LOCTITE®

Research, Development & Engineering

Tallaght Business Park,

Dublin, Ireland

Product Description Sheet
Product 7922

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PRODUCT DESCRIPTION

LOCTITE® Product 7922 Zinc-Spray is a sprayable, rapid curing zinc dust corrosion protection primer in an aerosol based on zinc, with an epoxy bonding agent. The material provides optimal protection against corrosion for iron and steel as a result of its electro-chemical interaction. The dry film bonds well to cleaned metal parts and features a high resistance to abrasive wear. It also conducts electricity, wet as well as dry. As a result of its "self-healing properties", Product 7922 is able to close small lesions and hence offer lasting protection for the steel surfaces.

APPLICATION AREAS

Product 7922 is used in vehicle bodywork repairs to galvanize welding points and the joints of those parts which were originally galvanized, in particular those which will not be painted. Product 7922 also serves as corrosion protection between welding flanges during MIG and spot welding. Product 7922 is used in structural steel engineering, in equipment, machinery, boat and appliance manufacture. It is particularly suitable where a high degree of corrosion protection and mechanical strain are required.

TECHNICAL DATA

Colour	Grey
Odour	Of solvents
Density	≈ 1.0 g/cm^3
Corrosion resistance Salt spray test DIN 50021 (35°C, salt solution 5 %, Ih)	No corrosion
Dry-film thickness	70 µm
Adhesion according to DIN 53151	Crosscut characteristic value GT 0-1
Cleaning	Acetone
In service temperature range and temperature resistance:	-50 °C to 500 °C (primer fully dried)

PRETREATMENT

Surfaces to be treated with Product 7922 have to be cleaned well and rust must be removed. In addition any old coats of paint or rust converters etc… should not be overspread, but should be removed prior to spraying. The areas must be dry and grease, dirt and dust free. Where possible the surfaces should be sanded; steel surfaces are prepared by sand blasting to SA 2.5 according to DIN 55928.

APPLICATION CONDITIONS

Product 7922 should not be applied below 10 % and above 80 % relative humidity. The temperature of metal surfaces must not exceed 30 °C, however, metal temperature should at least be 3 °C above the dew point.

APPLICATION

The material should be at room temperature at time of application. Shake the can well, continuing for 1 minute after the ball bearing becomes audible. Hold can vertically while spraying and apply in two to three crossing patterns at a distance of about 20 to 30 cm.
After use the can should be inverted and the spray activated until the jet is cleared and only propellant is emitted.

DRYING

Both air-drying and oven drying are possible. Where air-drying is used the ambient temperature, the effective metal temperature and also the relative humidity can affect drying times. Forced oven drying assists curing.
The following data can be used as guidelines

Air-drying

Dust-dry:	≈ 30 min
Touch-dry:	≈ 60 min
Cured:	24 - 48 h

Oven drying

Ventilation time:	≈ 10 min
Baking time:	≈ 30 min
Baking temperature	60 – 80 °C

PAINTING

In instances where painting is necessary, a trial coat should be applied to the thoroughly dried Product 7922 coating to test for compatibility. Good results are obtained with one component finish paints.

CLEANING

Remove splashes immediately with acetone.

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 oxidising 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 10 °C to 20 °C (50 °F to 68 °F) unless otherwise labelled. 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 Centre.

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 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 Loctite 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 Loctite Corporation's products.** Henkel Loctite 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 Loctite 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.