

Technical Data Sheet HPS 994

November 2018

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Product Description

Hernon® Porosity Sealant (HPS) 994 is the solution to leak proof parts, improving machinability, in addition to increasing the durability and surface quality for painting and plating. The hardened resins exhibit superior chemical resistance and elevated temperature stability.

The microscopic voids, where potential leaks occur (between metal grains or ceramic plastic molecules) in the part are filled by the low viscosity resin during vacuum application. Sealed micropores cure without shrinkage when exposed to elevated temperature to form tough cross-linked thermoset polymer, permanently sealing the workpiece. Residual adhesive film is water-washed from the part surfaces during rinsing.

The parts leave the impregnating process without surface residue and can then be used in production immediately. When used in preparation for plating or painting processes, the impregnation process also eliminates absorption of plating materials (like acids) or painting prep solvents that could otherwise later bleed out of pores causing finishes to discolor, bleed, pit or peel.

Sealed powdered metal parts exhibit better machinability, enhanced tool life and better dimensional control.

Product Benefits

- Single component
- Cost effective
- Provides superior stability and reliability
- High speed processing, parts are ready in 30 minutes from floor to floor
- Reliability – Hardened resin exhibits superior chemical and physical, elevated temperature resistance and pressure sealability.
- A simplified process permitting processing of treated parts: immediate painting or machining of impregnated parts is possible because **HPS 994** resin leaves no residue.

Typical Applications

- Pneumatic tool castings
- Automotive carburetors
- Engine blocks
- Water and fuel pumps

- Plastic molds
- Valves, manifolds
- Railway, truck brake parts
- Hydraulic pumps
- Steering gear components
- Compressor parts
- Powdered metal gun parts
- Regulators

Typical Properties (Uncured)

Property	Value
Resin	Acrylate blend
Appearance	Yellow – Amber
Viscosity @ 25°C, cP	5 to 15
Specific gravity	1.01
Surface Tension, Dynes/cm	30.1
Flash point	See MSDS

Typical Properties (Cured)

Property	Value
Hardness, Shore D, ASTM D2240	70 to 85
Operating Temperature, °C (°F)	-55 to 150 (-65 to 300)

Directions for use

HPS 994 can be activated with **Hernon® HPS Initiator 91**. Activate the resin as follows:

HPS 994 HPS Initiator 91

To achieve a Gel time of 3 to 10 mins at 90°C a amounts of **Initiator 91** with **HPS 41814**

HPS 41814

1 Gallon
5 Gallons
50 Gallons

HPS Initiator 91

25 to 35 grams
145 to 155 grams
1450 to 1550 grams

Mix the Resin and Initiator thoroughly until completely dissolved before use.

Impregnation system reactivity is monitored by measurement of the Gel Time of a small controlled sample of resin taken from the system. The following operational parameters are presented as a “typical” scenario to assess cure rate of the impregnation process and system:

1. Keep Resin at temperatures between 60°F-80°F in Tank.
2. Gel Time @ 194°F (90°C) should be in the range of 3-10 minutes when activated.

HPS 994 has been formulated to produce Gel Times in the 3-10 minute range @ 194°F (90°C). Should the Gel Time be above 10 minutes contact **Hernon®** Customer Service.

Higher temperatures produce quicker cure rates. **HPS 994** cures within the range of 177°F (80°C) to 205°F (96°C).

Proper cure requires the workpiece to uniformly attain full cure temperature. Parts that do not transfer heat well will require longer processing times. Efficient thermal conductivity yields shorter processing cycles. Parts with heavier cross sections require longer exposure at heat to attain sufficient temperature internally. Carefully consider part geometry.

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).

Disposal of Waste

Wastes generated during the impregnation process can, in general, be adequately handled by conventional biological treatment methods. Since both the circumstances of use and local environmental requirements vary, waste disposal recommendations are somewhat application specific.

Storage

HPS 994 should be stored in a cool, dry location in unopened containers at a temperature below 77°F (25°C). To prevent contamination of unused material, do not return any material to its original container.

HPS 994 in an active impregnation system with normal use has unlimited pot life if recommended controls are maintained, including temperature controls. Do not allow continuous exposure to ultraviolet light. **HPS 994** does not require aeration.

Impregnation Equipment

Hernon® offers complete systems support for vacuum impregnation. A full selection of equipment and tank sizes is available. Each system is engineered to maximize quality control of the process to maximize

productivity, economy of sealant usage, and energy efficiency. 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 Quality Standard.