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# Technical Data Sheet Product 7649

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## PRODUCT DESCRIPTION

LOCTITE® ACTIVATOR 7649 is a single component non-CFC solvent based surface activator. The activator is designed to promote the speed of cure of Loctite anaerobic adhesives and sealants. The activator is HIGHLY FLAMMABLE.

## TYPICAL APPLICATIONS

ACTIVATOR 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. ACTIVATOR 7649 can also be used when cure temperatures are below room temperature. Use of activator is particularly recommended for cure conditions below 15°C.

## LIQUID PROPERTIES

	Typical Value
Chemical type	Basic Copper Salt
Solvent	Acetone*
Appearance	Clear Green liquid
Specific Gravity @ 25°C	0.79
Viscosity, 20°C, mPa.s (cP)	2
Flash point (TCC), °C	-18 (HIGHLY FLAMMABLE)
TLV, (ACGIH), ppm	750
Drying time @ 20°C, seconds	30 to 70
On part life, days	30

\* Acetone is an environmentally friendly solvent.  
Acetone has zero Ozone Depletion Potential.  
Conforms to German WGK, category 0.

## Caution

UNDER NO CIRCUMSTANCES SHOULD ACTIVATOR AND ADHESIVE BE MIXED DIRECTLY AS LIQUIDS.

## TYPICAL PERFORMANCE

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

## GENERAL INFORMATION

For safe handling information on this product, consult the Material Safety Data Sheets, (MSDS).

## HANDLING INFORMATION

### Handling Precautions

Activator must be handled in a manner applicable to highly flammable materials and in compliance with relevant local regulations. For example, special care must be taken to avoid contact of the activator or its vapour with naked flame or any electrical equipment that is not flame proofed.

The carrying solvent can affect certain plastics or coatings. It is recommended to check all surfaces for compatibility before use.

Avoid prolonged or repeated skin contact.

Use only in a well ventilated area.

No smoking in presence of activator.

## 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 one 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.

## Storage

This activator is classified as being HIGHLY FLAMMABLE and therefore must be stored in an appropriate manner and in compliance with relevant regulations. Do not store near oxidising agents or combustible materials.

Product shall be ideally stored in a cool, dry location in unopened containers at a temperature between 8°C to 28°C (46°F to 82°F) unless otherwise labelled. Optimal storage is at the lower half of this temperature range. To prevent contamination of unused product, do not return any material to its original container. For further specific shelf life information, contact your local Technical Service Centre.

## Note

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