HERNON®
Formulating Solutions

121 Tech Drive, Sanford FL 32771
PH: 407-322-4000 / 800-527-0004
HERNON.com

Supertacker® 352

Product Description

Hernon® Supertacker® 352 is a single component, high performance elastomeric adhesive that exhibits exceptional bonding characteristics to a broad range of materials including metals, glass, plastic composites, rubber, leather, wood and vinyl. **Supertacker® 352** provides a tough, waterproof bond that won't crack or become brittle. **Supertacker® 352** out-performs silicones, acrylics, and rubber cement because it bonds to more surfaces with greater strength and durability.

Product Benefits

- Exceptional flexibility – Does not become brittle in cold weather, can bond items subject to vibration.
- Waterproof – Can be submerged in fresh and salt water after complete cure.
- Abrasion resistance – Great for bonding objects subject to wear.
- Non-flammable
- Paintable – Paint to match surrounding area or make UV-resistant.
- Excellent resistance to dilute acids and dilute caustics

Typical Applications

- Bonding dust caps to baskets for surround or lead wires on loudspeaker applications.
- Repair conveyor belts.
- Seal tanks and pipes.
- Insulate electrical connections and repair plastic containers.
- Bond glass, metal, plastics and wood.
- Repair torn vinyl mats.
- Affix plastic moldings and trim.
- Reinforce and seal metal seams in garage doors and HVAC systems

Typical Properties (Uncured)

Property	Value
Appearance	Black liquid
Viscosity @ 25ºC, cP	44,000-56,000
Specific gravity	1.37
Solids, %	30 by weight, 40 by volume
Tack free time, minutes	≤30
Flash point	See SDS

Typical Properties (Cured)

Property	Value
Tensile strength, psi, ASTM D412	3500
Elongation, %, ASTM D412	900
Hardness, Shore A, ASTM D2240	80
Dielectric strength, volts/mil, ASTM D149	400
Full Cure, thin film, hours	24
Temperature range, ºC (ºF)	-40 to 150 (-40 to 302)

Typical Cured Performance

180º Peel Strength, ASTM D903
Cured 7 Days at 22ºC

Substrate	180º Peel Strength, pli	Substrate	180º Peel Strength, pli
Glass	34	Polycarbonate	37
Wood	40	PVC	38
Cement	25	Acrylic	36
Aluminum	35	Urethane	32
Steel	45	Rubber	30
ABS	32	Neoprene	32

Directions for Use

1. Surface should be clean and dry. For best results roughen surface before use. Best when used between 70°F and 90°F.
2. Apply to each surface to be bonded, then press both surfaces together.
3. For porous surfaces (wood and concrete) apply a liberal bead of adhesive to surfaces and bond immediately.
4. **Supertacker® 352** hardens by solvent evaporation. At 70ºF (21ºC) the adhesive will provide significant "grab" in 5-10 minutes. However, normal bond lines require 24 hours and thick bond lines may require 48 to 72 hours.
5. Cure time increases with lower temperatures and decreases with temperatures above 70ºF (21ºC).
6. When finished, wipe excess adhesive from the tube neck and secure with cap.

Application Notes

1. Some substrates require light sanding for optimum adhesion.
2. As a sealant: Use thin coats of **Supertacker® 352** to build up to thick coating, allowing each layer to set 3 to 4 hours.
3. Speed drying time by using a hand-held dryer. Set on low heat. Do not hold directly on adhesive.
4. If product is used to adhere fabric, do not dry clean fabric.
5. **Supertacker® 352** is not recommended for use on Aquariums, Styrofoam™, polystyrene, polyethylene or polypropylene plastics.

Typical Environmental Resistance

Chemical/Solvent Resistance

Supertacker® 352 exhibits excellent resistance to water, dilute acids and dilute bases. Thin films of **Supertacker® 352** were immersed in the chemicals/solvents listed below for two weeks and exhibited little or no effect.

Chemical/Solvent	Chemical/Solvent
Acetic acid, 5%-10%	Lactic acid, 3.8%
Sulfuric acid, 3%- 10%	Sodium chloride, 10%
Distilled water	Sodium carbonate, 2.7%
Motor oil, 30w	Potassium hydroxide, 3.4%
Nitric acid, 10%- 20%	Ammonium hydroxide, 3.4%
Hydraulic oil	Ammonium nitrate, 50%
Antifreeze	Boric acid, 3.1%
Phosphoric acid, 30% - 60%	Oxalic acid, 3.1%

Chemical/Solvent Non-Resistance

The following is a list of common solvents that dissolve **Supertacker® 352** when hardened samples are immersed. The dissolution with these solvents is not instantaneous and therefore does not preclude usage in all cases. Applications where an occasional splash or brief exposure is expected may be acceptable. Test a small area before full use.

Chemical/Solvent	Chemical/Solvent
Gasoline	Propyl acetate
Cyclohexane	Toluene
Perchloroethylene	Methylene chloride
1,1,1-Trichlorethane	

Storage

Supertacker® 352 should be stored in a cool, dry location in unopened containers at a temperature between 50ºF to 80ºF (10ºC to 27ºC). Allow product to warm to room temperature before use. To prevent contamination of unused material, do not return any material to its original container.

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).

Dispensing Equipment

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