Technical Data Sheet

LOCTITE® SF 7025

Known as LOCTITE® 7025
June 2014

PRODUCT DESCRIPTION

LOCTITE® SF 7025 provides the following product characteristics:

Technology	Cyanoacrylate Activator
Chemical Type	Sulfenamide (active ingredient)
Solvent	n-Heptane
Active Ingredient Concentration, %	0.02 to 0.04[LMS]
Appearance (uncured)	Transparent, colorless liquid[LMS]
Viscosity	Very low
Cure	Not applicable
Application	CA adhesive cure accelerator

LOCTITE® SF 7025 is used where increased cure speed of LOCTITE® cyanoacrylate adhesives is required. It is especially recommended for irregular surfaces such as wood or stone where localized large gaps may exist. These gaps will contain larger volumes of adhesive which will cure slowly in the absence of activator. LOCTITE® SF 7025 is also recommended for porous substrates.

TYPICAL PROPERTIES

Specific Gravity @ 25 °C	0.68
Viscosity @ 20 °C, mPa·s (cP)	0.4
Drying Time @ 20 °C, seconds	≤60
On Part Life, hours	24
Flash Point - See SDS	

TYPICAL PERFORMANCE

Fixture time and cure speed achieved as a result of using LOCTITE® SF 7025 depend on the adhesive used and the substrate bonded.

Fixture Time, ISO 4587, seconds:

Steel (degreased) using LOCTITE® 416™, , single side activation	≤45[LMS]

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

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

Surface Activation

1. Apply one coating of activator to one of the surfaces to be bonded, (the most porous substrate), by light spray, brush or dipping. Ensure total coverage of the bond area. Contaminated surfaces may need special cleaning or degreasing prior to activation to remove any dissolvable contamination.
2. Allow LOCTITE® SF 7025 to fully evaporate from parts prior to bonding to avoid solvent entrapment within the bond joint.
3. Apply the Loctite cyanoacrylate product to the non-activated surfaces.
4. Assemble parts immediately, assuring correct positioning of the parts.
5. Maintain light contact pressure to prevent movement until the bond has fixtured, (typically 10 seconds).

Loctite Material Specification[LMS]

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

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 sensitve 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

(°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 1.1

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