



LOCTITE[®] 736

July 2004

PRODUCT DESCRIPTION

LOCTITE[®] 736 provides the following product characteristics:

Technology	Activator for Loctite anaerobic structural adhesives and sealants
Chemical Type	Aldehyde-amine condensate and Organocopper compound
Solvent	Trichlorethylene and Isopropanol
Appearance	Light amber liquid ^{LMS}
Viscosity	Very low
Cure	Not applicable
Application	Cure acceleration of Loctite anaerobic structural products

LOCTITE[®] 736 is used where increased cure speed of Loctite anaerobic structural products is required. It is especially recommended for applications with passive metals or inert surfaces and with large bond gaps.

TYPICAL PROPERTIES

Specific Gravity @ 25 °C	1.30
Viscosity @ 20 °C, mPa·s (cP)	3
Flash Point - See MSDS	
On Part Life, minutes	≤30

TYPICAL PERFORMANCE

Adhesive Properties

After 2 minutes @ 22 °C:

Lap Shear Strength, ISO 4587:

Steel and Loctite [®] adhesive 312, two side activation	N/mm ² (psi)	≥11 ^{LMS} (≥1,595)
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HANDLING PRECAUTIONS

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

GENERAL INFORMATION

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

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

Under no circumstances should activator and adhesive be mixed directly as liquids. Use only in a well ventilated area.

Where aqueous washing systems are used to clean the surfaces before bonding, it is important to check for compatibility of the washing solution with the adhesive. In some cases these aqueous washes can affect the cure and performance of the adhesive.

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 30 minutes. Contamination of the surface before bonding should be prevented.
4. Apply the Loctite anaerobic product to one or both surfaces and assemble parts immediately. If activator is applied to one surface only, apply adhesive to the non-activated surface.
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.

Loctite Material Specification^{LMS}

LMS dated July 08, 2004. Test reports for each batch are available for the indicated properties. LMS test reports include selected QC test parameters considered appropriate to specifications for customer use. Additionally, comprehensive controls are in place to assure product quality and consistency. Special customer specification requirements may be coordinated through Henkel Loctite Quality.

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 Technical Service Center or Customer Service Representative.

Conversions

(°C x 1.8) + 32 = °F
 kV/mm x 25.4 = V/mil
 mm / 25.4 = inches
 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·mm x 0.142 = oz·in
 mPa·s = cP

Note

The data contained herein are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof. In light of the foregoing, **Henkel Corporation specifically disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Henkel Corporation's products. Henkel Corporation specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits.** The discussion herein of various processes or compositions is not to be interpreted as representation that they are free from domination of patents owned by others or as a license under any Henkel Corporation patents that may cover such processes or compositions. We recommend that each prospective user test his proposed application before repetitive use, using this data as a guide. This product may be covered by one or more United States or foreign patents or patent applications.

Trademark usage

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Reference 1