Technical Data Sheet

LOCTITE® SF 1768™

Known as LOCTITE® FT-H ACCELERATOR™
August 2015

PRODUCT DESCRIPTION

LOCTITE® SF 1768™ provides the following product characteristics:

Technology	Cyanoacrylate Accelerator
Chemical Type	Amine (active ingredient)
Solvent	n-Heptane / Acetone
Active Ingredient Concentration, %	1.0 to 1.3[LMS]
Appearance	Transparent, colorless to slightly amber solution[LMS]
Viscosity	Very low
Cure	Not applicable
Application	CA adhesive cure accelerator

LOCTITE® SF 1768™ quickens the cure of cyanoacrylate adhesives where surface acidity or very low humidity levels are encountered. It is also useful for curing of very high viscosity material and for gap filling between substrates. May be preapplied or post applied by brush, spray or dropper.

TYPICAL PROPERTIES

Specific Gravity @ 25 °C	0.715
Viscosity @ 20 °C, mPa·s (cP)	1
Flash Point - See SDS	

TYPICAL PERFORMANCE

Fixture time and cure speed achieved as a result of using LOCTITE® SF 1768™ depend on the adhesive used and the substrate bonded.

GENERAL INFORMATION

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected with a sealant for chlorine or other strong oxidizing materials.

For safe handling information on this product, consult the Safety Data Sheet (SDS).

Caution:

Only Nitrogen or Argon should be used when dispensing this material from a pressurized system.

Under no circumstances should activator and adhesive be mixed directly as liquids.

Use only in a well ventilated area

Directions for use
Surface Activation

1. Apply one coating of Activator to the area to be bonded by spray, brush or dipping. Contaminated surfaces may need special cleaning or degreasing prior to activation to remove any soluble contamination
   NOTE: Because the solvent base can affect certain plastics or coatings, checking all surfaces for compatibility is recommended.
2. Allow the accelerator sufficient time to evaporate, under good ventilation, until the surfaces are completely dry (approximately 15 to 30 seconds).
3. Apply cyanoacrylate product immediately after solvent has dried.
4. Where possible, for a few seconds move surfaces in relation to each other to properly distribute the adhesive and to achieve maximum activation. Secure the assembly, and wait for surfaces to fixture before any further handling.

Loctite Material Specification[LMS]

LMS dated May 01, 2002. Test reports for each batch are available for the indicated properties. LMS test reports include selected QC test parameters considered appropriate to specifications for customer use. Additionally, comprehensive controls are in place to assure product quality and consistency. Special customer specification requirements may be coordinated through Henkel Quality.

Storage

This activator is classified as **HIGHLY FLAMMABLE** and must be stored in an appropriate manner in compliance with relevant regulations. Do not store near oxidising agents or combustible materials. The product is light sensitve and accordingly, translucent containers should be kept in a dark place when not in use. Store product in the unopened container in a dry location. Storage information may also be indicated on the product container labelling.
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 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

(°C x 1.8) + 32 = °F
kV/mm x 25.4 = V/mil
mm / 25.4 = inches
µm / 25.4 = mil
N x 0.225 = lb
N/mm x 5.71 = lb/in
N/mm² x 145 = psi
MPa x 145 = psi
N·m x 8.851 = lb·in
N·m x 0.738 = lb·ft
N·mm x 0.142 = oz·in
mPa·s = cP

Reference 0.1