

Technical Data Sheet Cup/Core Plug Sealant 928

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Product Description

Hernon® Cup/Core Plug Sealant 928 is a thixotropic anaerobic sealant designed for sealing core plugs but applicable to many other high strength applications where non-migration is desired.

Typical Applications

Sealing and securing cylindrical metal assemblies:

- Engine block cup and core plugs
- Water pump seals
- Hub and shaft assemblies

Typical Properties (Uncured)

Property	Value
Chemical type	Dimethacrylate ester
Appearance	Red fluorescent liquid
Viscosity at 25°C, cP	Spindle 3 at 2.5 rpm Spindle 3 at 20 rpm
	6,000 to 12,000 1,500 to 3,500
Specific gravity	1.08
Flash point	See SDS

Typical Curing Performance

Property	Value
Temperature Range, °F	-65 to 300
Set Time, Steel, minutes	≤30

Typical Cured Performance

Compressive Shear Strength,
Tested at RT, on steel pins and collars according to ASTM D4562.

Cure Conditions	Temperature	Strength, psi
24 Hours	22 °C	≥ 1500

Cured and tested at 22°C on 3/8 x 16 grade 2 nuts and grade 5 bolts.

Cure	Substrate	Torque	N•m (in-lb)
24 Hours	Steel	Breakaway	≥16.9 (≥150)
		Prevailing	≥5.6 (≥50)

Typical Environmental Resistance

Cured for 72 hours @ 23°C

Shear strength

Steel pins and collars, according to ISO 10123.

Hot Strength and Heat Aging

Test	Shear Strength, N/mm² (psi)
Hot strength at 88°C tested at Temperature	≥13.8 (≥2000)
Heat aging, 120 hours at 121°C, tested at 22°C	≥13.8 (≥2000)

Solvent/Chemical Resistance

Aged under conditions indicated and tested at 23°C

Solvent	Temperature (°F)	% of Initial Strength			
		1 week	2 weeks	4 weeks	8 weeks
Gasoline	73	119	124	99	129
Glycol / H ₂ O (50:50)	270	121	96	96	86
ATF	300	229	224	202	210
Motor Oil	300	209	195	210	197

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).

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 cure and performance of the adhesive.

This product is not normally recommended for use on plastics (particularly thermoplastic materials where stress cracking of the plastic could result). Users are recommended to confirm compatibility of the product with such substrates.

Directions for use

1. For best performance bond surfaces should be clean and free from grease.
2. Apply **Cup/Core Plug Sealant 928** to both parts to assure sufficient coverage.

3. Parts must be closely- fitted metal surfaces in order to assure effective sealing and bonding of the assembly.
4. Assemble parts in accordance with standard practice.
5. **Cup/Core Plug Sealant 928** cures in 2 hours on activated parts. Allow 24 hours on unactivated parts.

Storage

Cup/Core Plug Sealant 928 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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