



# CUSTOMER INFORMATION PACK

**Introduction of the upgraded  
LOCTITE® Accelerators  
for Instant Adhesives.**

March 2022



# INTRODUCTION

LOCTITE SF 7452™ Accelerator and LOCTITE SF 7455™ Accelerator are being reformulated by removing some of the raw materials used in the past and replacing them with more globally acceptable alternatives. The new formulations have been tested by Henkel, and the performance properties and shelf-lives of the products remain consistent with existing Henkel Quality Specifications. Side-by-side comparison data of the old vs. new formulations is referenced in the following pages.

Availability of the upgraded Accelerators is planned for early 2021. The new formulations will be implemented on a running basis and the product nomenclature will stay the same, i.e., SF 7452, SF 7455. However, the products will be assigned new finished good ordering numbers (IDH #s), since the changes impact a significant portion of

the formulations and new labelling will be required. The new ordering numbers (IDH #s) will be communicated to our distributors and direct customers at a later date, once they are established in our systems and our commercialization process has been completed. New Material Safety Data Sheets will also be made available at that time and Technical Data Sheets will be updated once all of the related testing is completed.

Due to our internal safety stocks, there will be a period of overlap where our distributors and customers may receive both new and old packages of product. The new formulations will be able to be identified by both the new finished good ordering numbers (IDH #s), as well as the Henkel batch code numbers that appear on each package.

# LOCTITE® SF 7452™ UPGRADE – TEST RESULTS

## 1. LOCTITE MATERIAL SPECIFICATION

LOCTITE Material Specification (LMS) for SF 7452.

	CURRENT SF 7452	NEW SF 7452
Active Ingredient %	0.8–0.95	0.19–0.21
Active Ingredient	Amine	Organic disulfide
Appearance	Transparent colorless to slightly amber liquid	Transparent colorless to slightly amber liquid
IR Spectrum	Corresponds to Standard	Corresponds to Standard
Solvent	Acetone	Acetone
Fixture Time, Steel (grit-blasted) LOCTITE 495™ (sec)	≤ 10	≤ 10

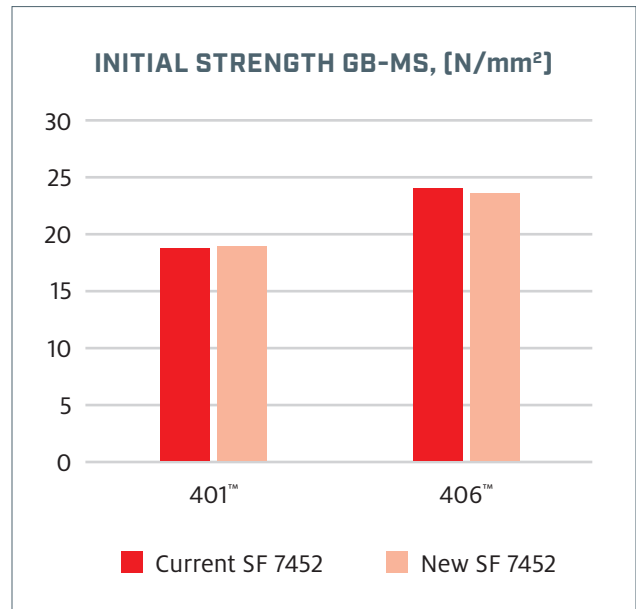
## 2. TEST RESULTS FOR LOCTITE SF 7452

### 2.1. Typical properties

	CURRENT SF 7452	NEW SF 7452
Viscosity @ 20°C, mPa.s (cP)	0.3–0.5	0.3–0.5
Flash Off Time (sec)	≤ 30	≤ 30
On Part Life (min)	< 1	10–20
Skin Over Time (sec)	≤ 10	≤ 10

### 2.2. Bond strengths

The initial bond strength on grit-blasted mild steel is unchanged.



The performance on plastic substrates and durability on GB-MS is unchanged.

	CURRENT SF 7452	NEW SF 7452
401 ABS	Substrate failure	Substrate failure
406 PC	Substrate failure	Substrate failure

	CURRENT SF 7452	NEW SF 7452
<b>401-GB-MS</b>	<b>% OF INITIAL STRENGTH</b>	
500 hours @ 120°C	40	45
500 hours @ 40°C/98% RH	70	70

## 3. CONCLUSION

LOCTITE SF 7452 has been upgraded without any compromise to the quality and performance with respect to the LMS.

# LOCTITE® SF 7455™ UPGRADE – TEST RESULTS

## 1. LOCTITE MATERIAL SPECIFICATION

LOCTITE Material Specification (LMS) for SF 7455.

	CURRENT SF 7455	NEW SF 7455
Active Ingredient %	0.7–1.0	0.15–0.25
Active Ingredient	Amine	Sulfenamide
Appearance	Transparent colorless to slightly amber liquid	Transparent colorless to slightly amber liquid
Solvent	Heptane	Heptane
Fixture Time, GB-MS LOCTITE 416™ (sec)	≤ 10	≤ 10

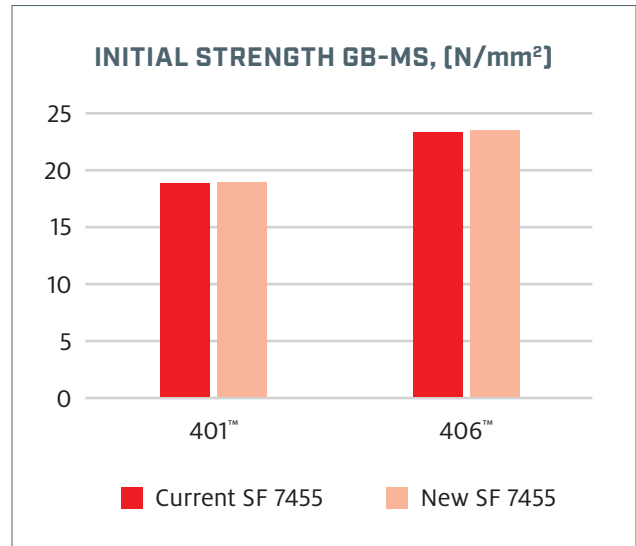
## 2. TEST RESULTS FOR LOCTITE SF 7455

### 2.1. Typical properties

	CURRENT SF 7455	NEW SF 7455
Viscosity @ 20°C, mPa.s (cP)	0.3–0.5	0.3–0.5
Flash Off Time (sec)	≤ 60	≤ 60
On Part Life (min)	< 1	5–10
Skin Over Time (sec)	≤ 10	≤ 10

### 2.2. Bond strengths

The initial bond strength on grit-blasted mild steel is unchanged.



The performance on plastic substrates and durability on GB-MS is unchanged.

	CURRENT SF 7455	NEW SF 7455
401 ABS	Substrate failure	Substrate failure
406 PC	Substrate failure	Substrate failure

	CURRENT SF 7455	NEW SF 7455
<b>401-GB-MS</b>	<b>% OF INITIAL STRENGTH</b>	
500 hours @ 120°C	45	45
500 hours @ 40°C/98% RH	70	70

## 3. CONCLUSION

LOCTITE SF 7455 has been upgraded without any compromise to the quality and performance with respect to the LMS.

**Note:**

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