

Instantbond 127

Product Description

Hernon[®] Instantbond 127 is a gel consistency single component, solventless, room temperature adhesive that sets in seconds when confined between two surfaces. The gel consistency allows for gap filling capability and prevents migration to unwanted areas.

Typical Applications

- Rapid bonding of a wide range of metal, plastic, or elastomeric material.
- On narrow flanges to maintain adhesive width control
- On porous substrates such as leather or foamed plastic or rubber.

Product Benefits

Instantbond 127 develops handling strength within seconds and a fully cured resilient bond within 24 hours. It can bond a wide variety of surfaces to include metals, thermoplastics, ceramics, leather, cork, and paper.

Performance Requirements

Instantbond 127 meets the requirements of CID A-A-3097 Type II Class 5.

Typical Properties (Uncured)

Property	Value
Chemical Type	Ethyl Cyanoacrylate
Appearance	Clear gel
Viscosity @ 77°F (25°C), cP	15,000 to 40,000
Specific gravity	1.06
Flash point	See SDS

Typical Properties (Cured)

Physical Properties

Property	Value
Temperature range, °C, (°F)	-55 to 82 (-65 to 180)

Typical Curing Performance

Cure Speed vs. Substrate

The rate of cure will depend on the substrate used. The table below shows the fixture time achieved on different materials at 22°C. Fixture time is defined as the time to develop a shear strength of 0.1 N/mm².

Substrate	Fixture Time (seconds)
Polycarbonate	≤ 45

Cure Speed vs. Bond Gap

The rate of cure will depend on the bondline gap. Thin bond lines result in high cure speeds, increasing the bond gap will decrease the rate of cure.

Typical Cured Performance

Shear Strength

Cured 24 Hours @ 22°C - tested according to ASTM D1002.

Substrate	Shear Strength, N/mm ² (psi)
Steel (grit blasted)	≥13.8 (≥2000)

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).

Directions for Use

For best performance bond surfaces should be clean and free from grease. This product performs best in thin bond gaps (<0.05 mm).

Disassembly and Cleanup

Liquid Cyanoacrylate should not be wiped with rags or tissue. The fabric will cause polymerization and large quantities of adhesive will heat or cure causing smoke and strong irritating vapors. Always flood with excess water to clean up spill conditions.

Storage

Cyanoacrylate adhesives must be stored under refrigeration at a temperature of 40°F ± 5°F for extended

shelf life. Before opening, the containers must be warmed to room temperature, otherwise, water may condense into the bottle and cause hardening of the adhesive. To prevent contamination of unused adhesive, do not return product to its original container.

Dispensing Equipment

Hernon® offers a complete line of semi and fully automated dispensing equipment. Contact **Hernon® 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. Hernon's Quality Management System for the design and manufacture of high-performance adhesives and sealants is registered to the ISO 9001 Quality Standard.