

Technical Data Sheet Blank Ammunition Sealant 48641

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Product Description

Hernon® Blank Ammunition Sealant 48641 is a medium viscosity, UV and LED curable compound formulated to provide high performance, fast curing, coating and sealing of ammunition blank tips. This product is also used for shallow potting applications.

Product Benefits

- UV fluorescence for in-process inspection
- LED curable
- NO Solvents 100% solid system
- 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	Purple, fluorescent liquid
Viscosity @ 25°C, cP	600 to 800
Specific Gravity @ 25°C	1.01
Flash Point	See SDS

Factors Affecting UV Curing

- 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
- 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.

Typical Curing Performance

Blank Ammunition Sealant 48641 will cure rapidly at room temperature when exposed to high intensity

ultraviolet light (365 nm). UV light intensities above 100 mW/cm² will insure optimum surface cure.

Tack Free Time

Property	Value
Tack free time, seconds	≤ 3 secs

Typical Properties (Cured)

Shear Strength

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

Substrate	Shear Strength, psi
Glass to Steel	≥ 300

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).

Storage

Blank Ammunition Sealant 48641 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

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

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