1
18	Nordbak® Ultra High Temperature Pneu-Wear	-	-	90	30	8 hrs + Post Cure 2hrs @ 148°C	2:1	2.27:1
18	Nordbak® Crusher Backing Compound	-	-	90	10	8	8.55:1	100:6.5
19	Nordbak® Hi-Impact Crusher Backing Compound	-	-	85	30	8	5.3:1	100:10.4
19	Nordbak® Sprayable Ceramic - Dual Cartridge	31 (4,500)	-	86	Spray to surface	6	Spray to surface	-
19	Nordbak® Brushable Ceramic (Grey)	13.8 (2,000)	-	85	30	6	2.75:1	4.8:1
20	Nordbak® High Temperature Brushable Ceramic	13.8 (2,000)	-	90	180	8hrs plus Post Cure 3hrs @ 149°C	2.6:1	4.25:1
20	Nordbak® Chemical Resistant Coating	-	-	85	20	16	2.3:1	3.4:1
20	Fixmaster® Concrete Sealer	-	-	-	15 mins	Topcoat to be applied when tacky	4.6:1	-

Loctite® Fixmaster® & Nordbak® – Chemical Compatibility Chart

Range summary only. For maximum chemical capability use Loctite® Fixmaster® High Performance Quartz or Loctite® Nordbak® Chemical Resistant Coating. Please consult your Loctite® Application Engineer if further product specific information is required.

COMPATIBLE	✓
NOT COMPATIBLE	X

Acetic Acid X
Acetic Acid X
Acetone X
Alcohol, Amyl ✓
Alcohol, Benzyl ✓
Alcohol, Butyl ✓
Alcohol, Ethyl X
Alcohol, Methyl X
Alcohol, Propyl ✓
Alum, Ammonium ✓
Alum, Chrome ✓
Alum, Potassium ✓
Alum, Sodium ✓
Aluminium Chloride ✓
Aluminium Sulphate ✓
Ammonia Solutions ✓
Ammonium Carbonate ✓
Ammonium Chloride ✓
Ammonium Nitrate ✓
Ammonium Phosphate ✓
Ammonium Sulphate ✓
Amyl Acetate X
Aniline ✓
Aniline Dyes ✓
Asphalt, Emulsions ✓
Asphalt, Molten ✓
Barium Carbonate ✓
Barium Chloride ✓
Barium Hydroxide ✓
Barium Sulphate ✓
Benzene X
Brake Fluids ✓
Butyl Acetate X
Calcium Bisulphate ✓
Calcium Carbonate ✓
Calcium Chloride ✓
Calcium Hydroxide ✓
Calcium Sulphate ✓
Carbon Tetrachloride X
Carbonic Acid ✓
Carnauba Wax ✓
Chalk ✓
China Clay ✓
Chloroacetic Acid X
Chlorobenzene, Dry X
Chloroform, Dry X
Chlorosulfonic Acid X
Chromium Chloride ✓
Chromium Sulphate ✓
Clay ✓
Creosote X
Creosote, Cresylic Acid X
Cyclohexane ✓
Diacetone Alcohol X
Dibutyl Phthalate ✓
Drying Oil ✓
Ethyl Acetate X
Ethylene Glycol ✓
Ferric Chloride ✓
Ferric Nitrate ✓
Ferric ✓
Ferrous Chloride ✓
Ferrous Sulphate, 10% ✓
Ferrous Sulphate (Sat) ✓
Fertilizer Sol ✓
Freon ♦ ✓
Fuel Oil ✓
Gasoline, Aviation ✓
Gasoline, Motor ✓
Glue, Animal Gelatine ✓
Glue, Plywood ✓
Glycerol ✓
Glycol Amine ✓
Grease, Lubricating ✓
Heptane ✓
Hexane ✓
Hydrogen Peroxide (dil) ✓
Hydrogen Peroxide (con) ✓
Ink ✓
Isooctane ✓
Isopropyl Alcohol ✓
Kerosene ✓
Lactic Acid ✓
Magnesium Bisulfite ✓
Magnesium Chloride ✓
Magnesium Hydroxide ✓
Magnesium Sulphate ✓
Maleic Acid ✓
Manganese Chloride ✓
Mercuric Chloride ✓
Mercury ✓
Mercury Dry ✓
Methyl Acetate X
Methyl Cellosolve ♦ X
Methyl Ethyl Ketone X
Methylene Chloride X
Mineral Spirits ✓
Mud ✓
Naphtha ✓
Naphthalene ✓
Nickel Ammonium Sulphate ✓
Nickel Chloride ✓
Nickel Sulphate ✓
Nitric Acid, 20% X
Oil, Creosote ✓
Oil, Emulsified ✓
Oil, Fuel ✓

Oil, Lubricating ✓
Ozone, Wet ✓
Paint Remover, Sol. Type ✓
Paraffin, Molten ✓
Paraffin, Oil ✓
Perchloroethylene (Dry) X
Petroleum Ether ✓
Petroleum Jelly ✓
Phosphoric Acid, 10% cold ✓
Phosphoric Acid, 10% hot ✓
Phthalic Acid ✓
Potash ✓
Potassium Bromide ✓
Potassium Carbonate ✓
Potassium Chlorate ✓
Potassium Chloride Sol ✓
Potassium Chromate ✓
Potassium Dichromate ✓
Potassium Ferricyanide ✓
Potassium Hydroxide ✓
Potassium Iodide ✓
Potassium Nitrate ✓
Potassium Permanganate ✓
Potassium Sulphate ✓
Propyl Alcohol ✓
Propylene Glycol ✓
Rosin, Wood ✓
Rosin, in Alcohol ✓
Rosin, Size ✓
Rubber, Latex ✓
Sewage ✓
Silicone Fluids ✓
Silver Nitrate ✓
Soap Solutions (Stearates) ✓
Sodium Acetate ✓
Sodium Aluminate ✓
Sodium Bisulfite ✓
Sodium Bromide ✓
Sodium Carbonate ✓
Sodium Chlorate ✓
Sodium Cyanide ✓
Sodium Hydroxide ✓
Sodium Hydro., 20% cold ✓
Sodium Hydro., 20% hot ✓
Sodium Hydro., 50% cold ✓
Sodium Hydro., 50% hot ✓
Sodium Hydro., 70% cold ✓
Sodium Hydro., 70% hot ✓
Sodium Metasilicate ✓
Sodium, Nitrate ✓
Sodium, Nitrite – Nitrate ✓
Sodium Phosphate, Mono ✓
Sodium Phosphate, Tri ✓
Sodium Silicate ✓
Sodium Sulphide ✓
Stannic Chloride ✓
Starch ✓
Starch Base ✓
Stearic Acid ✓
Steep Water ✓
Sterilization Steam ✓
Styrene ✓
Sulphuric Acid, 7-40% ✓
Sulphuric Acid, 40-75% X
Sulphuric Acid, 75-95% X
Sulphuric Acid, 95-100% X
Tannic Acid (cold) ✓
Tamin ✓
Tar and Tar Oil ✓
Tartaric Acid ✓
Tetraethyl Lead ✓
Toluene X
Trichloroethylene X
Trichloroethylene, Dry X
Turpentine ✓
Water, Acid, Below pH 7 ✓
Water, pH 7 to 8 ✓
Water, Alkaline, Over pH 8 ✓
Water, De-Ionised ✓
Water, De-Ionised, Low Conductivity ✓
Water, Gritty ✓
Water, Mine Water ✓
Water, Potable ✓
Water, River ✓
Water, Sandy ✓
Water, "White", low pH ✓
Water, "White", high pH ✓
Wax ✓
Wax, Emulsions ✓
Xylene X
Zinc Chloride ✓
Zinc Galvanizing ✓
Zinc Hydrosulphite ✓
Zinc Sulphate ✓

GASES

Acetylene ✓
Air ✓
Butane ✓
Carbon Dioxide ✓
Carbon Monoxide ✓
Chlorine Dry ✓
Chlorine Wet ✓
Coke, Oven Gas – Cold ✓
Coke, Oven Gas – Hot ✓
Ethane ✓
Gas, Manufacturing ✓
Gas, Natural ✓
Hydrogen Gas, Cold ✓
Methane ✓
Natural Gas, Dry ✓
Nitrogen Gas ✓
Nitrous Oxide ✓
Ozone ✓
Producer Gas, 50 PSI ✓
Propane ✓
Sulphur Dioxide ✓
Sulphur Dioxide, Dry ✓
Sulphur Trioxide Gas ✓

NOTE: 1. The above information does not constitute a recommendation of adhesive use. It is intended only as a guide for consideration by the purchaser with the expectation of favourable confirming test results. It is impossible to test adhesives reaction with the multitude of chemicals in existence, therefore, compatibility has been estimated based on a wide variety of customer experience.
 2. With the stringent action of such chemicals as Freon, strong cold acids and caustics, thorough evaluation is suggested. Sealing of hot corrosive chemicals is not recommended.
 3. Refer to Technical Data Sheet or contact Loctite Technical Services for use with chemicals not covered by this information.

♦Listing(s) may be Brand Name(s) or Trademarks for chemicals of Corporations other than Henkel.
 (This is a list of chemical stability only. It does not constitute approval for use in the processing of foods, drugs, cosmetics, pharmaceuticals, and ingestible chemicals).
 Loctite® adhesives are not recommended for use in pure oxygen or chlorine environments or in conjunction with strong oxidising agents, as explosive reaction can result.

Loctite® Repair, Rebuild and Protect

In every industrial sector worldwide, plant and equipment is subject to the effects of Wear / Abrasion, Corrosion / Erosion and Chemical Attack, shortening their expected service life. Destruction of these assets is greatly attributed to the constant degradation of exposed equipment working surfaces. This incremental and continual attack repeatedly strips the surface, causing substrate reduction and loss of structural integrity.

After a Loctite® Surface Engineering Workshop, your work force will have the knowledge and the tools to do the following:

Save Time & Money

- Reduce routine maintenance tasks
- Reduce standard repair time
- Reclaim worn parts
- Save money

Improve Reliability

- Extend mean time between failure
- Fewer needless variables for Planned Maintenance
- Enlarged reliability culture

Workshop Features

Pre-plant survey

- Workshop can be tailored to meet your needs through a plant tour and pre-survey

Hands-on training

- Job related and product specific
- Various applications cover all trades
- Training materials supplied
- Conducted on-site

Key Reasons for assets failure

- Review of common failure causes and prevention
- Solutions to prevent assets failure
- Solutions to extend assets life

In-plant follow up

- Expert application assistance

For more information about the Loctite® Surface Engineering Workshop or to schedule a training session at your workplace, call 1300 88 555 6

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