

Ultrabond® 786

Product Description

Hernon® Ultrabond 786 is an EB/UV curable product that provides excellent adhesion to a wide variety of substrates like metals, glass, ceramics and plastics. The sealant offers a water-tight seal with excellent environmental and high impact resistance.

Typical Properties (Uncured)

Property	Value
Appearance	Clear to Light Yellow Liquid
Viscosity @ 25°C, cP	9000 to 15000
Specific Gravity	1.04
Refractive Index, Nd	1.47
Flash Point	See SDS

Typical Properties (Cured)

Physical Properties

Property	Value
Hardness, ASTM D2240, Shore A	55-65

Typical Curing Performance

Adhesive Properties

This product is cured when exposed to UV radiation of 365nm. The speed of cure will depend on the UV intensity as measured at the product surface.

Cure Time

Measured @ 365 nm, using medium pressure, mercury arc lamp: US 1000, at ½ inch distance: < 5 seconds
By using LED9, at ¼ inch distance: < 10 seconds

Fixture Time

Fixture time is defined as the time to develop a shear strength of 0.1 N/mm².

Specimen	Cure Conditions	Fixture Time
Glass/Glass blocks	US 1000, at ½ inch distance	< 5 seconds

Typical Cured Performance

Block- Shear Strength on different specimens
Cured with US 1000, at ½ inch distance
Tested at RT, according to ASTM D4501.

Specimen	Cure Conditions	Value, psi
Glass to Glass	UV-cured for 30 sec, post-cured for 24 hours at 22 °C	50-150
Glass to Steel	UV-cured for 30 sec, post-cured for 24 hours at 22 °C	≥ 100

General Information

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

Directions for use

Apply enough material around the area to be sealed. Cure the material with a high intensity UV lamp for 5 seconds at 365 nm.

Factors Affecting UV Curing

- All UV sources degrade with use. Check output with a radiometer.
- Thicker films require longer cures.
- Light intensity decreases as distance from UV source increases.
- Some clear plastics may contain UV inhibitors.

Precautions When Using UV Lamps

- Never look directly at UV source.
- Wear protective UV goggles
- Do not expose bare skin to high intensity UV light.
- Wear protective clothing.
- Use in a well-ventilated area. Some UV sources generate ozone. Provide shielding around high intensity UV sources.
- High intensity UV sources generate heat. Take appropriate precautions.

Cleanup

Uncured **Ultrabond 786** should be cleaned up with acetone if uncured and placed in a closed container for disposal. Small areas can be cleaned up by curing the product prior to disposal by exposing the product to UV cure, light or sunlight. Afterwards the area can be washed with soap and water.

Storage

Ultrabond 786 is UV sensitive. Exposure to daylight, UV light and artificial lighting should be kept to a minimum during storage and handling. Product should be dispensed from applicators with black feed lines.

Ultrabond 786 can be stored in a dry location in unopened containers at a temperature between 60°F to 90°F (15°C to 32°C) unless otherwise labeled. Material must be mixed prior to use. To prevent contamination of unused material, do not return any material to its original container.

Dispensing Equipment

Hernon® offers a complete line of semi and fully automated dispensing equipment. Contact **Hernon® Sales** for additional information.

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