HERNON®
Formulating Solutions

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Ultrabond® 752

Product Description

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

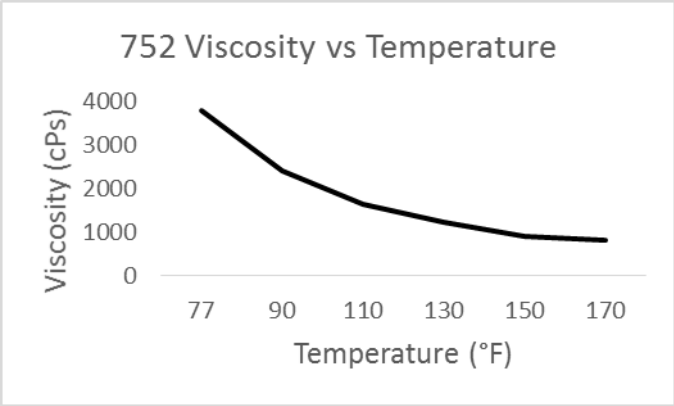
Product Benefits

- 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 @ 25ºC	1.10
Viscosity @ 25ºC, 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, ºC (ºF)	-55 to 135 (-65 to 275)

Typical Curing Performance

Ultrabond® 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/mm².

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 ºC	≥ 250
Glass to Steel	UV-cured for 30 sec, post-cured for 24 hours at 22 ºC	≥ 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 45ºF to 85ºF (7ºC to 29ºC) 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

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