HERNON®
High Performance Adhesives and Sealants
ISO 9001 Registered

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Technical Data Sheet
Tuffbond® 47771

Product Description

Hernon® Tuffbond® 47771 adhesive/sealant is a two component, 100% solid system, one to one ratio, room temperature cure system.

Typical Applications

- Tank lining
- Chemical resistant flooring
- Marine coating
- Underwater coating
- Potting electrical components

Product Benefits

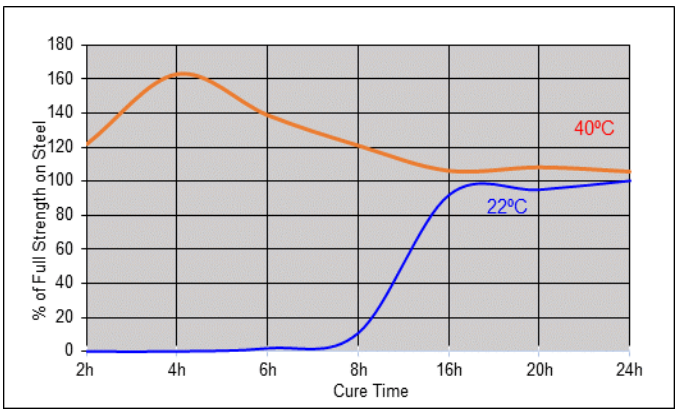
- Excellent resistance to organic acids and bases.
- Good mechanical properties.
- Outstanding resistance to abrasion.
- Non-critical mixing.
- Excellent adhesion to a wide variety of substrates

Typical Properties (Uncured)

Property	Resin	Hardener
Chemical Type	Epoxy	Amine
Color	Black	Amber
Viscosity at 25ºC, cP	60,000 to 70,000	60,000 to 70,000
Mix Ratio	1 Part	1 Part
Specific gravity at 25ºC	1.18	1.00

Cured Speed vs Temperature

Shear Strength on steel lap-shear specimens tested at 22ºC, according to ASTM D1002.



Typical Cured Properties

Property	Value
Working Life at 25ºC, 20g, 1:1 ratio (min.)	40 to 60
Thermal Conductivity, W/m ºK	0.65
Glass Transition Temperature, (Tg) ºC	77
Coefficient of thermal expansion, ASTM D696 (K^{-1}) :	
Below Tg	18 x 10^{-6}
After Tg	240 x 10^{-6}
Hardness, Shore D, ASTM D2240	70-80

Typical Cured Performance

Shear Strength on lap-shear specimens tested according to ASTM D1002.

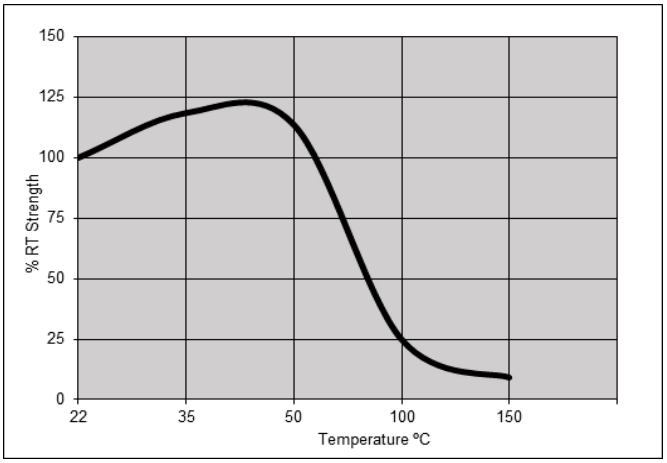
Cure Time at 22ºC	Shear Strength (psi)
24 Hours (Steel)	3,500 – 4,500

Typical Environmental Resistance

Shear Strength on steel lap-shear specimens tested according to ASTM D1002.
Cured for 72 hours at 22ºC.

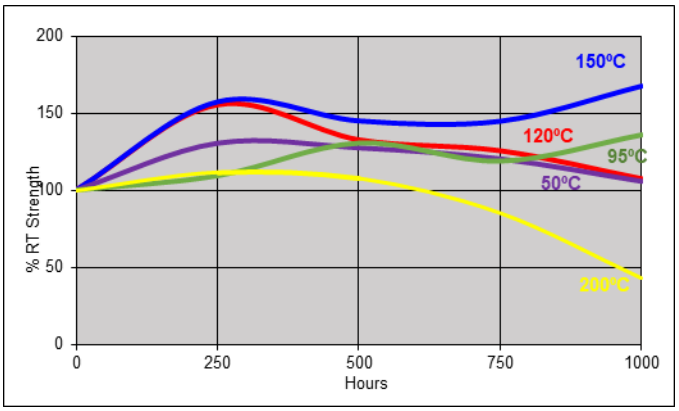
Hot Strength

Tested at temperature



Heat Aging

Aged at temperature indicated and tested at 22ºC.



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 Safety Data Sheet (SDS).

Storage

Tuffbond® 47771 should be stored in a cool, dry location in unopened containers at a temperature between 45ºF to 85ºF (7ºC to 29ºC) 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.