Laboratory Data Sheet

LOCTITE® SF 772

October 2026 V2

PRODUCT DESCRIPTION

LOCTITE® SF 772 provides the following product characteristics:

Technology	Primer for Cyanoacrylate
Chemical Type	Aromatic Phosphine
Solvent	2-Dimethoxypropane
Appearance	Clear to colorless
Fluorescence	Positive under UV light*
Viscosity	Very Low
Cure	Not applicable
Application	CA surface primer

** Low intensity (< 5 mW/cm^2) and short exposure time (max. 6 seconds/ 30 mJ/cm^2) only. High intensity and long exposure time will reduce product performance.*

LOCTITE® SF 772 is a primer designed to improve the adhesion of LOCTITE® cyanoacrylate instant adhesives e.g. LOCTITE® 472 to low surface energy substrates.

LOCTITE® SF 772 is specifically formulated for use on difficult to bond polyolefin plastics such as polyethylene and polypropylene and also performs very well on other low surface energy materials such as PTFE, silicone and acetal to optimize bonding of these materials to each other or to other materials.

By modifying the surface characteristics of these substrates, the primer enables reliable bonding with LOCTITE cyanoacrylate adhesives.

To determine which substrates are suitable for priming with Loctite SF 772, please consult the *"Influence of LOCTITE® SF 772 Primer on Different Plastics"* table below and LOCTITE's Design Guide for Bonding Plastics.

TYPICAL PROPERTIES

Viscosity, Cone & Plate, 25°C, mPa·s (cP): Cone: CP50^{-1} Shear Rate: 3,000 s^{-1}	0.60-1.1
Drying Time @ 21°C and 53 % RH, seconds (Polypropylene)	<10
Maximum recommended time for assembly after application, hours	2

TYPICAL PERFORMANCE OF CURED MATERIAL

Adhesive Properties

Substrates treated with (or without) primer LOCTITE® SF 772 and subsequently bonded with LOCTITE® 472, where indicated.

24 hours @ 23 °C / 50% RH:

Lap Shear Strength, ISO 4587

LOCTITE® 472

Substrate	Units	Unprimed	Primed with SF 772
Polypropylene	N/mm^2 (psi)	0.8-1.4 (120-205)	10.5-10.9* (1520-1580)
Polyethylene	N/mm^2 (psi)	0.5-0.7 (70-100)	3.3-7.6 (475-1100)
Polytetrafluoroethylene (PTFE)	N/mm^2 (psi)	0.2-0.6 (29-87)	1.2-1.4 (174-203)
Acetal	N/mm^2 (psi)	0 (0)	4.1-4.9 (594-711)

**Substrate Failure; The bond strength is stronger than the substrate material.*

This document reflects laboratory test data generated on an experimental product; final TDS values may vary slightly but will remain within a comparable performance range.

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ADHESIVE PROPERTIES

Influence of LOCTITE® Primers on Different Plastics

This table highlights how the use of LOCTITE® primers can influence typical bond strength across different plastic substrates, when subsequently bonded with a LOCTITE® instant adhesive.

Substrate	Instant Adhesive Strength Observations with LOCTITE® primers
Polyolefins (PE & PP)	Significant increase in bond strength
Silicone	Significant increase in bond strength
Fluoropolymers (e.g PTFE)	Significant increase in bond strength
ABS	Significant decrease in bond strength
Acetal (POM)	Significant increase in bond strength
Polyamide (Nylon)	Significant decrease in bond strength
Polyvinyl chloride (PVC)	Significant decrease in bond strength
EPDM Rubber	No increase or decrease in bond strength
Phenolic	Decrease in bond strength
Polycarbonate (PC)	Significant decrease in bond strength

TYPICAL ENVIRONMENTAL RESISTANCE

Polypropylene Substrates treated with primer LOCTITE® SF 772 and bonded with adhesive LOCTITE® 406™.

Cured for 72 hours @ 23 °C / 50% RH
Block Shear Strength, ISO 13455

Heat Aging

Aged at temperature indicated and tested @ 23°C

		% of Initial Strength		
Environment	°C	100h	500	1000
Polypropylene to Polypropylene	60	120	105	120
Polypropylene to Polypropylene	80	120	On Test	On test
Polypropylene to Polypropylene	100	90	65	On Test

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 Safety Data Sheet (SDS).

Directions for use

For directions on how to apply a LOCTITE® primer, please click on this LINK or scan the QR code.

1. Clean all substrates prior to bonding with a suitable cleaner to remove any contaminants, greases, oils etc. and allow them to dry.

2. Once dry, remove the brush and apply a layer of primer onto the low surface energy plastic to be bonded. If both substrates are low surface energy plastic, prime both substrates. Do not prime plastics or metals that have high surface energy or which are normally bondable with LOCTITE® instant adhesives e.g steel, PVC, polycarbonate etc.

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3. Before bonding, allow the solvent to fully evaporate from the surface. Excellent bonding performance with LOCTITE cyanoacrylate adhesives can be achieved up to 2 hours after application, however it is recommended to bond immediately after priming to achieve optimum performance.

4. Excess primer should be avoided.

5. Presence of primer may be detected by means of a UV inspection lamp (365 nm). For detection purposes, use only low-intensity UV light (<5 mW/cm²) and a short exposure time (maximum 6 seconds / 30 mJ/cm²). Higher intensity or longer exposure will reduce product performance.

6.

Handling precautions
Primer must be handled in a manner applicable to highly flammable materials and in compliance with relevant local regulations. The solvent can affect certain plastics or coatings. It is recommended to check all surfaces for compatibility before use.

Storage
Store product in the unopened container in a dry location. Storage information may be indicated on the product container labeling. **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 Corporation 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.

Product Specification
The laboratory data contained herein are intended as reference only and are not considered specifications for the product. Product specifications are located on the Certificate of Analysis or please contact Henkel representative.

Approval and Certificate
Please contact your local Henkel representative for related approval or certificate of this product.

Data Ranges
The data contained herein may be reported as a typical value. Values are based on actual test data and are verified on a periodic basis.

Temperature/Humidity Ranges: 23 °C / 50% RH = 23±2 °C / 50±5% RH

Conversions
(°C x 1.8) + 32 = °F
kV/mm x 25.4 = V/mil
mm / 25.4 = inches
µm / 25.4 = mil
N x 0.225 = lb
N/mm x 5.71 = lb/in
N/mm² x 145 = psi
MPa x 145 = psi
N·m x 8.851 = lb·in
N·m x 0.738 = lb·ft
N·mm x 0.142 = oz·in
mPa·s = cP

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