LOCTITE®

7387™

October 2010

PRODUCT DESCRIPTION

7387™ provides the following product characteristics:

Technology	Activator for LOCTITE® toughened acrylic adhesives
Chemical Type	Substituted dihydropyridine
Solvent	n-Heptane and Isopropanol
Appearance	Transparent yellow to amber liquid[LMS]
Viscosity	Very low
Cure	Not applicable
Application	Cure promotion of toughened acrylic adhesives

7387™ is designed to initiate the cure of Loctite toughened acrylic adhesives.

TYPICAL PROPERTIES

Specific Gravity @ 25 °C	0.8
Viscosity @ 25°C, mPa·s (cP)	1 to 2
Flash Point - See MSDS	
Infrared Spectroscopy	To match standard[LMS]

TYPICAL PERFORMANCE

Fixture time and cure speed achieved as a result of using 7387™ depend on the adhesive used, the substrate bonded, surface cleanliness and whether one or two surface activation is used.

Fixture Time, ISO 4587, minutes:

Steel (grit blasted) using LOCTITE® 330™, , single side activation	≤4[LMS]

(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. 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. Allow the solvent time to evaporate under good ventilation until the surfaces are completely dry.
5. The activator will remain active for up to 6 hours. Bond assembly should be completed within this time.
6. Where adhesive is applied onto an activated surface, assembly should be completed as quickly as possible (within 15 seconds).
7. Secure the assembly and await fixturing before any further handling..

Loctite Material Specification[LMS]

LMS dated September 01, 1995. 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. 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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Reference 1.3