

Technical Data Sheet EF[®] Activator 15

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Product Description

Hernon[®] EF[®] Activator 15 is designed to be used with Hernon[®] ReAct[™] 727, 784 and Fusionbond 374.

Product Benefits

- Primer can be applied up to 2 hours before bonding parts or used instantly.

Typical Properties (Uncured)

Property	Value
Resin	Organic accelerator
Appearance	Yellow to amber liquid
Viscosity @ 25°C, cP	35
Specific gravity	0.965
Flash point	See MSDS

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 for ReAct[™] 727/784 using a thin layer of EF[®] Activator 15 on different materials at 22°C. Fixture time is defined as the time to develop a shear strength of 0.1 N/mm².

Tested on steel and aluminum lap-shear specimens, plastic and glass block-shear specimens. One side primed with EF[®] Activator 15.

Substrate	Fixture Time, minutes
As Received Steel	8
As Received Aluminum	12
Abraded Aluminum	10
Epoxyglass	10
Phenolic	5
PVC	4
ABS	4
Acrylic	10
Polycarbonate	5
Glass	22

Typical Cured Performance

The table below shows the shear strength achieved for ReAct[™] 727/784 using EF[®] Activator 15 on steel and aluminum lap-shear specimens tested in accordance with ISO 4587, and plastic and glass block-shear specimens in accordance with ISO 13445. Cured for 24 hours at room temperature. One side primed with EF[®] Activator 15.

Substrate	Shear Strength, N/mm ² (psi)
As Received Steel	33.4 (4850)
As Received Aluminum	7.2 (1050)
Abraded Aluminum	12.5 (1810)
Epoxyglass	11.9 (1720)
Phenolic	6.9 (995)
PVC	4.9 (710)
ABS	3.0 (430)
Acrylic	7.2 (1040)
Polycarbonate	5.4 (790)
Glass	9.9 (1440)

Directions For Use

1. Substrates should be free of heavy grease and grinding residues. A chemical conversion coating may enhance adhesive properties and provide maximum corrosion protection on metallic assemblies.
2. Apply a thin layer of EF[®] Activator 15 to one surface. Apply ReAct[™] 727/784 or Fusionbond 374 to the other surface to be bonded.
3. Join surfaces using sufficient force to spread adhesive thinly. Join parts within two hours of applying primer (primer on-part life is two hours maximum). Minimizing the on part time of the primer maximizes consistency in performance.
4. Maintain pressure until handling strength is achieved. Handling strength varies with part geometry, substrate, surface area, tolerances, etc.
5. Release pressure and allow 24 hours for adhesive to fully cure.

Storage

EF® Activator 15 should be stored in a cool, dry location in unopened containers at a temperature between 46°F to 85°F (8°C to 29°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.

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.

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 Quality Standard.