Technical Data Sheet

LOCTITE® SF 7455

October 2022

PRODUCT DESCRIPTION

LOCTITE® SF 7455 provides the following product characteristics:

Technology	Activator for Cyanoacrylate
Chemical Type	Sulfenamide (active ingredient)
Solvent	Heptane
Appearance	Transparent to slightly hazy liquid
Viscosity	Very low
Cure	Not applicable
Application	CA adhesive cure accelerator

LOCTITE® SF 7455 is an activator used where increased cure speed of cyanoacrylate adhesives is required. It can be either pre- or post-applied to the bond. The product is especially suited for post-application on cyanoacrylate adhesive to ensure rapid fixturing. Typical applications include securing wires or coils to PCBs, tamper-proofing adjustable components, mounting stand-offs, edge guides and board stiffeners.

TYPICAL PROPERTIES

Specific Gravity @ 23°C	0.68
Viscosity @ 25 °C, mPa·s (cP)	0.4
Drying Time @ 23°C, seconds	60
On Part Life, minutes	5

TYPICAL PERFORMANCE OF CURED MATERIAL

Effect on Cure Speed of Cyanoacrylate Adhesives

Fixture time and cure speed achieved as a result of using LOCTITE® SF 7455 depend on the adhesive used and the substrate bonded. The fixture time is defined as the time to develop a shear strength of 0.1 N/mm² .

Fixture Time, ISO 4587, seconds: Steel (grit blasted) using LOCTITE® 416™, two side activation	10

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

Post Activation

1. Apply LOCTITE® cyanoacrylate to the parts to be bonded or fixed.
2. Apply activator over all exposed cyanoacrylate adhesive by spray or drop. (Typically use one drop of activator per drop of exposed adhesive).

Surface Activation

1. Apply one coating of activator to the area to be bonded by spray, brush or dipping. Contaminated surfaces may need special cleaning or degreasing prior to activation to remove any soluble contamination.
2. Allow LOCTITE® SF 7455 to fully evaporate from parts prior to bonding to avoid solvent entrapment within the bond joint.
3. Apply the LOCTITE® cyanoacrylate product immediately after drying.
4. Activator can be re-applied if necessary if there is a delay between original activator and adhesive application.

Handling Precautions

Primer 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.

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 Henkel representative.

Product Specification
The technical data contained herein are intended as reference only and are not considered specifications for the product. Product specifications are located on the Certificate of Analysis or please contact Henkel representative.

Approval and Certificate
Please contact your local Henkel representative for related approval or certificate of this product.

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

Temperature/Humidity Ranges: 23°C/50% RH = 23±2°C/50± 5% RH.

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

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