HERNON®
High Performance Adhesives and Sealants
ISO 9001 Registered

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Technical Data Sheet
EF® Primer 57

Product Description

Hernon® EF® Primer 57 is a single component, solvent-free, reactive monomer based product designed to promote the cure speed of **Hernon®** anaerobic adhesives and sealants.

Typical Applications

EF® Primer 57 is used where increased cure speed of **Hernon®** anaerobic products is required, and for difficult to bond applications where galvanized steel or zinc electroplated surfaces are involved. This product was specially formulated for increasing bond integrity on dichromated surfaces.

Typical Properties

Property	Value
Appearance	Light blue liquid
Specific Gravity @ 25ºC	1.03
Viscosity	Low
Solvent	None
On Part Life, hours	≤ 1
Flash Point	See MSDS

Typical Performance

Fixture time and cure speed achieved as a result of using **EF® Primer 57** depend on the adhesive used, the substrate bonded, surface cleanliness and whether one or two surface activation is used.

Fixture Time, ISO 4587
Grit blasted steel lap-shear specimens
One side activated with **EF® Primer 57**

Hernon Adhesive	Fixture Time (minutes)
HASA 722	≤ 4

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

General Information

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected with a sealant for chlorine or other strong oxidizing materials.

For safe handling information on this product, consult the Material Safety Data Sheet (MSDS).

Under no circumstances should activator and adhesive be mixed directly as liquids. Use only in a well ventilated area.

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 cases these aqueous washes can affect the cue 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

Cleanliness of the parts to be assembled has a direct effect on the speed and final curing performance of the adhesive. Be sure that the parts are clean and dry. **EF® Cleaner 62** is a reliable way of cleaning parts.

1. Apply the activator on one or both mating surfaces to be bonded.
2. The activator will not dry and will remain active for up to 1 hour after application.
3. Apply **Hernon®** adhesive to one surface and assemble parts immediately. Hold firmly for one to three minutes. Poorly fitted parts may require longer holding time.
4. When activator is applied to only one surface, apply the adhesive to the non-activated surface.
5. Secure the assembly and wait for adhesive to fixture before any handling.
6. Full cure occurs in 3 to 24 hours depending upon the gap between the surfaces.
7. When possible, move surfaces in relation to each other for a few seconds to distribute the adhesive evenly and to achieve maximum adhesion.

Storage

EF® Primer 57 should be stored in a cool, dry location in unopened containers at a temperature between 46ºF to 82ºF (8ºC to 28ºC) 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.