

# LOCTITE<sup>®</sup> SF 736

Known as LOCTITE<sup>®</sup> 736  
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## PRODUCT DESCRIPTION

LOCTITE<sup>®</sup> SF 736 provides the following product characteristics:

<b>Technology</b>	Activator for LOCTITE <sup>®</sup> anaerobic structural adhesives and sealants
<b>Chemical Type</b>	Aldehyde-amine condensate and Organocopper compound
<b>Solvent</b>	Trichlorethylene and Isopropanol
<b>Appearance</b>	Light amber liquid <sup>LMS</sup>
<b>Viscosity</b>	Very low
<b>Cure</b>	Not applicable
<b>Application</b>	Cure acceleration of LOCTITE <sup>®</sup> anaerobic structural products

LOCTITE<sup>®</sup> SF 736 is used where increased cure speed of LOCTITE<sup>®</sup> anaerobic structural products is required. It is especially recommended for applications with passive metals or inert surfaces and with large bond gaps.

## TYPICAL PROPERTIES

Specific Gravity @ 25 °C	1.3
Viscosity @ 20 °C, mPa·s (cP)	3
Flash Point - See SDS	
On Part Life, minutes	≤30

## TYPICAL PERFORMANCE

### Adhesive Properties

After 2 minutes @ 22 °C:

Lap Shear Strength, ISO 4587: Steel and LOCTITE <sup>®</sup> 312™, two side activation	N/mm <sup>2</sup> ≥11 <sup>LMS</sup> (psi) (≥1,595)
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### Handling precautions

The solvent can affect certain plastics or coatings. It is recommended to check all surfaces for compatibility before use.

## 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).**

**Under no circumstances should activator and adhesive be mixed directly as liquids. Use only in a well ventilated area.**

Where aqueous washing systems are used to clean the surfaces before bonding, it is important to check for compatibility of the washing solution with the adhesive. In some cases these aqueous washes can affect the cure and performance of the adhesive.

### Directions for use:

1. Spray or brush on the activator on both mating surfaces to be bonded. For small gaps, treatment of only one surface may be adequate. Contaminated surfaces may need repeated treatment or special degreasing prior to activation to remove any dissolvable contamination. Porous surfaces may need two treatments of activator.
2. Allow the solvent time to evaporate under good ventilation until the surfaces are completely dry.
3. After activation, parts should be bonded within 30 minutes. Contamination of the surface before bonding should be prevented.
4. Apply the Loctite anaerobic product to one or both surfaces and assemble parts immediately. If activator is applied to one surface only, apply adhesive to the non-activated surface.
5. Where possible, move surfaces in relation to each other for a few seconds on assembly to properly distribute the adhesive and for maximum activation..
6. Secure the assembly and await fixturing before any further handling..

### Loctite Material Specification<sup>LMS</sup>

LMS dated July 08, 2004. 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

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