

# Technical data sheet



Product: INI1

Manufacturer: HENKEL KGAA

Product group: KLEBSTOFF

Article group: INITIATOR

Download: 03.05.2024

## LOCTITE SF INI1

This data sheet was provided to you by Tewipack Uhl GmbH. The company tewipack Uhl GmbH assumes no responsibility for the topicality and the Accuracy of the information contained. The properties of the products can vary due to various influences such as composition and condition of the Substrate, impurities in or on the substrate, temperature and humidity at the Change storage and environmental conditions during use. Using this product in combination with other material, the customer is responsible for to check through our own tests whether the product is suitable for the planned combination and whether this combination delivers the expected results

Tewipack Uhl GmbH  
Industriestraße 15  
D-75382 Althengstett

Telephone:  
+49(0)7051/9297-0  
Fax:  
+49(0)7051/9297-99

E-Mail:  
info@tewipack.de  
Website:  
www.tewipack.de

Managing director:  
Alexander Uhl,  
Michael Uhl  
HRB 330424  
Amtsgericht  
Stuttgart

Bank details:  
Sparkasse  
Sindelfingen  
Pforzheim  
Calw  
BLZ 666 500  
85  
Konto 17 787

Commerzbank  
Sindelfingen  
BLZ 603 400 71  
Konto 8 001 166

Vereinigte  
Volksbank AG  
Böblingen  
BLZ 603 900 00  
Konto 80 089  
003

Postbank  
Stuttgart  
BLZ 600 100  
70  
Konto 146  
294 708

# LOCTITE® SF INI1

June 2020

## PRODUCT DESCRIPTION

LOCTITE® SF INI1 provides the following product characteristics:

<b>Technology</b>	Activator for LOCTITE® toughened acrylic adhesives
<b>Chemical Type</b>	Substituted dihydropyridine
<b>Solvent</b>	None
<b>Appearance</b>	Amber to light brown liquid
<b>Viscosity</b>	Very low
<b>Cure</b>	Not applicable
<b>Application</b>	Cure promotion of toughened acrylic adhesives

LOCTITE® SF INI1 is designed to initiate the cure of LOCTITE® toughened acrylic adhesive LOCTITE® AA F246.

## TYPICAL PROPERTIES OF UNCURED MATERIAL

Specific Gravity @ 25°C 0.97

Viscosity @ 25°C, mPa.s (cP)

U-Tube Viscometer 60

## TYPICAL PERFORMANCE

Fixture time and cure speed achieved as a result of using LOCTITE® SF INI1 depend on the substrate bonded, surface cleanliness and whether one or two surface activation is used.

Fixture Time @ 22°C, ISO 4587, minutes: 5

Steel (degreased) using LOCTITE® AA F246  
single side activation

(Fixture time is defined as the time to develop a shear strength of 0.1 N/mm<sup>2</sup> )

## 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:

1. Most surfaces may be bonded "as received" but contamination such as loose oxide layers or excessive oil may affect cure speed and bond strength. Cleaning is recommended if maximum strength is required.
2. Brush on the activator to one of the mating surfaces to be bonded. Apply adhesive to other surface.
3. For large gaps (>0.4 mm or 15.8 mils) or where maximum cure speed is required then treatment of both surfaces is recommended.
4. The activator will not dry and will remain active for up to 30 minutes. Bond assembly should be completed within this time.
5. Where adhesive is applied onto an activated surface, assembly should be completed as quickly as possible (within 15 seconds).
6. Secure the assembly and await fixturing before any further handling.

## Handling Precautions

Users are reminded that all materials, whether innocuous or not, should be handled according to the principles of good industrial hygiene.

Activator must be handled in compliance with relevant local regulations.

The initiator 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: below 8 to 21 °C. Storage 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 technical 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 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**

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

**Note:**

The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. The product can have a variety of different applications as well as differing application and working conditions in your environment that are beyond our control. Henkel is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product.

Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

**In case products are delivered by Henkel Belgium NV, Henkel Electronic Materials NV, Henkel Nederland BV, Henkel Technologies France SAS and Henkel France SA please additionally note the following:**

In case Henkel would be nevertheless held liable, on whatever legal ground, Henkel's liability will in no event exceed the amount of the concerned delivery.

**In case products are delivered by Henkel Colombiana, S.A.S. the following disclaimer is applicable:**

The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. Henkel is not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product.

Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

**In case products are delivered by Henkel Corporation or Henkel Canada, Inc. the following disclaimer is applicable:**

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**

Except as otherwise noted, all trademarks in this document are trademarks of Henkel Corporation in the U.S. and elsewhere. ® denotes a trademark registered in the U.S. Patent and Trademark Office.

Reference 0.0