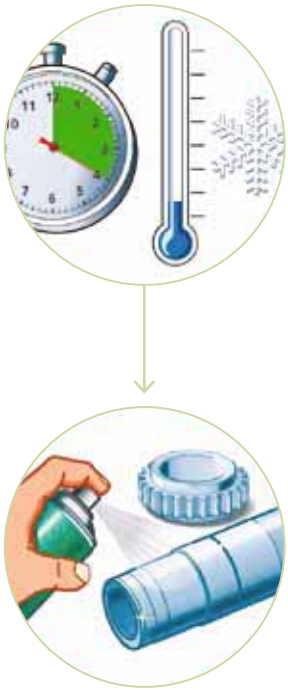


Why Use a LOCTITE activator or primer?

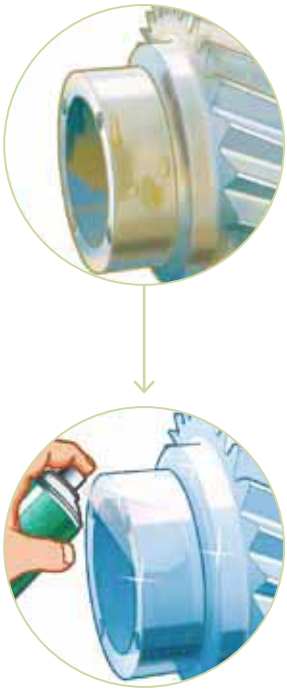
Henkel offers a complete range of activators and primers providing solutions for the following LOCTITE adhesive technologies:

1. LOCTITE activators / primers for instant bonding (cyanoacrylates)
LOCTITE primers are used for improving adhesion to substrates. They are applied before the adhesive. For low surface energy plastic substrates, e.g. polyolefin, PP, PE, best adhesion will be achieved with LOCTITE 770 / 7701.

LOCTITE activators are used to increase cure speed. Loctite activators are mostly applied before the adhesive. Heptane-based activators have good “on-part life” and provide for a good aesthetic appearance of the bondline. They are also suitable for use on plastics which are sensitive to stress cracking. Activators can also be applied after the adhesive, e.g. for curing residual adhesive. They provide for an excellent cosmetic appearance by avoiding white staining of instant adhesives.

2. LOCTITE activators for modified acrylics
LOCTITE activators for modified acrylics are needed to initiate the curing process. Usually, the activator is applied to one surface and the modified acrylic to the other surface. The curing process starts when the two parts are assembled. Fixture time is dependent on the adhesive, on the substrate and on the cleanliness of the surfaces.

3. LOCTITE activators for threadlocking, pipe and thread Sealing, gasketing, retaining and anaerobic acrylics
LOCTITE activators for this group of adhesives are used to increase the cure speed of the products. They are recommended for applications on passive metals such as stainless steel, plated or passivated surfaces. Activators are available as solvent-based or solvent-free formulations.



Why use a LOCTITE surface preparation product?

The LOCTITE portfolio of surface preparation products offers solutions for all types of surface treatments or preparations. All products are easy to use and thus ideal for maintenance and line production.

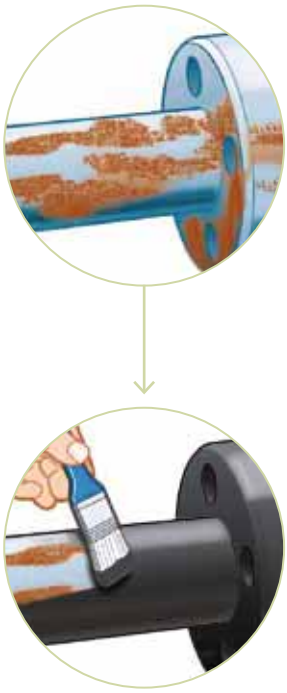
1. Protection of Welding Equipment
Protect shroud and contact tip from welding spatter and ensure uninterrupted welding for a complete shift.

2. Belt Dressing
Prevent slippage and increase friction for all types of belts.

3. Rust Treatment
Conversion of rust into a stable base – treated surface can be overpainted.

4. Corrosion Protection
Protect surfaces against corrosion – drying and non-drying product available.

5. Tamper Proofing
Visually detect movements in adjusted parts.



Why use a LOCTITE emergency repair product?

Whatever your working environment, unpredictable and emergency situations can happen and in most of the cases need to be sorted out within a very short timeframe. Our range of emergency repair products helps you to avoid unnecessary downtime and costs. All of them are easy to apply, enabling you to deal with emergencies quickly. More than this, some will also help you to increase the reliability of your industrial equipment.

1. O-Ring Replacement
O-rings can be made as and when required, avoiding the need to stock.

2. Freeing of Corroded Parts
Releasing rusted, corroded and seized components using the shock freeze effect.

3. Detection of Pipe Leaks
Easy-to-apply system for location of small leaks in iron, copper and plastic pipes.

4. Sealing of Leaks
For emergency sealing of tanks, pipes and castings without the need to replace components.

5. Taping
For immediate fixing and protection of various materials.

Surface Preparation
Product Table

What is your application?

Instant bonding

What do you want to do?

Improve adhesion

Accelerate

General purpose

Solution	LOCTITE SF 7239	LOCTITE SF 770/7701*	LOCTITE SF 7458	LOCTITE SF 7455
Description	Primer	Primer	Activator	Activator
Colour	Colourless	Colourless	Colourless	Colourless
Solvent	Heptane	Heptane	Heptane	Heptane
Application method	Pre-applied	Pre-applied	Pre or post applied	Post applied
Pack sizes	Not available in the U.K.	SF 770: 10g, 300g SF 7701: 454 g	500ml	25ml, 150ml, 500ml
	LOCTITE SF 7239 • Plastic Primer • General purpose • Suitable for use on all industrial plastics • Improves the adhesion of instant adhesives on polyolefins and other low surface energy plastics	**LOCTITE SF 770** **LOCTITE SF 7701*** • Polyolefin primer • Only for difficult to bond plastics • Provides (best) adhesion of instant adhesives to polyolefins and other low surface energy plastics	**LOCTITE SF 7458** • General purpose • For all substrates • Good onpart life can be pre or post applied • Low odour • Minimises post cure white discolouring • Provides good aesthetic appearance of the bondline	**LOCTITE SF 7455** • General purpose • For all substrates • Fast fixturing between close fitting parts • For post application

 *For medical applications

Modified acrylics (329, 3298, 330, 3342)

Threadlocking, pipe and thread sealing, gasketing, retaining and anaerobic acrylics

What activator is preferred?

Best cosmetic appearance	**Ideal for plastics prone to stress cracking**	**Solvent-based**	**Solvent-based**	**Solvent-free**
LOCTITE SF 7452	**LOCTITE SF 7457**	**LOCTITE SF 7386**	**LOCTITE SF 7471/7649**	**LOCTITE SF 7240**
Activator	Activator	Activator	Activator	Activator
Transparent, light amber	Colourless	Transparent	Transparent, green	Blue-green
Acetone	Heptane	Heptane	Acetone	Solvent-free
Post-applied	Pre or post applied	Pre-applied	Pre-applied	Pre-applied
500ml	150ml, 500ml	500ml	150ml, 500ml, 15.8kg	90ml
LOCTITE SF 7452 • Cures excess adhesive • Provides excellent cosmetic appearance avoiding white discolouring of instant adhesive • Not recommended on plastics prone to stress cracking	**LOCTITE SF 7457** • Good on part life – can be pre or post applied • Recommended for use on plastics prone to stress cracking	**LOCTITE SF 7386** • Initiate the cure of modified acrylic adhesives • Fixture time and cure speed depend on adhesive, bonded substrate and surface cleanliness	**LOCTITE SF 7471** **LOCTITE SF 7649** • Speed up cure on passive and inactive surfaces • For large bond gaps • On-part life of: LOCTITE 7649: ≤ 30 days, LOCTITE 7471: ≤ 7 days	**LOCTITE SF 7240** • Increase cure speed on passive and inactive surfaces • For large bond gaps • For low (< 5°C) temperature curing