

ReAct® 730

Product Description

Hernon® ReAct® 730 is a high strength non-flammable structural adhesive. This adhesive provides a resilient and rapid cure at room temperature when used with **Hernon® Activator 59, 56 and 63**. **ReAct® 730** will provide high strength bonds on a variety of metals, ceramics, glass, and some plastics.

Typical Properties (Uncured)

Property	Value
Chemical type	Modified methacrylate
Appearance	Light yellow liquid
Viscosity @ 77°F (25°C), cP	50,000 to 80,000
Specific gravity	1.09

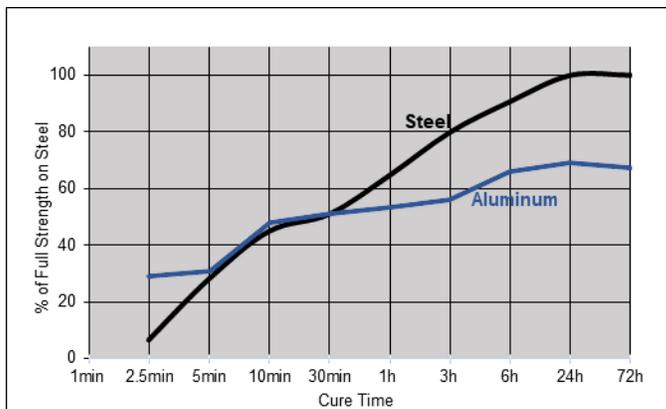
Typical Properties (Cured)

Property	Value
Coefficient of thermal conductivity, ASTM C 177, W/(m·K)	0.19

Typical Curing Performance

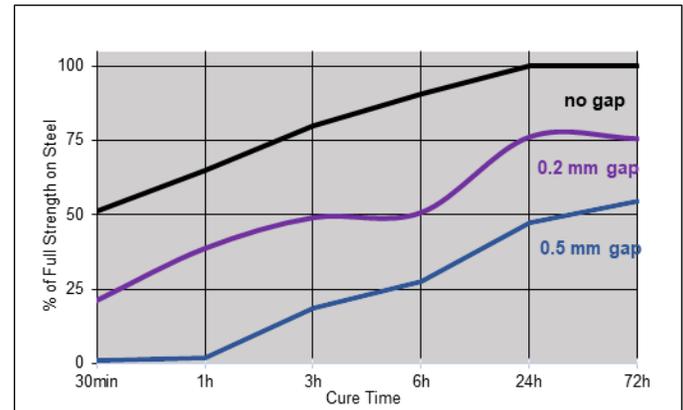
Cure Speed vs. Substrate

The rate of cure will depend on the substrate used. The graph below shows the shear strength developed with time on grit blasted lap shears and tested according to ASTM D1002. (**Activator 59** applied to one surface).



Cure Speed vs. Bond Gap

The rate of cure will depend on the bond line gap. The following graph shows shear strength developed with time on grit blasted steel lap shears at different controlled gaps and tested according to ASTM D1002. (**Activator 59** applied to one surface)



Fixture time and cure speed achieved as a result of using **ReAct® 730** depend on the activator used, the substrate bonded, surface cleanliness and whether one or two surface activation is used.

Fixture time is defined as the time to develop a shear strength of 0.1 N/mm².

Fixture times, were tested on lap-shear specimens, given below.

Hernon Activator	Substrate	Fixture Time (minutes)
Activator 59	G/B Steel	≤2
Activator 63	G/B Steel	≤5
Activator 56	G/B Steel	6-8

Typical Cured Performance

Cured 24 hours at 22°C.

Shear Strength was tested according to ASTM D1002. (**Activator** is applied to one surface)

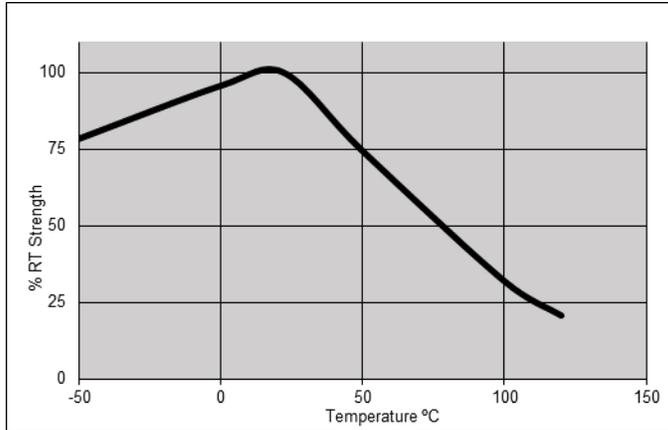
Substrate	Activator	Value (psi)
G/B steel	Activator 59	2500-3500
G/B steel	Activator 63	≥3000
Steel	Activator 63	≥2500
G/B steel	Activator 56	≥2500

Typical Environmental Resistance

Cured for 1 week @ 22°C,
Grit blasted steel lap-shear specimens (**Activator 59**
applied to one surface)
Shear Strength according to ASTM D1002.

Hot Strength

Tested at temperature



Heat Aging

Aged at temperature indicated and tested at 22°C

Aging Period	Temperature	Value N/mm ² (psi)
1000 hours	100°C	≥17.3 (2,500)
1000 hours	120°C	≥13.8 (2,000)

Chemical/Solvent Resistance

Aged under conditions indicated and tested at 22°C.

Chemical/Solvent	Temperature (°C)	% of Initial Strength
		720 hours
Water Glycol 50/50	87	66.2
Acetone	22	14.8
Gasoline	22	75.7
Motor Oil	87	≥100

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 cue and performance of the adhesive.

Directions for Use

1. For best performance bond surfaces should be clean and free from grease.
2. To ensure a fast and reliable cure, Hernon Activator should be applied to one of the bond surfaces and the adhesive to the other surface. Parts should be assembled within 15 minutes.
3. The recommended bond-line gap is 0.1mm. Where bond gaps are large (up to a maximum of 0.5 mm), or faster cure speed is required, **Activator** should be applied to both surfaces. Parts should be assembled immediately (within 1 minute).
4. Excess adhesive can be wiped away with organic solvent.
5. Bond should be held clamped until adhesive has fixtured.
6. Product should be allowed to develop full strength before subjecting to any service loads (typically 24 to 72 hours after assembly, depending on bond gap, materials, and ambient conditions).

Storage

ReAct® 730 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.

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.