

# A649 Activator

Engineering Adhesives

## DESCRIPTION

A649 Structural Activator is used where an increase in the speed of cure of an Anaerobic adhesive or structural bond is required.

A649 can be used to increase cure speed on passive surfaces (e.g. stainless steel), inert surfaces, or where large gap fill is required.

A649 is also used as an Activator for some SCIGRIP adhesives such as ST3326 where it acts as a catalyst without which the adhesive is unable to cure.

A649 is also useful in areas where cold (<15°C) conditions slow down or almost inhibit the cure of an Anaerobic compound.

Typical Properties	
Chemical base:	Blend of Solvents Acetone / Heptane
Colour:	Turquoise Tint
Specific Gravity	0.68-0.73
Flash point:	-8°C
Drying Time:	<30 seconds

## APPLICATIONS

Testing should be undertaken to ensure that even after cleaning the residues from previous treatments do not inhibit the cure mechanism of the adhesive or activator

## LIMITATIONS

The products are not recommended for oxygen rich systems. Care should be taken near plastics, A649 and its variants do not function well with Anaerobic sealants such as S974, S910, and S918 where Activator A471 is better suited.

## DIRECTIONS FOR USE

Spray or brush activator onto either both or one surface. It may be necessary to treat both surfaces in the case of big gaps or where more activity is required. In the case of A649 allow solvent to evaporate & dry.

Parts should be bonded as soon as possible, but activators kept in clean conditions will last up to 30 days.

Next assemble by applying adhesive to one or both surfaces and apply firm pressure for 30-40 seconds without movement. Parts will have a handling strength usually within 1-2 minutes, but full strength can take up to 12-24 hours depending on conditions and metals activity.

## PACKAGING

SCIGRIP A649 is supplied 1 Litre tins.

## STORAGE & SHELF LIFE

Store in cool area out of direct sunlight.

12 months in original closed packing at temperature 20°C.



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## HEALTH & SAFETY

Never mix activator and adhesive in volume, as a high exothermic reaction will take place generating heat and fumes.

For further information please refer to Safety Data Sheet.

