

Instantbond 127A

Product Description

Hernon® Instantbond 127A is a single-component, solvent-free, gel-consistency adhesive designed for rapid bonding at room temperature. The gel structure provides excellent gap-filling capability and prevents migration to unwanted areas. Once applied between two surfaces, it sets within seconds and forms a strong, resilient bond that fully cures within 24 hours.

Typical Applications

- Rapid bonding of metals, plastics, elastomers, and other substrates
- On narrow flanges to maintain adhesive width control
- Use on porous or absorbent substrates such as leather, foamed plastics, rubber, wood, paper, and fabric

Product Benefits

- Full cure and durable, resilient bond in 24 hours
- Excellent adhesion to metals, thermoplastics, ceramics, elastomeric compounds, leather, cork, and paper
- Gel consistency allows precise application without run-off
- Certified to RoHS, REACH, and PFAS-free standards

Performance Requirements

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

Typical Properties (Uncured)

Property	Value
Chemical Type	Ethyl Cyanoacrylate
Appearance	Clear gel
Specific gravity	1.05
Flash point	See SDS

Typical Properties (Cured)

Physical Properties

Property	Value
Temperature range, °C	-40 to +80
Glass transition temperature, °C	120

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
Steel (grit blasted)	≤ 30

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, psi
Steel (grit blasted)	≥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.

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