

## HPS Initiator 4322

### Product Description

Hernon<sup>®</sup> HPS Initiator 4322 is used to activate Hernon<sup>®</sup> Hernon<sup>®</sup> Porosity Sealant (HPS) resins.

### Typical Properties

Property	Value
Appearance	White
Flash Point	See SDS

### Gel Time

Gel time\*\* at 90°C with **HPS 994R**: 4 to 10 minutes

\*\*99.8 grams of **HPS 994R** mixed with with 0.2 grams of **HPS Initiator 4322**

### Activation Instructions

**HPS 994R** can be activated using the following mixing proportions:

<u>HPS 994R</u>	<u>HPS Initiator 4322</u>
1 Gallon (3.78Kg)	7.6 grams
5 Gallons (18.9Kg)	37.8 grams

Mix thoroughly until the initiator is completely dissolved before use.

Please see technical data sheets for HPS resins for Activation instructions and Directions for Use.

### Cure Mechanism and Rate

HPS resins cures to form a thermoset polymer when exposed to elevated temperature. Thermal content and coefficient of thermal transfer in the workpieces influence the cure rate of the HPS system.

Higher temperatures produce quicker cure rates. **HPS resins generally** cures within the range of 177°F (80°C) to 205°F (96°C).

Proper cure requires the workpiece to uniformly attain full cure temperature. Parts that do not transfer heat well will required longer processing times. Efficient thermal conductivity yields shorter processing cycles. Parts with heavier cross sections require longer exposure at heat to attain sufficient temperature internally. Carefully consider part geometry.

Consult **Hernon<sup>®</sup>** Technical Service for specific process requirements.

### Handling Precautions

This is a highly flammable material. When dispensing this material from a pressurized system, only nitrogen or argon should be used. Please check local, state and federal regulations regarding the use of flammable liquids in the workplace. For example, special care must be taken to avoid contact of the activator or its vapor with naked flame or any electrical equipment that is not flame proofed.

### Storage

Store in the unopened container in a dry location. Store in a cool, dry location in unopened containers at a temperature below 10 °C. 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 with a sealant for chlorine or other strong oxidizing materials.**

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

Where aqueous washing systems are used to clean the surfaces before bonding, it is important to check for compatibility of the washing solution with the adhesive. In some case these aqueous washes can affect the cue and performance of the adhesive.

### Dispensing Equipment

**Hernon<sup>®</sup>** offers a complete line of semi and fully automated dispensing equipment. Contact **Hernon<sup>®</sup> 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<sup>®</sup>, 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. Hernon's Quality Management System for the design and manufacture of high-performance adhesives and sealants is registered to the ISO9001 Quality Standard.