

## Technical Data Sheet EF<sup>®</sup> Accelerator 75

December 2009

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### Product Description

**Hernon<sup>®</sup> EF<sup>®</sup> Accelerator 75** is a low toxicity, non-flammable, non-combustible, non-ozone depleting, low volatile organic compound (VOC) accelerator which improves **Hernon<sup>®</sup>** instant adhesive fixturing and curing performance.

### Typical Applications

**EF<sup>®</sup> Accelerator 75** is used to provide curing on inactive surfaces, speed the cure on active surfaces and increase the curing speed between bonding surfaces.

### Typical Properties

Property	Value
Active ingredient	Organic amine
Appearance	Clear liquid
Specific gravity	1.50
Drying time, seconds	≤ 5
On part life, minutes	≤ 1
Flash point	See MSDS

### Typical Performance

Fixture time and cure speed achieved as a result of using **EF<sup>®</sup> Accelerator 75** depend on the adhesive used and the substrate bonded.

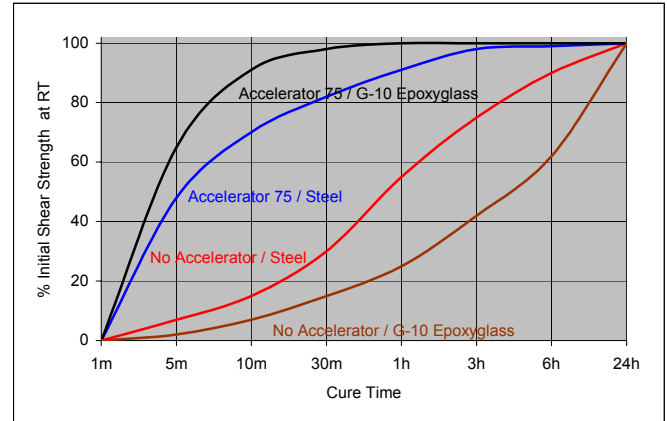
Fixture Time, ISO 4587, seconds  
Grit blasted steel - single side activation

Hernon <sup>®</sup> Instant Adhesive	Fixture Time, seconds
Instantbond™ 117	≤ 7

Fixture time is defined as the time to develop a shear strength of 0.1 N/mm<sup>2</sup>.

#### Strength vs. Time

The graph below shows the shear strength developed with time using **EF<sup>®</sup> Accelerator 75** with **Instantbond™ 117**. Testing was performed @ 22 °C in accordance with ISO 4587.



### Handling Precautions

The solvent can affect certain plastics or coatings. It is recommended to check all surfaces for compatibility before use.

### 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).**

### Directions for Use

#### Post Activation

- Apply **Instantbond™** adhesive to one of the surfaces to be bonded and assemble parts.
- Apply **EF<sup>®</sup> Accelerator 75** over all exposed **Instantbond™** adhesive by spray or by drop. (Use one drop of activator per one drop of exposed adhesive)

#### Surface Activation

- Apply one coating of Accelerator to the area to be bonded by spray, brush or dipping. Contaminated surfaces may need special cleaning or degreasing prior to activation to remove any soluble contamination.
- Allow the solvent time to evaporate until the surfaces are completely dry (approx. 30 seconds).
- Apply the **Hernon<sup>®</sup>** cyanoacrylate product immediately after drying or not more than 45 seconds thereafter.
- Activator can be re-applied if necessary if there is a delay of more than 45 seconds between original activator and adhesive application.

**Storage**

**EF® Accelerator 75** should be stored in a cool, dry location in unopened containers at a temperature between 46°F to 82°F (8°C to 28°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 ISO9001 Quality Standard.