



Henkel Corporation offers a complete line of Loctite® brand surface preparation products to ensure the maximum performance of Loctite® brand adhesives and sealants.

Loctite® brand accelerators are used to increase the cure speed and gap-filling capabilities of cyanoacrylate adhesives. Activators are specially-engineered curing agents for structural adhesives. Loctite® brand primers are used to ensure cure on inactive surfaces and speed the cure of machinery adhesives.

All Loctite® brand surface preparation products are available in ozone-safe (non-CFC), solvent-based and solventless formulations.

SURFACE PREPARATION

ACCELERATORS

Loctite® 7452™ Tak Pak® Accelerator

This accelerator, with aggressive cleaning properties, promotes the cure speed of all Loctite® brand cyanoacrylate adhesives.

Loctite® 7113™ Accelerator

This accelerator features long on-part life. Use with Loctite® brand cyanoacrylate adhesives.

ACTIVATORS

Loctite® 7075™ Activator

An acetone-based activator that promotes the proper cure of Loctite® 324™ and 325™ Speedbonder™ Structural Adhesives.

Loctite® 7380™ Activator

This solvent-free activator allows immediate mating of parts. Use with most Loctite® brand acrylic adhesives.

Loctite® 7387™ Depend® Activator

This activator promotes the cure of most Loctite® brand acrylic adhesives. This is a flammable product.

PRIMERS

Loctite® 7471™ Primer T™

A solvent-based primer that speeds the cure of all Loctite® brand anaerobic adhesives and ensures proper cure on inactive metals.

Loctite® 7649™ Primer N™

A solvent-based primer that features very long on-part life. Use to speed the cure of all Loctite® brand anaerobic products and ensure proper cure on inactive metals. Ideal for cure conditions below room temperature.

Loctite® 770™ Prism® Primer






An adhesion promoter formulated for use with polyolefins and other low energy surfaces. Use with Loctite® brand cyanoacrylate adhesives. Fast dry time and long on-part life.

Q. When should I use a primer?



A. Use a primer when **both** surfaces are considered inactive. It is necessary to apply the primer to one surface, in most cases, unless gaps are excessive. See chart.

ACTIVE METALS		INACTIVE METALS	
Iron	Bronze	Plated Parts	Cadmium
Plain Steel	Nickel	Anodized Aluminum	Magnesium
Copper	Manganese	(Alodine, Iridite)	Natural or Chemical Black Oxide
Brass	Monel	Titanium	Magnetite Steel
Commercial Aluminum (with copper content, e.g. 6061)	Kovar	Stainless Steel	Iconel
		Galvanized Steel	Silver
		Zinc	Gold
		Pure Aluminum	Plastics

**LOCTITE® BRAND
ACCELERATORS/PRIMERS
PROPERTIES CHART**

PRODUCT	Item Number	Container	Color	Viscosity cP	Base	On-Part Life	Dry Time	Application	Agency Approvals
712™ Tak Pak® 	20352 18636 18390	1.75 fl. oz. bottle 0.7 fl. oz. metered mist 1 gal. can	Clear/amber	1	Isopropanol	1 min.	<30 sec.	All cyanoacrylates	MIL-46050C for existing designs, CFIA
770™ Prism®	18396 18397	1.75 fl. oz. bottle 16 fl. oz. can	Colorless	1.25	Heptane	8 hrs.	30 sec.	All cyanoacrylates	CFIA
793™ Prism®	18650 20246	1.75 fl. oz. bottle 16 fl. oz. bottle	Clear/ light amber	3	Propylene based glycol ether/water	<2 hrs.	<10 min.	All cyanoacrylates	-
7090™	19368 12695	1 fl. oz. bottle 1 liter bottle	Light amber	3	No solvent	1 hr.	<10 min.	Anaerobics	-
7109™ Tak Pak II®	22440 23034	1.75 fl. oz. bottle 1 qt. bottle	Clear/amber	3	Perfluorocarbon	1 min.	<5 sec.	All cyanoacrylates	-
7113™ 	19605 19606	1.75 fl. oz. bottle 1 gal. can	Clear	0.4	Heptane	24 hrs.	1 min.	All cyanoacrylates	-
7452™ Tak Pak® 	18490 18580 18637 18575 18576	1.75 fl. oz. brush-cap bottle 1.75 fl. oz. spray-cap bottle 0.7 fl. oz. metered mist 1 qt. can 1 gal. can	Clear/amber	0.4	Acetone	1 min.	<30 sec.	All cyanoacrylates	MIL-46050C for existing designs,
7453™ Tak Pak®	20282	1.75 fl. oz. bottle	Clear/amber	0.4	Acetone (electronic grade)	1 min.	<30 sec.	All cyanoacrylates	-
7471™ Primer T™ 	19267 22477 19268	1.75 fl. oz. bottle 4.5 oz. aerosol can 1 gallon can	Amber	2	Acetone/ Isopropanol	7 days	30-70 sec.	Anaerobics	MIL-S-22473E
7649™ Primer N™ 	19269 38402 21347 21348 19266	1.75 fl. oz. glass bottle 1.75 fl. oz. aluminum bottle 25 gm aerosol can 4.5 oz. aerosol can 1 gallon can	Clear/green	2	Acetone	30 days	30-70 sec.	Anaerobics	MIL-S-22473E, NSF/ANSI 61, NSF P1, CFIA

**LOCTITE® BRAND ACTIVATORS
PROPERTIES CHART**

PRODUCT	Item Number	Container	Color	Viscosity cP	Base	On-Part Life	Dry Time	Application
7075™	21349 22671	1 qt. can 4.5 oz. aerosol can	Amber	2	Acetone	2 hrs.	3 minutes	324, 325
7380™ 	19822 19824 19907	1 liter can 1.75 fl. oz. bottle 1 gallon can	Light brown	43	Monomer	2 hrs.	None	Structurals
7387™ Depend® 	18861 18862 21088	1.75 fl. oz. bottle 1 qt. can 4.5 oz. aerosol can	Light brown	1.5	Heptane/Isopropanol	2 hrs.	None	Structurals
25062	25062	1 liter bottle	Thin green/ fluorescent	1.03	Methacrylate	1 hr.	None	Anaerobics on dichromate surfaces

 Indicates worldwide availability.