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Technical Data Sheet Product 737

Worldwide Version, July 1994

PRODUCT DESCRIPTION

LOCTITE® ACTIVATOR 737 is a single component surface activator. The activator is designed to promote the cure of Loctite toughened acrylic adhesives, Multibond 329 and 330.

TYPICAL APPLICATIONS

ACTIVATOR 737 is a medium speed grade used to initiate the cure of Loctite toughened acrylic adhesives. It is especially recommended for curing of Multibond 329 and 330 adhesives where maximum environmental resistance is required or where bond gaps exceed 0.25mm.

LIQUID PROPERTIES

Chemical Base	Organic Accelerator
Solvent	None
Colour	Dark Amber
Specific Gravity, 25°C	0.98
Viscosity, 20°C, mPa.s	50 to 100
Flash point (COC), °C	>100
Shelf life @ 20°C, months	12
Toxicity	Low
On part life, hrs	6

PERFORMANCE

Fixture time and cure speed achieved as a result of using Activator 737 depend on the adhesives used, the substrate bonded, surface cleanliness and whether one or two surface activation is used. Details of cure speed on different materials and through different gaps are included in the TDS for Multibond.

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 onto one of the mating surfaces to be bonded. Apply adhesive to other surface.
3. For large gaps (>0.4mm) 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 six hours. The joint should be completed within this time.
5. Where adhesive is applied onto an activated surface, assembly should be completed as quickly as possible, (within 60 seconds).
6. Secure the assembly and await fixturing before any further handling.
7. Replace cap on activator container to maintain optimum performance.

HANDLING PRECAUTIONS

Under no circumstance should the activator and adhesive be mixed directly as liquids.

Avoid prolonged or repeated skin contact.

Use only in a well ventilated area.

GENERAL INFORMATION

Storage

Store material in original containers in a cool, dry place for maximum shelf life. When stored, unopened, under these conditions, the material will retain its performance and properties for twelve months.

SPECIFICATIONS

The technical data contained herein are intended for reference and should not be used for preparing specifications. Please contact the Loctite Technical Service Department or local representative for assistance and recommendations on specification limits for these materials.

Note

The data contained herein are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof. In light of the foregoing, Loctite Corporation specifically disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Loctite Corporation's products. Loctite Corporation specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits. The discussion herein of various processes or compositions is not to be interpreted as representation that they are free from domination of patents owned by others or as a licence under any Loctite Corporation patents that may cover such processes or compositions. We recommend that each prospective user test his proposed application before repetitive use, using this data as a guide. This product may be covered by one or more United States or foreign patents or patent applications.