

## Technical Data Sheet Ultrabond<sup>®</sup> 752

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### Product Description

Hernon<sup>®</sup> Ultrabond<sup>®</sup> 752 is a UV curable adhesive product that provides excellent adhesion to glass and to plastics such as polyester, PVC, cellulose acetate, or nylon.

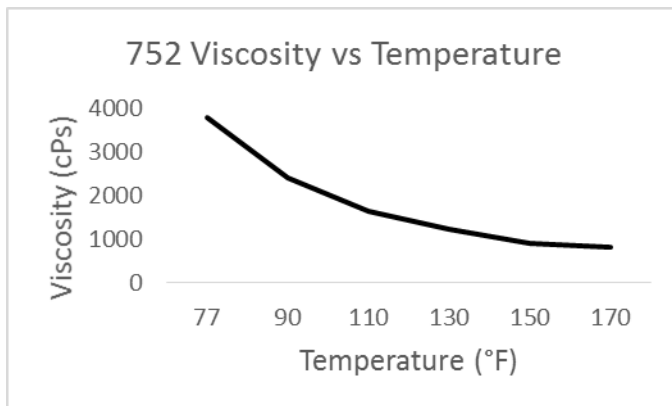
### Product Benefits

- 100% solid system (no solvents)
- Excellent adhesion to a variety of surfaces
- Excellent environmental resistance
- Good gap filling properties
- No shrinkage due to solvent evaporation
- Rapid room temperature cure

### Typical Properties (Uncured)

| Property                | Value                  |
|-------------------------|------------------------|
| Chemical Type           | Modified Acrylic Ester |
| Appearance              | Amber liquid           |
| Specific Gravity @ 25°C | 1.10                   |
| Viscosity @ 25°C, cP    | 3500 to 5000           |
| Flash Point             | See SDS                |
| Refractive Index, nD    | 1.496                  |

### Typical Variance of Viscosity with Temperature



### Typical Properties (Cured)

#### Physical Properties

| Property                      | Value |
|-------------------------------|-------|
| Hardness, ASTM D2240, Shore A | 65-75 |

|                            |                         |
|----------------------------|-------------------------|
| Temperature Range, °C (°F) | -55 to 135 (-65 to 275) |
|----------------------------|-------------------------|

### Typical Curing Performance

Ultrabond<sup>®</sup> 752 will cure rapidly at room temperature when exposed to high intensity ultraviolet light (365 nm). The speed of cure will depend on the UV intensity as measured at the product surface.

#### Tack Free 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: < 5 seconds

#### Fixture Time

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

| Specimen    | Cure Conditions             | Fixture Time |
|-------------|-----------------------------|--------------|
| Glass/Glass | 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 | ≥ 250      |
| Glass to Steel | UV-cured for 30 sec, post-cured for 24 hours at 22 °C | ≥ 450      |

### 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).

#### Factors Affecting UV Curing

- Dark surfaces lengthen cure time.
- Full range (UV-A, B & C) lamps provide faster cures than filtered sources.
- 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.

#### **Storage**

**Ultrabond® 752** should be stored in a cool, dry location in unopened containers at a temperature between 45°F to 85°F (7°C to 29°C) unless otherwise labeled. Optimal storage is at the lower half of this temperature range. To prevent contamination of unused material, do not return any material to its original container.

#### **Dispensing Equipment**

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

These suggestions and data are based on information we believe to be reliable and accurate, but no guarantee of their accuracy is made. HERNON MANUFACTURING, INC. shall not be liable for any damage, loss or injury, direct or consequential arising out of the use or the inability to use the product. In every case, we urge and recommend that purchasers, before using any product in full scale production, make their own tests to determine whether the product is of satisfactory quality and suitability for their operations, and the user assumes all risk and liability whatsoever, in connection therewith. Heron's Quality Management System for the design and manufacture of high-performance adhesives and sealants is registered to the ISO 9001 Quality Standard.