Technical Data Sheet

LOCTITE® SF 7239

Known as
Loctite® 7239 Primer
October 2015

PRODUCT DESCRIPTION

LOCTITE® SF 7239 Plastic Primer is a single component material, which dries rapidly at room temperature. It is suitable for use on all plastics and makes polyolefin, and other low energy surfaces, suitable for bonding with LOCTITE cyanoacrylate adhesives. On such treated surfaces the cured performance of LOCTITE cyanoacrylate adhesives is similar to that described in the TDS for the particular adhesive.

TYPICAL APPLICATIONS

LOCTITE® SF 7239 may be used on all plastic surfaces. Polypropylene, polyethylene, PTFE and thermoplastic rubber materials are normally difficult to bond. However, when treated with LOCTITE® SF 7239 Plastic Primer good adhesion is achieved with LOCTITE cyanoacrylate adhesives.

LIQUID PROPERTIES	Typical Value
Chemical type	Organic amine derivative
Solvent	Heptane*
Appearance	Colourless
Specific Gravity @ 25°C	0.68
Viscosity @ 20°C, mPa.s	1.25
Flash point (COC), °C	-1
Drying time @ 20°C, seconds	30
On part life, minutes	10

* Heptane is an environmentally friendly solvent. Heptane has zero Ozone Depletion Potential. Conforms to German WGK, category 1.

TYPICAL PERFORMANCE.

Fixture time and cure speed achieved as a result of using LOCTITE® SF 7239 depend on the adhesive used and the substrate bonded. Surfaces should be re-primed if still un-bonded after ten minutes.

Effect on Cure Speed of CA's.

This Primer behaves as an activator and accelerates the cure speed of cyanoacrylate adhesives. Fixture time on most primed substrates is less than ten seconds but 24 hours at room temperature (22° C) should be allowed for the adhesive to develop maximum bond strength.

Effect on Cured Properties of CA's.

Shear strength ranges, ASTM D1002, DIN 53283, N/mm^2: Bonds made with 401, both substrates primed with SF 7239.

Substrates	Range
Polypropylene - Polypropylene	3 to 5
Polyethylene - Polyethylene	2.5 to 4
Polytetrafluorethylene (Teflon** & Fluon†)	1 to 5
Polyacetal - Polyacetal	2.5 to 3.5
Thermoplastic rubber (Santoprene*)	6 (substrate failure)
Mild Steel - Mild Steel	7 to 9
Polycarbonate - Polycarbonate	8 to 11
PMMA - PMMA	6 to 9
ABS - ABS	8 to 10
Phenolic - Phenolic	4 to 6
Polypropylene - PMMA	4 to 7
Polypropylene - Aluminium	1.5 to 3
Aluminium - Aluminium	3 to 5

* *Monsanto trademark*
** *Dupont trademark*
† *ICI trademark*

Peel Strength

LOCTITE® SF 7239 Primer is not recommended in assemblies where high peel strength is required.

HANDLING PRECAUTIONS

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

The carrying solvent can affect certain plastics or coatings. It is recommended to check all surfaces for compatibility before use.

GENERAL INFORMATION

For safe handling information on this product, consult the Material Safety Data Sheets, (MSDS).

Directions for use

1. Primer should be applied by spraying, brushing or dipping both surfaces at ambient temperature. Excess Primer should be avoided. Allow the Primer to dry completely. The coating retains maximum activity for 10 minutes after drying.
2. Apply LOCTITE instant adhesive to one of the substrates to be bonded.
3. Bring the parts together, as soon as possible after the adhesive is applied, and hold firmly by hand for about 30 seconds until fixtured. Handling strength is achieved within a few minutes.

4. Allow up to 24 hours for full bond strength to develop.
5. Use in well ventilated areas. Avoid use of naked flames or other sources of ignition.

Storage

Product shall be ideally stored in a cool, dry location in unopened containers at a temperature between 8°C to 28°C (46°F to 82°F) unless otherwise labeled. Optimal storage is at the lower half of this temperature range. To prevent contamination of unused product, do not return any material to its original container. For further specific shelf life information, contact your local Technical Service Center.

Data Ranges

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

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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