Technical Data Sheet

LOCTITE® SF 7090™

Known as LOCTITE® 7090™
January 2015

PRODUCT DESCRIPTION

LOCTITE® SF 7090™ provides the following product characteristics:

Technology	Activator for LOCTITE® anaerobic adhesives and sealants
Chemical Type	Copper salt and Aliphatic amine
Solvent	Reactive methacrylate monomer
Appearance	Dark blue-green liquid[LMS]
Viscosity	Low
Cure	Copolymerization
Application	Cure acceleration of LOCTITE® anaerobic products

LOCTITE® SF 7090™ is a reactive monomer based "solvent free" surface activator designed to promote the cure speed of LOCTITE® anaerobic products. It is especially recommended for applications with passive metals or inert surfaces and with large bond gaps. LOCTITE® SF 7090™ is particularly recommended when prevailing temperature is low (<15 °C).

TYPICAL PROPERTIES

Specific Gravity @ 25 °C	1.03
Viscosity, Brookfield - RVT, 25 °C, mPa·s (cP):	
Spindle 1, speed 20 rpm	10 to 25[LMS]
Flash Point - See SDS	
On Part Life, hours	≤1

TYPICAL PERFORMANCE

Fixture time and cure speed achieved as a result of using LOCTITE® SF 7090™ depend on the adhesive used and the substrate bonded.

Fixture Time, ISO 4587, seconds:	
Steel (grit blasted) using LOCTITE® 326™, two side activation	≤25[LMS]

(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 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.

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. Spray or brush on the activator on both mating surfaces to be bonded. For small gaps, treatment of only one surface may be adequate. Contaminated surfaces may need repeated treatment or special degreasing prior to activation to remove any dissolvable contamination. Porous surfaces may need two treatments of activator.
2. The activator will not dry and will remain active for up to 1 hour after application.
3. Apply the Loctite anaerobic product to one or both surfaces and assemble parts immediately.
4. Where possible, move surfaces in relation to each other for a few seconds on assembly to properly distribute the adhesive and for maximum activation..
5. Secure the assembly and await fixturing before any further handling..

Loctite Material Specification[LMS]

LMS dated May 11, 1998. 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

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

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 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 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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