

**LOCTITE® SF 7451™**Known as LOCTITE® 7451™  
March 2014**PRODUCT DESCRIPTION**

LOCTITE® SF 7451™ provides the following product characteristics:

<b>Technology</b>	Cyanoacrylate Activator
<b>Chemical Type</b>	Amine (active ingredient)
<b>Appearance</b>	Transparent colorless to slightly amber liquid <sup>LMS</sup>
<b>Solvent</b>	Acetone
<b>Active Ingredient Concentration, %</b>	0.8 to 1.0
<b>Viscosity</b>	Very low
<b>Cure</b>	Not applicable
<b>Application</b>	CA adhesive cure accelerator

LOCTITE® SF 7451™ has been formulated with "cleanroom" grade acetone and is suitable for use in the assembly of disposable medical devices. LOCTITE® SF 7451™ is used where increased cure speed of LOCTITE® cyanoacrylate adhesives is required. It can be either pre- or post-applied to the bond. The product is especially suited for post-application on cyanoacrylate adhesive to ensure rapid fixturing.

**ISO-10993**

An ISO 10993 Test Protocol is an integral part of the Quality Program for LOCTITE® SF 7451™. LOCTITE® SF 7451™ has been qualified, in conjunction with LOCTITE® 4014, to Loctite's ISO 10993 Protocol as a means to assist in the selection of products for use in the medical device industry. Certificates of Compliance are available at [www.loctite.com](http://www.loctite.com) or through the Henkel Loctite Quality Department.

**TYPICAL PROPERTIES**

Specific Gravity @ 25 °C	0.79
Viscosity @ 20 °C, mPa·s (cP)	0.3 to 0.5
Drying Time @ 20 °C, seconds	≤30
On Part Life, minutes	≤1
Infrared Spectroscopy	To match standard <sup>LMS</sup>
Flash Point - See SDS	

**TYPICAL PERFORMANCE**

Fixture time and cure speed achieved as a result of using LOCTITE® SF 7451™ depend on the adhesive used and the substrate bonded.

Fixture Time, ISO 4587, seconds:

Steel (degreased) using LOCTITE® 495™, ≤15  
, single side activation

(Fixture time is defined as the time to develop a shear strength of 0.1 N/mm<sup>2</sup> )

**Handling precautions**

Activator must be handled in a manner applicable to highly flammable materials and in compliance with relevant local regulations.

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.**

**Directions for use****Post Activation**

1. Apply Loctite cyanoacrylate to the parts to be bonded or fixed.
2. Apply Activator over all exposed cyanoacrylate adhesive by spray or drop. (Typically use one drop of activator per drop of exposed adhesive).

**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.
2. Allow LOCTITE® SF 7451™ to fully evaporate from parts prior to bonding to avoid solvent entrapment within the bond joint.
3. Apply the Loctite cyanoacrylate product immediately after drying or not more than 45 seconds thereafter.
4. Activator can be re-applied if necessary if there is a delay of more than 45 seconds between original activator and adhesive application.

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

LMS dated March 26, 1996. 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 sensitive 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**

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$   
 $\text{kV/mm} \times 25.4 = \text{V/mil}$   
 $\text{mm} / 25.4 = \text{inches}$   
 $\mu\text{m} / 25.4 = \text{mil}$   
 $\text{N} \times 0.225 = \text{lb}$   
 $\text{N/mm} \times 5.71 = \text{lb/in}$   
 $\text{N/mm}^2 \times 145 = \text{psi}$   
 $\text{MPa} \times 145 = \text{psi}$   
 $\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$   
 $\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$   
 $\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$   
 $\text{mPa}\cdot\text{s} = \text{cP}$

**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 1.2