Technical Data Sheet

LOCTITE® SF 7407™

Known as LOCTITE® 7407™
May 2015

PRODUCT DESCRIPTION

LOCTITE® SF 7407™ provides the following product characteristics:

Technology	Activator for LOCTITE® toughened acrylic adhesives
Chemical Type	Copper modified organic accelerator
Appearance	Clear, yellow to amber liquid with a greenish tinge
Components	One component - requires no mixing
Solvent	Heptane / Isopropanol*
Cure	Not applicable
Application	Cure promotion of toughened acrylic adhesives
Specific Benefit	Does not contain CFC

LOCTITE® SF 7407™ is a non-CFC solvent based surface activator. LOCTITE® SF 7407™ is designed to initiate and promote rapid cure of Loctite® toughened acrylic adhesives.

*Heptane / Isopropanol is an environmentally friendly solvent with zero ozone depletion potential.

TYPICAL PROPERTIES

Specific Gravity @ 25 °C	0.8
Flash Point - See SDS	
Viscosity @ 20°C, mPa·s (cP)	1 to 2
Vapour Pressure, hPa	45
On Part Life, hours	24
TLV (ACGIH), ppm	600

TYPICAL PERFORMANCE

Fixture time and cure speed achieved as a result of using LOCTITE® SF 7407™ depend on the adhesive used, the substrate bonded, surface cleanliness and whether one or two surface activation is used.

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).

Handling precautions

Activator must be handled in a manner applicable to highly flammable materials and in compliance with relevant local regulations. Special care must be taken to avoid contact of the product or its vapour with naked flame or any electrical equipment that is not flame proofed.

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

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

Directions for use

Surface Activation

1. Most surfaces may be bonded "as received" but contamination such as loose oxide layers or excessive oil may affect cure speed and bond strength. Cleaning is recommended if maximum strength is required.
2. Brush on the activator to one of the mating surfaces to be bonded. Apply adhesive to other surface.
3. For large gaps (>0.4 mm) or where maximum cure speed is required then treatment of both surfaces is recommended.
4. Allow 1 to 5 minutes for solvent to evaporate. After the solvent evaporates, the active ingredients will appear wet, and will remain active for up to 2 hours after application. Contamination of the surface before bonding should be prevented.
5. Where adhesive is applied onto an activated surface, assembly should be completed as quickly as possible (within 15 seconds).
6. Secure the assembly and await fixturing before any further handling..
7. Recap product after use.

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

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. 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

Note:
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Reference 0.2