

LOCTITE® SF 7400™

June 2014

PRODUCT DESCRIPTION

LOCTITE® SF 7400™ provides the following product characteristics:

Technology	Solvent based
Chemical type	Pigmented organic polymer
Appearance	Red liquid
Cure	Solvent evaporation
Application	Visible marker for use on electronics equipment

LOCTITE® SF 7400™ is a solvent based dark red marking ink for use on electronic equipment. The product dries quickly and has excellent adhesion to a range of materials. It is ideal for tamper-proofing adjustment points or marking components to indicate they have been set or tested.

Typical properties

Viscosity, brookfield, 20°C, mPa·s (cP): Spindle 4, speed 60 rpm	1,030
Solids content, %	22.5
Tack Free Time (100 µm), minutes	5
Dry time (100 µm), hours	5 to 7
Flash point - see SDS	

Typical performance

LOCTITE® SF 7400™ dries by the evaporation of solvent to leave a pigmented film of organic polymer. When fully dried, it has excellent visibility and shows good adhesion to a wide range of polymers and metals.

Even when fully dried, LOCTITE® SF 7400™ will re-dissolve in solvents but the rate is slow. Removal of the cured film by mechanical action followed by wiping off the residues with butyl acetate or MEK is the most effective method of removal.

GENERAL INFORMATION

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials.

For safe handling information on this product, consult the Material Safety Data Sheet.

Direction for use:

1. Some settling of the pigment will occur on storage. Thoroughly shake the container to re-disperse the pigment prior to use.
2. Allow the product to stand before use to eliminate air bubbles created by the pigment dispersion step.
3. Apply LOCTITE® SF 7400™ to the surface.
4. Thin films of LOCTITE® SF 7400™ (100 micron) will dry in approximately 5 minutes to a tack free surface at room temperature. Thicker films will dry on the surface in approximately 5 minutes but will require a longer time for thorough drying. LOCTITE® SF 7400™ will be completely dry in approximately 6 hours.
5. Product can be removed by wiping with solvents (eg. MEK or butyl acetate) while it is still liquid.
6. Consult your local Henkel® Technical Services Center for information on automatic application equipment which is suitable for use with LOCTITE® SF 7400™.

Not for product specifications

The technical data contained herein are intended as reference only. Please contact your local quality department for assistance and recommendations on the specifications of this product.

Storage

The product is classified as flammable and must be stored in an appropriate manner in compliance with relevant regulations. Do not store near oxidizing 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 Henkel representative.

Conversions
 $(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$
 $\text{kV/mm} \times 25.4 = \text{V/mil}$
 $\text{mm} / 25.4 = \text{inches}$
 $\mu\text{m} / 25.4 = \text{mil}$
 $\text{N} \times 0.225 = \text{lb}$
 $\text{N/mm} \times 5.71 = \text{lb/in}$
 $\text{N/mm}^2 \times 145 = \text{psi}$
 $\text{MPa} \times 145 = \text{psi}$
 $\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$
 $\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$
 $\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$
 $\text{mPa}\cdot\text{s} = \text{cP}$
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