

## Technical Data Sheet Ultrabond Primer Sealant 34194

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### Product Description

**Hernon<sup>®</sup> Ammunition Primer Sealant 34194** is a single component 100% solid system offering a tough, dry coating with superior chemical and environmental resistance after cure. **Ammunition Primer Sealant 34194** will cure rapidly when exposed to high intensity U.V. light. This coating is formulated to migrate rapidly resulting in complete coverage of the gap. The fluorescent sealant will offer an easy inspection using standard vision system.

### Product Benefits

- UV fluorescence for in-process inspection
- 100% solid system (no solvents).
- Excellent environmental resistance
- Excellent waterproof resistance providing Leak free seals
- Good gap filling properties.
- No shrinkage due to solvent evaporation
- Rapid room temperature cure

### Typical Properties (Uncured)

Property	Value
Chemical Type	Modified Acrylic Ester
Appearance	Clear Fluorescent Liquid
Specific Gravity	1.00
Viscosity @ 25°C, cP	≤ 120
Flash Point	See MSDS

### Curing Characteristics

The following factors can affect cure rates:

- Lamp intensity and wave length
- Distance from light source
- Light transmittance of bonded part
- Temperature

### Typical Curing Performance

Fixture Time – High Intensity Light                      10 seconds

### Typical Properties (Cured)

Property	Value
Refractive Index	1.54 ± 0.02
Coefficient of Thermal Expansion, cm/cm°C	1.3 to 2.0 × 10 <sup>-6</sup>
Elongation, %	2
Temperature Range, °F	-65 to 250

### 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).**

Where aqueous washing systems are used to clean the surfaces before bonding, it is important to check for compatibility of the washing solution with the adhesive. In some cases these aqueous washes can affect the cure and performance of the adhesive.

### Ultraviolet Light

Precautions should be taken to avoid exposure of operator to direct or reflected radiation. Exposure to short wave ultraviolet light can cause a burning of the skin and eyes. Eyes and skin should be protected when mercury vapor lamps are in operation.

Most long wave ultraviolet sources do not require shielding.

### Recommended Lamps

For information about safe low intensity or high intensity rapid cure lamps, contact the **Hernon<sup>®</sup> Technical Department**.

### Storage

**Hernon Ammunition Sealant 34194** 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.

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