

## LOCTITE® PC 7641™

Known as LOCTITE® Big Foot™ Water Based Primer/Sealer  
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### PRODUCT DESCRIPTION

LOCTITE® PC 7641™ provides the following product characteristics:

<b>Technology</b>	Epoxy
<b>Appearance</b>	clear
<b>Components</b>	Two-component
<b>Mix Ratio, by volume - Base : Hardener</b>	3 : 1
<b>Cure</b>	Room temperature cure
<b>Application</b>	Non-slip coating
<b>Specific Benefit</b>	<ul style="list-style-type: none"><li>• Applies easily</li><li>• Low odor</li><li>• Low VOC</li><li>• Increases adhesion and coverage of Loctite® Big Foot™ Non-Slip Coatings</li><li>• Resists abrasion</li><li>• Resists most mild acids, alkalis, salts, gasoline, and oils</li></ul>

LOCTITE® PC 7641™ is a sealing system designed to increase the adhesion and coverage of Loctite® Big Foot™ non-slip coatings on concrete, wood, tile and other porous substrates. LOCTITE® PC 7641™ is designed to be used as a base coat for Loctite® Big Foot™ non-slip coatings, except Loctite® Big Foot™ Acrylic Pedestrian Grade. It dries quickly, ensuring good intercoat adhesion with topcoats. Typical applications include use in kitchens, hospitals, and beverage plants. This product is typically used in applications with an operating range of -29 °C to +60 °C.

### TYPICAL PROPERTIES OF UNCURED MATERIAL

#### Mixed:

Volume of Solids, %	38
VOC, g/l	120
Coverage, 2 mils	29.7 m <sup>2</sup> per 3.78 l (320 ft <sup>2</sup> /gal)

### TYPICAL CURING PERFORMANCE

#### Curing Properties

Cure Time @ 25 °C, hours	3 to 6
Pot life, hours	2
Recoat Time @ 21 °C, hours	6

### 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 7641™ can be applied to any clean, dry surface. Recommended methods of cleaning are as follows:

1. All surfaces to be coated should be sound, clean, dry and free of all contaminants.
2. Loose dirt and dust are best removed by a stiff bristle brush or by blowing down with dry, oil-free compressed air.
3. Oil, wax and grease should be removed by dissolving in a water-based cleaner/degreaser such as Loctite® Natural Blue Cleaner and Degreaser. Rinse thoroughly with fresh water while the dissolved solution is still wet. An alternate method is to clean with appropriate solvents such as mineral spirits as per SSPC-SP-1. It is important that the solvent be removed from the surface while still liquid and not be allowed to evaporate during the cleaning process and redeposit oil or grease on the deck. Ample solvent should be applied to the surface to completely dissolve the grease and oil. The solvent containing the dissolved grease and oil should be wiped up with clean rags before the solvent dries.
4. Depending on concentration and type, chemical contamination should be removed by detergent power washing followed by a liberal fresh water while the detergent is still wet. Allow surface to completely dry.
5. After cleaning, any remaining loose particles should be removed by brushing or blowing with dry, oil-free compressed air.

##### New Concrete:

1. New concrete should be properly cured for at least 30 days with good ventilation.

2. After proper curing, new floors must be swept clean and all contaminants which might interfere with the adhesion of the coating system including laitance, curing membranes, surface hardeners, greases and oils be removed.

3. An appropriate profile must be created using chemical or mechanical means.

4. The preferred method to prepare floor surfaces and to remove paint, laitance, curing membranes and surface hardeners is by mechanical removal of the same with a portable shot blast cleaning machine.

5. Chemical cleaning of laitance and unbounded particles can be accomplished by etching the surface with a muriatic acid or buffered acid solution. Follow acid manufacturer's application and safety instructions. After the acid has finished reacting with the concrete, the residue should be removed by a liberal fresh water rinse or preferably by power washing. Allow the surface to completely dry.

6. NOTE: Acid etching will not remove oil, grease or wax. If the acid does not bubble or foam when spread on the concrete, the surface should be examined for films or oil, grease, wax, curing membranes, hardeners or other sealers. If such film is present, it must be removed.

#### Aged and Uncoated Concrete Floors:

Proceed as for **New Concrete** with particular emphasis on examinations for grease, oil and chemical contamination and subsequent adequate cleaning.

#### Wood:

Remove any weathered wood to expose clean, sound wood. Smooth wood should be sanded to roughen up the surface.

#### Tile and Fiberglass:

Glazed or ceramic tile and glazed fiberglass must be sanded to remove all glaze and to roughen up the surface. Remove any residual sanding dust by air blowing or wiping with alcohol.

#### Application Method:

LOCTITE® PC 7641™ is a two-part compound. Stir thoroughly (approximately 3 to 6 minutes) with a mechanical mixer, Loctite® Big Foot™ Mixer Blades. Apply by using:

1. Roller Application - Use the bristle roller, Loctite® Big Foot™ Bristle Roller Cores. Apply uniformly.
2. Brush Application - Use a 10cm wide thin stock brush.
3. Spray Application - Airless, air assisted or conventional paint spray equipment can be used.
4. Loctite® Big Foot™ coatings can be successfully applied to a primed surface after 3 to 6 hours @ 21°C.
5. Clean tools immediately after completing installation using soap and water.

**NOTE:** If Big Foot is not applied within 72 hours, the primed surface must be mechanically abraded or grit-blasted and LOCTITE® PC 7641™ reapplied.

**NOTE: Unlike conventional epoxies, LOCTITE® PC 7641™ will not harden in the can. It will remain liquid after its two hour pot life. Therefore, no material should be used two hours after mixing as it will not cure properly.**

#### 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 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 1.1