LOCTITE® 7649

April 2008

PRODUCT DESCRIPTION

LOCTITE® 7649 provides the following product characteristics:

Technology	Activator for LOCTITE® anaerobic adhesives and sealants
Chemical Type	Copper salt and Aliphatic amine
Solvent	Acetone
Appearance	Transparent, green liquid[LMS]
Viscosity	Very low
Cure	Not applicable
Application	Cure acceleration of LOCTITE® anaerobic products

LOCTITE® 7649 is used where increased cure speed of LOCTITE® anaerobic products is required. It is especially recommended for applications with passive metals or inert surfaces and with large bond gaps. LOCTITE® 7649 is particularly recommended when prevailing temperature is low (<15 °C).

TYPICAL PROPERTIES

Specific Gravity @ 25 °C	0.79
Viscosity @ 20 °C, mPa·s (cP)	2
Flash Point - See MSDS	
Drying Time @ 20 °C, seconds	30 to 70
On Part Life, days	≤30

TYPICAL PERFORMANCE

Fixture time and cure speed achieved as a result of using LOCTITE® 7649 depend on the adhesive used and the substrate bonded.

Fixture Time, ISO 4587, seconds:	
Steel (degreased) using LOCTITE® 326™, , single side activation	≤30

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

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.

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 Material Safety Data Sheet (MSDS).

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. Allow the solvent time to evaporate under good ventilation until the surfaces are completely dry.
3. After activation, parts should be bonded within 1 month. Contamination of the surface before bonding should be prevented.
4. Apply the Loctite Anaerobic product to one or both surfaces and assemble parts immediately.
5. Where possible, move surfaces in relation to each other for a few seconds on assembly to properly distribute the adhesive and for maximum activation..
6. Secure the assembly and await fixturing before any further handling..

Loctite Material Specification[LMS]

LMS dated September 01, 2005. 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

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. 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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Reference 1.1