Technical Data Sheet

LOCTITE® SF 7388™

Known as LOCTITE® 7388™
January 2015

PRODUCT DESCRIPTION

LOCTITE® SF 7388™ provides the following product characteristics:

Technology	Activator for LOCTITE® toughened acrylic adhesives
Solvent	Heptane / Isopropanol
Appearance	Clear, yellow to amber liquid with a greenish tinge
Components	One component - requires no mixing
Viscosity	Very low
Cure	Not applicable
Application	Cure promotion of toughened acrylic adhesives

LOCTITE® SF 7388™ is designed to initiate the cure of Loctite toughened acrylic adhesives.

TYPICAL PROPERTIES

Viscosity @ 25°C, mPa·s (cP)	1.5
On Part Life, minutes	15
Flash Point - See SDS	

TYPICAL PERFORMANCE

Fixture time and cure speed achieved as a result of using LOCTITE® SF 7388™ depend on the adhesive used, the substrate bonded, surface cleanliness and whether one or two surface activation is used.

Fixture Time, ISO 4587, seconds:

PVC using LOCTITE® 330™, , single side activation	65 to 105

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

TYPICAL PERFORMANCE OF CURED MATERIAL

Cured for 24 hours @ 22 °C, single side activation, using LOCTITE® 330™

Lap Shear Strength, ISO 4587:

Steel (grit blasted):

0 gap	N/mm²	17
	(psi)	(2,465)
0.5 mm gap	N/mm²	7
	(psi)	(1,015)

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.

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.

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 specifications for this product.

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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