

LOCTITE® SF 7240™

January 2015

Product description

LOCTITE® SF 7240™ provides the following product characteristics:

Technology	Activator for LOCTITE® anaerobic adhesives and sealants
Chemical type	Basic copper salt
Solvent	Reactive methacrylate monomer
Appearance	Blue-green liquid
Components	One component - requires no mixing
Viscosity	Low
Cure	Not applicable
Application	Cure promotion of LOCTITE® anaerobic products

LOCTITE® SF 7240™ is designed to promote the curing speed of LOCTITE® anaerobic adhesives and sealants, without significant loss of joint strength. It is especially recommended for applications with passive metals or inert surfaces and with large bond gaps. This product should also be used when cure temperature is low and is particularly recommended for cure conditions below 15°C.

Typical properties

Specific gravity @ 25°C	1.05 to 1.1
Viscosity @ 25°C, mPa·s (cP)	10 to 20
Flash point - see SDS	

Typical performance

Fixture time and cure speed achieved as a result of using LOCTITE® SF 7240™ depend on the adhesive used, the substrate bonded, surface cleanliness and whether one or two surface activation is used.

Typical performance of cured material

Adhesive properties

After 5 minutes @ 22°C

Compressive shear strength, ISO 10123:

Steel pins and collars and LOCTITE® 638™, single side activation	N/mm ² (psi)	4 to 17 (580 to 2,465)
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After 24 hours @ 22 °C

Compressive shear strength, ISO 10123:

Steel pins and collars and LOCTITE® 638™, single side activation	N/mm ² (psi)	17 to 37 (2,465 to 5,365)
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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).

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

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. 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. The activator will not dry and will remain active for up to 6 hours. 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.

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 the specifications of this product.

Storage

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

Optimal storage: 8 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 Henkel representative.

Conversions

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

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