

LOCTITE® SF INI1

June 2020

PRODUCT DESCRIPTION

LOCTITE® SF INI1 provides the following product characteristics:

Technology	Activator for LOCTITE® toughened acrylic adhesives
Chemical Type	Substituted dihydropyridine
Solvent	None
Appearance	Amber to light brown liquid
Viscosity	Very low
Cure	Not applicable
Application	Cure promotion of toughened acrylic adhesives

LOCTITE® SF INI1 is designed to initiate the cure of LOCTITE® toughened acrylic adhesive LOCTITE® AA F246.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Specific Gravity @ 25°C 0.97

Viscosity @ 25°C, mPa.s (cP)
U-Tube Viscometer 60

TYPICAL PERFORMANCE

Fixture time and cure speed achieved as a result of using LOCTITE® SF INI1 depend on the substrate bonded, surface cleanliness and whether one or two surface activation is used.

Fixture Time @ 22°C, ISO 4587, minutes: 5
Steel (degreased) using LOCTITE® AA F246
single side activation

(Fixture time is defined as the time to develop a shear strength of 0.1 N/mm²)

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).

Directions For Use:

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 15.8 mils) or where maximum cure speed is required then treatment of both surfaces is recommended.
4. The activator will not dry and will remain active for up to 30 minutes. Bond assembly should be completed within this time.
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.

Handling Precautions

Users are reminded that all materials, whether innocuous or not, should be handled according to the principles of good industrial hygiene.

Activator must be handled in compliance with relevant local regulations.

The initiator can affect certain plastics or coatings.

It is recommended to check all surfaces for compatibility before use.

Storage

Store product in the unopened container in a dry location. Storage information may be indicated on the product container labeling.

Optimal Storage: below 8 to 21 °C. Storage 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 Henkel representative.

Product Specification

The technical data contained herein are intended as reference only and are not considered specifications for the product. Product specifications are located on the Certificate of Analysis or please contact Henkel representative.

Approval and Certificate

Please contact Henkel representative for related approval or certificate of this product.

Data Ranges

The data contained herein may be reported as a typical value. Values are based on actual test data and are verified on a periodic basis.

Temperature/Humidity Ranges: 23 °C / 50% RH = 23±2 °C / 50 ±5% RH.

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:

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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