HERNON®
Formulating Solutions

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ReAct® 761

Product Description

Hernon® ReAct® 761 is a tough acrylic adhesive designed primarily for bonding permanent magnets. **ReAct® 761** has also found wide acceptance in a variety of structural bonding applications due to its versatile performance capabilities.

ReAct® 761 provides high tensile strength while maintaining excellent product flexibility. This results in tough durable bonds with outstanding impact and peel resistance.

ReAct® 761 is a single component adhesive used in combination with **Hernon® Activator 59, Activator 56 or Activator 63** for curing at room temperature. The adhesive may also be heat cured at 150ºC.

Product Benefits

- High impact and shock resistance
- Good gap filling capabilities
- High temperature resistance
- Excellent adhesion to a variety of surfaces
- Consistent rate of cure in 60º to 100ºF
- Consistent bond strength
- Eliminates need for mechanical clips
- Requires minimal clamping time
- Room temperature cure, eliminates high cost of energy needed for heat cured material

Typical Properties (Uncured)

Property	Value
Resin	Modified acrylic
Appearance	Pale yellow liquid
Viscosity @ 25ºC, cP	80,000 to 120,000
Specific gravity	1.01

Typical Properties (Cured)

Property	Value
Hardness, Shore D	60-70

Typical Curing Performance

ReAct® 761 is designed to be used with **Activator** and cured at room temperature. Cure characteristics are measured by determining fixture time (handling time) and speed of cure.

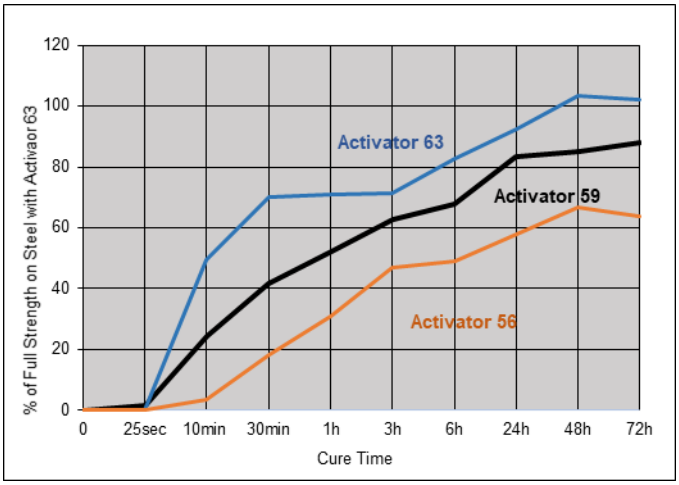
Fixture Time

Fixture time is defined as the time to develop a shear strength of 0.1 N/mm².
Fixture Time, G/B steel, with **Activator** on 1 side.

Gap, mm	Activator	Fixture Time, minutes
0	**Activator 59**	≤ 3
0.05	**Activator 59**	≤ 3
0.20	**Activator 59**	≤ 15
0.50	**Activator 59**	≤ 30
0	**Activator 63**	≤ 2
0	**Activator 56**	≤ 2

Cure Speed vs. Substrate

The graph below shows the shear strength developed with time on steel lap-shear specimens, tested according to ASTM D1002 (**Activator** is applied to one surface).



Typical Cured Performance

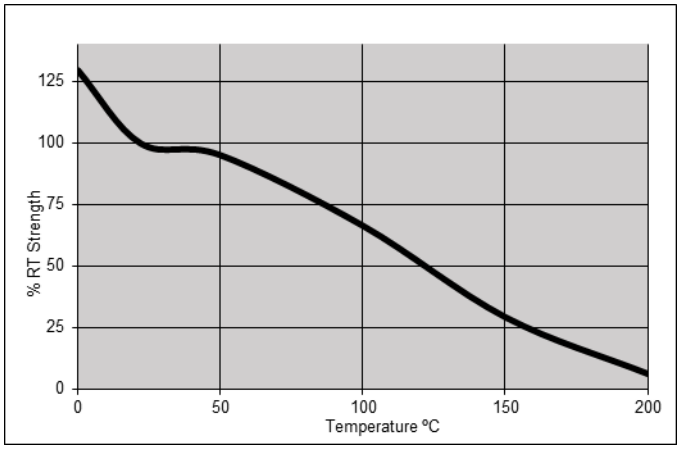
Shear Strength

Tested at RT according to ASTM D1002

Substrate	Cure Type	Cure Conditions	Value (psi)
G/B Steel	Activator 56	24h at 22ºC	2000-3000
G/B Steel	Activator 59	24h at 22ºC	2000-3000
G/B Steel	Activator 63	24h at 22ºC	2500-3500
G/B Steel	Heat Cure	30m at 150ºC	≥4000
G/B Steel	Heat Cure	10m at 150ºC	≥3000
G/B Steel	Heat Cure	30m at 120ºC	≥2500
Stainless Steel	Activator 56	24h at 22ºC	1000-2000

Typical Environmental Resistance

Lap shear Strength, ASTM D1002.
Cured for 48 hours at 22ºC,
Steel, with **Activator 59** on 1 side.
Hot Strength
Tested at temperature



Heat Aging
Aged 1000 hours at temperature indicated, tested at 22ºC.

Temperature, ºC	% of Initial Strength
90	140
120	140
150	140
200	40

Chemical/Solvent Resistance
Aged for 720 hours at 87ºC in chemical/solvent indicated. Tested at 22ºC.

Chemical/Solvent	% of Initial Strength
Air reference	136
Water/glycol 50/50	120
Motor oil	100
Automatic Transmission Fluid	84
Brake Fluid	33

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. **Activator 59 or 56** should be applied to one of the bond surfaces and the adhesive to the other surface. Parts should be assembled within two hours. Minimizing the on-part time of the activator maximizes the consistency of performance.
3. Where bond gaps are large (up to a maximum of 0.5 mm), or faster cure speed is required, **Activator 59 or 56** should be applied to both surfaces. Parts should be assembled immediately.
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® 761 should be stored in a cool, dry location in unopened containers at a temperature between 45ºF to 85ºF (7ºC to 29ºC) 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 ISO9001 Quality Standard.