

Technical Data Sheet Dragonbond 194

December 2010

Page 1 of 1

Product Description

Hernon[®] Dragonbond 194 is a single component, clear cyanoacrylate adhesive, toughened for impact and peel resistance.

Typical Applications

Dragonbond 194 is a flexible cyanoacrylate excellent for parts subjected to shock and vibration on most metals, plastics, and rubber substrates.

Dragonbond 194 is used primarily in the silk screen printing industry with **EF[®] Accelerator 72** to bond the silk screen to the wood frame, but can be used in many other applications where a flexible bond is needed

Typical Properties (Uncured)

Property	Value
Resin	Ethyl cyanoacrylate
Appearance	Clear liquid
Viscosity @ 25°C, cP	700
Specific gravity	1.05
Flash point	See MSDS

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 Material Safety Data Sheet (MSDS).

Directions For Use

To ensure a good bond, surfaces must be clean and free from rust inhibitors, mold release agents, oil, and other components. Bond strength on painted parts is dependent on the paint to substrate strength.

Bond Durability

Surface area, surface temperature, environment, and stress all affect the durability of the bond.

Blooming

Adhesive vapors can settle on surfaces during cure and leave a white residue on parts. This condition is called blooming. This effect can be reduced by one or more of the following methods:

- Increase airflow
- Reduce amount of adhesive used on part
- Use **EF[®] Accelerator 72** to speed fixture
- Residue can be removed by **Hernon[®] Cyanoacrylate Remover 14**

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.

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 9001:2008 Quality Standard.