PRODUCT CATALOG

2019

HIGH PERFORMANCE ADHESIVES AND SEALANTS
PRECISION DISPENSING SYSTEMS
UV LED CURING EQUIPMENT
TOTAL SOLUTIONS

HERNON.COM
Hernon Manufacturing, Inc. produces high performance adhesives, sealants, UV LED curing lights and precision dispensing systems. Hernon maintains a library of over 5000 unique adhesive and sealant formulas in addition to creating customized formulas to address specific manufacturing challenges. A full in-house chemical laboratory ensures quick turn around on testing and development projects and an on-site machine division allows Hernon to build, service and integrate unique dispensing systems to even the most exacting specifications. This horizontal integration helps Hernon to provide customers with a Total Solution for any unique application.

Hernon Manufacturing is headquartered in Sanford, FL. and maintains an ever-expanding network of over 100 distributor and partner locations around the globe. Already shipping to over 60 nations, Hernon can provide adhesive solutions to manufacturing operations anywhere in the world.

Hernon Manufacturing’s objective is to continuously improve our products and services to meet our customer's needs. We are committed to the efficient delivery of quality products worldwide.

### Adhesives Category

<table>
<thead>
<tr>
<th>Performance Attributes</th>
<th>Acrylics</th>
<th>Cyanoacrylates</th>
<th>Epoxies</th>
<th>Silicones</th>
</tr>
</thead>
<tbody>
<tr>
<td>Benefits</td>
<td>Good impact resistance/flexibility</td>
<td>Excellent adhesion to rubber or plastics</td>
<td>Wide range of formulations</td>
<td>Excellent temperature resistance</td>
</tr>
<tr>
<td>Limitations</td>
<td>Primer required</td>
<td>Low solvent resistance</td>
<td>Mixing required</td>
<td>Low strength</td>
</tr>
<tr>
<td>Typical Temperature Resistance</td>
<td>-65°F to 300°F</td>
<td>-65°F to 180°F</td>
<td>-65°F to 180°F</td>
<td>-65°F to 400°F</td>
</tr>
<tr>
<td>Highest Temperature Resistance</td>
<td>400°F</td>
<td>250°F</td>
<td>275°F</td>
<td>600°F</td>
</tr>
</tbody>
</table>

### Environmental Resistance

<table>
<thead>
<tr>
<th>Solvents Type</th>
<th>Acrylics</th>
<th>Cyanoacrylates</th>
<th>Epoxies</th>
<th>Silicones</th>
</tr>
</thead>
<tbody>
<tr>
<td>Polar Solvents (ex, H2O, Ethylene Glycol, IPA, Acetone)</td>
<td>Good</td>
<td>Poor</td>
<td>Very Good</td>
<td>Good</td>
</tr>
<tr>
<td>Non-Polar Solvents (ex, Motor Oil, Toluene, Gasoline, ATF)</td>
<td>Very Good</td>
<td>Good</td>
<td>Excellent</td>
<td>Poor</td>
</tr>
</tbody>
</table>

### Adhesion to Substrates

<table>
<thead>
<tr>
<th>Substrate Type</th>
<th>Acrylics</th>
<th>Cyanoacrylates</th>
<th>Epoxies</th>
<th>Silicones</th>
</tr>
</thead>
<tbody>
<tr>
<td>Metals</td>
<td>Excellent</td>
<td>Very Good</td>
<td>Excellent</td>
<td>Good</td>
</tr>
<tr>
<td>Plastics</td>
<td>Fair</td>
<td>Very Good</td>
<td>Fair</td>
<td>Fair</td>
</tr>
<tr>
<td>Glass</td>
<td>Excellent</td>
<td>Poor</td>
<td>Excellent</td>
<td>Very Good</td>
</tr>
<tr>
<td>Rubber</td>
<td>Poor</td>
<td>Very Good</td>
<td>Fair</td>
<td>Good</td>
</tr>
<tr>
<td>Wood</td>
<td>Good</td>
<td>Good</td>
<td>Very Good</td>
<td>Fair</td>
</tr>
<tr>
<td>Overlapping Shear Strength</td>
<td>High</td>
<td>High</td>
<td>High</td>
<td>Low</td>
</tr>
<tr>
<td>Peel Strength</td>
<td>Medium</td>
<td>Low</td>
<td>Medium</td>
<td>Medium</td>
</tr>
<tr>
<td>Tensile Strength</td>
<td>High</td>
<td>High</td>
<td>High</td>
<td>Low</td>
</tr>
<tr>
<td>Elongation/Flexibility</td>
<td>Medium</td>
<td>Low</td>
<td>Low</td>
<td>Very High</td>
</tr>
<tr>
<td>Hardness</td>
<td>Semi-Rigid</td>
<td>Rigid</td>
<td>Rigid</td>
<td>Soft</td>
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### Process Considerations

<table>
<thead>
<tr>
<th>Process Type</th>
<th>Acrylics</th>
<th>Cyanoacrylates</th>
<th>Epoxies</th>
<th>Silicones</th>
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<tbody>
<tr>
<td>Number of Components</td>
<td>2</td>
<td>1</td>
<td>2</td>
<td>1</td>
</tr>
<tr>
<td>Fixture Time</td>
<td>Average</td>
<td>10 min.</td>
<td>60 sec.</td>
<td>35 min.</td>
</tr>
<tr>
<td>Fastest</td>
<td>30 sec.</td>
<td>10 sec.</td>
<td>3-5 min.</td>
<td>10 min.</td>
</tr>
<tr>
<td>Full Cure Time</td>
<td>24 hours</td>
<td>24 hours</td>
<td>12-24 hours</td>
<td>24 hours</td>
</tr>
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### Gap Fill

<table>
<thead>
<tr>
<th>Gap Type</th>
<th>Acrylics</th>
<th>Cyanoacrylates</th>
<th>Epoxies</th>
<th>Silicones</th>
</tr>
</thead>
<tbody>
<tr>
<td>Ideal</td>
<td>0.002” - 0.004”</td>
<td>0.001” - 0.003”</td>
<td>0.004” - 0.006”</td>
<td>0.004” - 0.006”</td>
</tr>
<tr>
<td>Maximum</td>
<td>0.040”</td>
<td>0.010”</td>
<td>0.125”</td>
<td>0.240”</td>
</tr>
<tr>
<td>Dispensing/Mixing Equipment Required</td>
<td>No</td>
<td>No</td>
<td>Yes</td>
<td>No</td>
</tr>
<tr>
<td>Light Cure Versions Available?</td>
<td>Yes</td>
<td>Yes</td>
<td>Yes</td>
<td>Yes</td>
</tr>
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</table>

For more information on each Adhesive (Category, refer to pages...)

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<thead>
<tr>
<th>Adhesive</th>
<th>Acrylics</th>
<th>Cyanoacrylates</th>
<th>Epoxies</th>
<th>Silicones</th>
</tr>
</thead>
<tbody>
<tr>
<td>-</td>
<td>3 - 8</td>
<td>15-22</td>
<td>13-14</td>
<td>27-28</td>
</tr>
</tbody>
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Contact Us!

Roger Alvarez
Quality Specialist

Our team is standing by to answer any questions you may have. Use this form to reach out to us and get the answers you need.
**Dissipator®**

**Dissipator® 745**

Dissipator® 745 is a self-leveling or self-shimming thermally conductive adhesive. The leveling action reduces the adhesive to a uniform layer thickness of 0.005 - 0.007" on each application. Gap control assures predictable dissipation of heat.

**Dissipator® 746**

Dissipator® 746 is a specialized acrylic adhesive for bonding heat sensitive components to heat sinks and circuit boards. The Dissipator® 746 offers controlled bond strength to facilitate field service of components. Parts can be removed and/or replaced with relative ease.

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**Fusionbond®**

**Fusionbond®** structural adhesives offer bonds stronger than steel. Fusionbond® is a two-component, methacrylate adhesive that is formulated to bond diverse substrates and offers unparalleled chemical resistance. It is also resistant to fatigue, impact and maintains the ability to fill gaps. Fusionbond® offers shear strength not found in other adhesives. Tests to ASTM D1002 have demonstrated shear strengths over 5000 psi on abraded steel and up to 3660 psi on abraded aluminum. ASTM D4501 standard tests have show strengths up to 1340 psi on epoxy glass. In the same testing, standard PVC failed before Fusionbond® at 2520 psi. Elongation is up to 40% and hardness is up to 80 Shore D.

Fusionbond® excels in bonding various hard-to-bond substrates including phenolics, polycarbonate and blends, polyurethanes, ABS, and PVC. Other bondable substrates include steel, stainless steel, styrenics, titanium, and others. Fusionbond® is resistant to many chemicals including kerosene, hydrocarbon oil, mineral spirits, and ethylene glycol. In testing, Fusionbond® maintained integrity in unleaded gasoline for more than 1000 hours. The temperature range of Fusionbond® is from –55°C to 121°C (-67°F to 250°F).

Fusionbond® is a 1-to-1 ratio, easy to dispense adhesive. It can be dispensed from dual cartridges using a static mixer or larger containers in bigger production applications. The working time is 5 to 10 minutes with a fixture time on received steel in 10 to 15 minutes.

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**Typical Dissipator® Values**

<table>
<thead>
<tr>
<th>Grade</th>
<th>Color</th>
<th>Viscosity</th>
<th>Temperature Range °C (°F)</th>
<th>Fixture Time, Minutes</th>
<th>Shear Strength, N/mm² (psi)</th>
<th>Thermal Conductivity W/m·K</th>
<th>Recommended Activator</th>
</tr>
</thead>
<tbody>
<tr>
<td>745</td>
<td>Blue</td>
<td>Thixotropic Paste</td>
<td>-55 to 150 (-65 to 300)</td>
<td>&lt; 5</td>
<td>&gt; 5.5 (&gt; 800)</td>
<td>0.808</td>
<td>63</td>
</tr>
<tr>
<td>746</td>
<td>White</td>
<td>Thixotropic Paste</td>
<td>-55 to 150 (-65 to 300)</td>
<td>&lt; 5</td>
<td>&gt; 5.5 (&gt; 800)</td>
<td>0.760</td>
<td>63</td>
</tr>
</tbody>
</table>

**Fusionbond® Typical Values**

<table>
<thead>
<tr>
<th>Color</th>
<th>Viscosity, cP</th>
<th>Temp. Range, °C (°F)</th>
<th>Fixture Time, Minutes</th>
<th>Gap Fill, mm (in.)</th>
<th>Shear Strength, N/mm² (psi)</th>
<th>Working Life, Min.</th>
<th>Hardness, Shore D</th>
</tr>
</thead>
<tbody>
<tr>
<td>Grade Part A Part B</td>
<td>Part A Part B</td>
<td>Grade Part A Part B</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>370 White Blue</td>
<td>40,000 to 64,000</td>
<td>40,000 to 64,000</td>
<td>-55 to 121 (-67 to 250)</td>
<td>10 to 15</td>
<td>9.65 (0.38)</td>
<td>≥ 3000</td>
<td>10 to 15</td>
</tr>
<tr>
<td>371 White Off-White</td>
<td>40,000 to 64,000</td>
<td>40,000 to 64,000</td>
<td>-55 to 121 (-67 to 250)</td>
<td>10 to 15</td>
<td>9.65 (0.38)</td>
<td>≥ 3000</td>
<td>15 to 30</td>
</tr>
<tr>
<td>372 White Blue</td>
<td>30,000 to 50,000</td>
<td>30,000 to 50,000</td>
<td>-55 to 121 (-67 to 250)</td>
<td>10 to 12</td>
<td>9.65 (0.38)</td>
<td>≥ 3000</td>
<td>15 to 20</td>
</tr>
<tr>
<td>374 Amber</td>
<td>-</td>
<td>-</td>
<td>-55 to 121 (-67 to 250)</td>
<td>4 to 6</td>
<td>9.65 (0.38)</td>
<td>≥ 3000</td>
<td>4 to 6</td>
</tr>
<tr>
<td>375 Yellow Blue</td>
<td>40,000 to 64,000</td>
<td>40,000 to 64,000</td>
<td>-55 to 121 (-67 to 250)</td>
<td>7 to 10</td>
<td>9.65 (0.38)</td>
<td>≥ 3000</td>
<td>4 to 6</td>
</tr>
<tr>
<td>377 Blue Off-White</td>
<td>150,000 - 250,000</td>
<td>150,000 - 250,000</td>
<td>-40 to 121 (-40 to 250)</td>
<td>-</td>
<td>0.380</td>
<td>≥ 3000</td>
<td>10 to 15</td>
</tr>
<tr>
<td>37784 White Blue</td>
<td>7.000 to 9.000</td>
<td>7.000 to 9.000</td>
<td>-55 to 121 (-67 to 250)</td>
<td>10 to 15</td>
<td>9.65 (0.38)</td>
<td>≥ 3000</td>
<td>5 to 10</td>
</tr>
</tbody>
</table>
Fusionbond® 370 Fusionbond® 370 is a two-component methacrylate adhesive specially formulated for structural bonding of thermoplastics, metal, wood, and composites.

- 100% solid
- Easy mixing ratio of 1:1 by volume
- Almost no surface preparation is needed
- Superior fatigue and impact resistance
- Outstanding environmental resistance
- Exceptional at bonding dissimilar substrates
- Excellent salt spray resistance and gap filling ability

Fusionbond® 371 Fusionbond® 371 bonds to a wide variety of substrates. An excellent choice for composite bonding applications in marine, automotive and construction industries.

- 100% solid
- Easy mixing ratio of 1:1 by volume
- Almost no surface preparation is needed

Fusionbond® 372 Fusionbond® 372 is the strongest structural adhesive available on the market today. It is halogen free and bonds to a wide variety of substrates with extremely high impact and heat resistance.

- Superior impact and peel strength
- Halogen free
- Excellent temperature and chemical resistance
- Bonds to most substrates

Fusionbond® 374 Fusionbond® 374 is a 100% solid, room temperature cure, structural adhesive. This formulation offers high strength bonds with excellent impact, temperature and chemical resistance. The two component, no-mix system allows controlled assembly ideal for production and repair applications. A structural bond develops within minutes.

- Bonds to a large variety of substrates including metals, plastics, composites, ceramics, glass, wood, leather, rubber and marble.
- Halogen Free
- Minimal or no surface preparation.

Recommended Dispensing Equipment For Fusionbond®

- Autobonder® 2700
- Autobonder® 2040
- Manual and Pneumatic Guns

Fusionbond® 375 Fusionbond® 375 is formulated for bonding PVC, acrylic, ABS, stainless steel, and some type of fiberglass. Fusionbond® 375 fixtures quickly in 7 to 10 minutes at room temperature to form a resilient and high-strength bond.

- Non-sagging gaps filled to 0.375 inch
- Superior impact and peel strength
- Rapid room temperature cure

Fusionbond® 377 Fusionbond® 377 is a non-sag, two-component methacrylate adhesive specially formulated for structural bonding of thermoplastics, wood and composite assemblies. An excellent choice for composite bonding applications in the marine, automotive and construction industries because it requires virtually no surface preparation.

- Superior fatigue and impact resistance
- Superior toughness at temps -40 to 250°F
- Outstanding environmental resistance

Fusionbond® 378 Fusionbond® 378 is a highly thixotropic, two component, room temperature curing, 1:1 ratio, methacrylate adhesive system. Fusionbond® 378 is formulated to provide fixture strength within 12 to 15 minutes. This adhesive forms resilient bonds and maintains its strength over a wide range of temperatures. Fusionbond® 378 is suitable for bonding a variety of substrates with a minimum of surface preparation.

- Contains glass beads to control bond-line thickness
- Superior shear and impact strength
- Excellent strength at bonding dissimilar substrates including anodized and galvanized metals
- Non-sagging gaps filled to 0.375 inch
- Maintains strength from -40°F to +220°F

Fusionbond® 37784 Fusionbond® 37784 offers a lower viscosity and is specially formulated for structural bonding of thermoplastics, metal, wood and composite assemblies. Fusionbond® 37784 requires virtually no surface preparation.

- Outstanding environmental resistance
- Exceptional at bonding dissimilar substrates
- Excellent salt spray resistance and gap filling ability
- Dramatically reduces assembly cost

Click a product name to see the TDS and SDS on the Hernon Website

Fusionbond® 374
Fusionbond® 375
Fusionbond® 377
Fusionbond® 378
Fusionbond® 37784

Applications:

- Bonding ferrite to plated metals in electric motors and loud speakers.
- Bonding rearview mirror mounting button to glass.
- Where fast setting of adhesives with high structural properties is required.

HASA® 714
HASA® 714 is a single component structural anaerobic adhesive formulated for bonding rigid assemblies. HASA® 714 cures when it is confined between mating surfaces. Primer 56 accelerates the cure.

Applications:

- Bonding ferrite to plated metals in electric motors and loud speakers.
- Bonding of glass and ceramics.
- Where fast setting of adhesives with high structural properties is required.

HASA® 722
HASA® 722 is a single-component, anaerobic, structural adhesive designed for bonding rigid assemblies. HASA® 722 has highly cross-linked structural thermoset plastics with excellent properties over a broad range of operational conditions.

Applications:

- Bonding ferrite to plated metals in electric motors and loud speakers.
- Bonding of glass and ceramics.
- Where fast setting of adhesives with high structural properties is required.

H.A.S.A. (Historically Anaerobic Structural Adhesive)

HASA® offers a complete line of structural anaerobics, the HASA (H.A.S.A. Anaerobic Structural Adhesive) line of products. These adhesives are 100% active, single component adhesives that cure upon exclusion of air. HASA® adhesives have been highly engineered to meet specific design criteria combining high tensile, impact, temperature and peel strengths for specific assembly requirements. HASA® materials have excellent gap filling abilities (up to 0.040”) and offer temperature stability (to 350°F). They are easily dispensed bonding agents which will ultimately reduce assembly time and related costs for your structural bonding needs. Cure is accomplished by applying HASA® between mating surfaces including metals, glass, ceramics, thermoset plastics and filled thermoplastics. Use surface primers to achieve fast fixtureing times and high production rates. Cured HASA® materials are highly cross-linked structural thermoset plastics with excellent properties over a wide range of conditions.

Applications:

- Bonding ferrite to plated metals in electric motors and loud speakers.
- Bonding of glass and ceramics.
- Where fast setting of adhesives with high structural properties is required.

HASA® 66071
HASA® 66071 is a single component structural anaerobic adhesive formulated for bonding rigid assemblies at high temperatures. HASA® 66071 cures when it is confined between mating surfaces. Primer 50 accelerates the cure.

Applications:

- Bonding ferrite to plated metals in electric motors and loud speakers.
- Bonding of glass and ceramics.
- Where fast setting of adhesives with high structural properties is required.
**H.A.S.A. Benefits**

- Increased Profitability: Lower Costs, Design Efficiency
- Anaerobically Cured
- Lower Cost than mechanical assembly.
- Lower Energy Cost – parts bond at room temperature.
- Superior Reliability – assembly integrity assured.

**Recommended Dispensing Equipment For H.A.S.A.**

- HERNON® offers a complete line of semi and fully automated dispensing equipment. Contact HERNON® Sales for additional information. www.hernon-equipment.com

**H.A.S.A. Typical Values**

<table>
<thead>
<tr>
<th>Grade</th>
<th>Viscosity cP</th>
<th>Temp. Range, °C (°F)</th>
<th>Fixture Time at 22°C</th>
<th>Gap Fill, mm (in.)</th>
<th>Shear Strength, N/mm² (psi)</th>
<th>Recommended Primer / Activator</th>
</tr>
</thead>
<tbody>
<tr>
<td>714</td>
<td>Amber 1, 100</td>
<td>-55 to 121 (-65 to 400)</td>
<td>30</td>
<td>0.003</td>
<td>&gt;10.0 (&gt;1450)</td>
<td>Primer 56</td>
</tr>
<tr>
<td>716</td>
<td>Amber 2, 800</td>
<td>-55 to 121 (-65 to 250)</td>
<td>30 seconds</td>
<td>0.381 (0.015)</td>
<td>&gt;10.3 (&gt;1500)</td>
<td>Primer 50</td>
</tr>
<tr>
<td>722</td>
<td>Amber 10,000</td>
<td>-55 to 105 (-65 to 221)</td>
<td>30 seconds</td>
<td>0.508 (0.020)</td>
<td>&gt;10.3 (&gt;1500)</td>
<td>Primer 50</td>
</tr>
<tr>
<td>66071</td>
<td>Amber 16,000</td>
<td>-55 to 121 (-65 to 240)</td>
<td>20 seconds</td>
<td>0.381 (0.015)</td>
<td>&gt;10.3 (&gt;1500)</td>
<td>Primer 50</td>
</tr>
</tbody>
</table>

**ReAct® 727**

ReAct® 727 is a structural acrylic designed to bond magnets, ferrites, plastic and metal wear strips as well as metals with special surface treatments such as galvanized, phosphate and dichromate surfaces.

- (Amber Liquid)
- Fast Fixture Times
- High Temperature
- High Impact & Peel

**ReAct® 730**

ReAct® 730 is a general-purpose structural acrylic designed to bond porous and non-porous surfaces in applications subject to bending and flexing. Use 730 to bond: plastic, metal, cardboard, ceramic, concrete, cork, fabric, fiberglass, glass, leather, marble, nylon, particle board, phenolic, polycarbonate, wood, vinyl, and more.

- (Pale Yellow Liquid)
- Quick Fixture Times
- High Strength
- High Impact & Peel
- General Purpose

**Applications:**

- Fuel pump parts
- Speaker magnets to housings and frames
- Wood, metal and plastic signs to concrete
- Composites like graphite fibers, honeycomb
- Glass and metal combinations: greenhouses, solar collectors, etc.
- Aluminum decorative trim

**ReAct® 766**

Excellent adhesion to a variety of surfaces ReAct® 766 is formulated to bond permanent magnets and a wide variety of other substrates. ReAct® 766 demonstrates excellent impact and peel resistance which results in tough, durable structural bonds. Temperature resistance is from –40°F (-40°C) to 400°F (204°C).

- (Clear-Yellow Liquid)
- High impact and shock resistance
- Good gap filling capabilities
- High temperature resistance

**ReAct® Benefits**

- No-Mix, Single-Component for Production Ease
- On-Demand Cure When Parts Assembled
- Allows Preparation of Parts in Production Environment
- Superior Reliability and Strength

**ReAct® 761**

ReAct® 761 is a fast curing high viscosity structural acrylic adhesive with extended high temperature performance to 400°F. Excellent choice for parts subjected to paint bake cycles after assembly. ReAct® 761 is an ideal production line adhesive providing quick cures on glass, metal and thermoplastics. It can reach handling strengths within 180 seconds of mating parts with Activator 63.

Quicker fixturing can be obtained with closer part tolerances and smaller gaps. Faster fixturing reduces in-process “float” times with shorter clamping and fixturing phases. This product delivers the highest tensile shear strength and excellent impact resistance.

**Applications:**

- Firearm parts, grips
- Magnets for motors
- Speaker magnets
- Utensil handles, grips

- Fuel pump parts
- Speaker magnets to housings and frames
- Wood, metal and plastic signs to concrete
- Composites like graphite fibers, honeycomb
- Glass and metal combinations: greenhouses, solar collectors, etc.
- Aluminum decorative trim

**Recommended Dispensing Equipment For HASA®**

- HERNON® offers a complete line of semi and fully automated dispensing equipment. Contact HERNON® Sales for additional information. www.hernon-equipment.com
Heron Manufacturing has taken the excellent bond strength of Fusionbond® structural adhesive and merged it with the simplicity of ReAct® two-component, no-mix curing system to create ReAct® 784. ReAct® 784 is a 100% solid system, room temperature cure, versatile structural adhesive. This formulation will offer rapid, high strength and high impact resistant bonds to a variety of substrates within minutes.

- (White Liquid)
- Bonds to an exceptionally large variety of substrates including metals, plastics, composites, ceramics, glass, wood, leather, rubber and marble
- Convenient two-component, no-mix system for rapid production applications
- Minimal or no surface preparation
- 100% solid system

**Recommended Dispensing Equipment For ReAct®**
- Autobonder® 2101
- Autobonder® 2111
- Autobonder® 2512
- Manual and Pneumatic Guns

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**ReAct® 767**

ReAct® 767 is a high performance tough acrylic adhesive designed primarily for securing ceramic permanent magnet segments in motor magnet bonding applications. Used in conjunction with Activator 56, this structural adhesive is ideal for choke and transformer bonding, DC motor assembly, alternator and fly wheel applications, tacking, unitizing, ruggedizing, sealing and shallow potting. ReAct® 767 fixtures in seconds, is acrylic acid free and non-corrosive, non-flammable, and suitable for harsh environments. ReAct® 767 exhibits good thermal shock, impact and peel resistance characteristics, and excellent adhesion to a wide variety of plated surfaces.

- Excellent adhesion to a wide variety of plated surfaces.
- Shock, impact and peel resistance characteristics, and
- Bonding metals with special surface treatments such as galvanized, phosphate and dichromate surfaces.
- DC motor assembly.
- Magnet bonding.
- Bonding pre-coated sheet metal.
- Bonding ferrites, plastic, and metal wear strips.
- Bonding metals with special surface treatments such as galvanized, phosphate and dichromate surfaces.

**Applications**

- Bonding metals with special surface treatments such as galvanized, phosphate and dichromate surfaces.
- Tack, unitizing, ruggedizing, sealing and shallow potting.
- Motor assembly, alternator and fly wheel applications.
- Tack, unitizing, ruggedizing, sealing and shallow potting.
- DC motor assembly.
- Alternator and fly wheel applications.
- Tack, unitizing, ruggedizing, sealing and shallow potting.
- DC motor assembly.
- Alternator and fly wheel applications.
- Tack, unitizing, ruggedizing, sealing and shallow potting.
- DC motor assembly.
- Alternator and fly wheel applications.

**ReAct® 784**

ReAct® 784 is a high performance tough acrylic adhesive designed primarily for securing ceramic permanent magnet segments in motor magnet bonding applications. Used in conjunction with Activator 56, this structural adhesive is ideal for choke and transformer bonding, DC motor assembly, alternator and fly wheel applications, tacking, unitizing, ruggedizing, sealing and shallow potting. ReAct® 767 fixtures in seconds, is acrylic acid free and non-corrosive, non-flammable, and suitable for harsh environments. ReAct® 767 exhibits good thermal shock, impact and peel resistance characteristics, and excellent adhesion to a wide variety of plated surfaces.

- Excellent adhesion to a wide variety of plated surfaces.
- Shock, impact and peel resistance characteristics, and
- Bonding metals with special surface treatments such as galvanized, phosphate and dichromate surfaces.
- DC motor assembly.
- Magnet bonding.
- Bonding pre-coated sheet metal.
- Bonding ferrites, plastic, and metal wear strips.
- Bonding metals with special surface treatments such as galvanized, phosphate and dichromate surfaces.

**Applications**

- Bonding metals with special surface treatments such as galvanized, phosphate and dichromate surfaces.
- Tack, unitizing, ruggedizing, sealing and shallow potting.
- Motor assembly, alternator and fly wheel applications.
- Tack, unitizing, ruggedizing, sealing and shallow potting.
- DC motor assembly.
- Alternator and fly wheel applications.
- Tack, unitizing, ruggedizing, sealing and shallow potting.
- DC motor assembly.
- Alternator and fly wheel applications.
- Tack, unitizing, ruggedizing, sealing and shallow potting.
- DC motor assembly.
- Alternator and fly wheel applications.

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**Supertacker® 351**

Supertacker® 351 is a single component, high performance elastomeric adhesive that exhibits exceptional bonding characteristics to a broad range of materials including metals, glass, plastic composites, rubber, leather, wood and vinyl. Supertacker® 351 out-performs silicones, acrylics and rubber cement because it bonds to more surfaces with greater strength and durability.

- (Clear Liquid)
- Exceptional flexibility – Does not become brittle in cold weather, can bond items subject to vibration.
- Waterproof
- Abrasion resistance
- Non-flammable
- Paintable
- Excellent resistance to dilute acids and dilute caustics

**Supertacker® 352**

Supertacker® 352 is a singlecomponent, high performance elastomeric adhesive for bonding metals, glass, plastic composites, rubber, leather, wood and vinyl. Supertacker® 352 will form a waterproof bond that will not crack or become brittle.

- (Black Liquid)
- Viscosity 50,000 cP
- Exceptional flexibility – Does not become brittle in cold weather, can bond items subject to wear.
- Waterproof
- Abrasion resistance
- Non-flammable
- Paintable
- Excellent resistance to dilute acids and dilute caustics

---

**Supertacker® Typical Values**

<table>
<thead>
<tr>
<th>Grade</th>
<th>Color</th>
<th>Viscosity, cP</th>
<th>Temperature Range, Continuous, °C (°F)</th>
<th>Tack Free Time/ Full Cure at 75°F</th>
<th>Hardness, Shore A</th>
<th>% Elongation</th>
</tr>
</thead>
<tbody>
<tr>
<td>351</td>
<td>Clear</td>
<td>50,000</td>
<td>-40 to 150 (-40 to 300)</td>
<td>5 minutes / 24 hours</td>
<td>80</td>
<td>900</td>
</tr>
<tr>
<td>352</td>
<td>Black</td>
<td>50,000</td>
<td>-40 to 150 (-40 to 300)</td>
<td>5 minutes / 24 hours</td>
<td>80</td>
<td>900</td>
</tr>
<tr>
<td>353</td>
<td>Clear</td>
<td>110,000</td>
<td>-40 to 150 (-40 to 300)</td>
<td>5 minutes / 24 hours</td>
<td>80</td>
<td>900</td>
</tr>
<tr>
<td>357</td>
<td>Clear</td>
<td>100,000</td>
<td>-40 to 150 (-40 to 300)</td>
<td>5 minutes / 24 hours</td>
<td>80</td>
<td>900</td>
</tr>
</tbody>
</table>

---

**ReAct® Typical Values**

<table>
<thead>
<tr>
<th>Grade</th>
<th>Color</th>
<th>Viscosity</th>
<th>Temperature Range at 22°C</th>
<th>Fixture Time</th>
<th>Gap Fill (mm.)</th>
<th>Recommended Primer / Activator</th>
</tr>
</thead>
<tbody>
<tr>
<td>727</td>
<td>Off-White</td>
<td>55,000 to 65,000</td>
<td>-40 to 149 (-40 to 300)</td>
<td>25 seconds</td>
<td>0.508 (0.020)</td>
<td>Activator 56</td>
</tr>
<tr>
<td>730</td>
<td>Light yellow</td>
<td>45,000 to 90,000</td>
<td>-51 to 121 (-60 to 250)</td>
<td>3 minutes</td>
<td>0.762 (0.030)</td>
<td>Activator 56 or 59</td>
</tr>
<tr>
<td>761</td>
<td>Pale yellow</td>
<td>75,000 to 130,000</td>
<td>-40 to 204 (-40 to 400)</td>
<td>3 minutes</td>
<td>0.508 (0.020)</td>
<td>Activator 59 or 63</td>
</tr>
<tr>
<td>766</td>
<td>Clear-yellow</td>
<td>70,000 to 90,000</td>
<td>-40 to 204 (-40 to 400)</td>
<td>3 minutes</td>
<td>0.508 (0.020)</td>
<td>Activator 59 or 63</td>
</tr>
<tr>
<td>767</td>
<td>Off-White</td>
<td>50,000 to 70,000</td>
<td>-40 to 149 (-40 to 300)</td>
<td>25 seconds</td>
<td>0.508 (0.020)</td>
<td>Activator 56</td>
</tr>
<tr>
<td>784</td>
<td>White</td>
<td>40,000 to 64,000</td>
<td>-55 to 121 (-65 to 250)</td>
<td>3 minutes</td>
<td>0.508 (0.020)</td>
<td>Activator 15</td>
</tr>
</tbody>
</table>
**Supertacker® 357**

Supertacker® 357 is a single component, high performance elastomeric adhesive for bonding metals, glass, plastic composites, rubber, leather, wood, and vinyl. Supertacker® 357 provides a tough, waterproof bond that won’t crack or become brittle. Supertacker® 357 out-performs silicones, acrylics and rubber cement because it bonds to more surfaces with greater strength and durability.

- (Clear Liquid)
- Viscosity 100,000 cP
- Exceptional flexibility – Does not become brittle in cold weather, can bond items subject to vibration
- Waterproof – Can be submerged in fresh and salt water after complete cure
- Abrasion resistance – Great for bonding objects subject to wear
- Non-flammable
- Paintable – Paint to match surrounding area or make UV-resistant
- Excellent resistance to dilute acids and dilute caustics

**Tuffbond® 302**

Tuffbond® 302 is a modified epoxy adhesive that provides a very fast room temperature cure. Tuffbond® 302 exhibits very good moisture, chemical and heat resistance. This very fast cure epoxy adhesive is specially formulated for rapid in-line assembly of loud speakers. Tuffbond® 302 is also recommended for bonding metals, wood, ceramics, etc., and can be used for potting and encapsulation of electrical and electronic components.

- Fast at room temperature (about 4 minutes)
- Low shrinkage
- 100% reactive, non-solvent system
- Easy mixing ratio of resin and hardener
- No fuming on gelation

**Recommended Dispensing Equipment For Supertacker®**

- Autobonder® 2101
- Autobonder® 2111
- Manual and Pneumatic Guns

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**Tuffbond® 313**

Tuffbond® 313 is a two component, one-to-one mix ratio adhesive system. Tuffbond® 313 is a 100% solid adhesive that cures at room temperature. The working time of a 100 gram mass is 40 to 60 minutes. Tensile Strength is up to 7100 psi according to ASTM D638 testing. Hardness is 70 Shore D. Temperature resistance is from –65°F (-53°C) to 300°F (149°C).

**Tuffbond® 314**

Tuffbond® 314 is a flexible and resilient two-part epoxy adhesive system. Due to its versatile and convenient working characteristics, it should be considered for any room temperature curing application where elevated temperature curing cycles can be used. By changing the ratio of resin and hardener, the cured adhesive can change from a tough and flexible to a hard and rigid system.

Tuffbond® 314 is recommended for bonding metal, glass, wood, concrete and rubber and can be used for potting and encapsulation of electrical and electronic components.
**Tuffbond® 315**

Tuffbond® 315 is a modified epoxy adhesive that provides a fast room temperature cure. Tuffbond® 315 exhibits very good moisture chemical and heat resistance. This fast cure epoxy adhesive is specially formulated for rapid in-line assembly of loud speakers. Tuffbond® 315 is also recommended for bonding metals, wood, ceramics, etc., and can be used for potting and encapsulation of electrical and electronic components.

**Tuffbond® 316**

Tuffbond® 316 is a two component, variable-ratio adhesive. The mix ratio can be adjusted from a tough and flexible adhesive to a hard and rigid adhesive. The working time of a 100 gram mass is 8 to 100 minutes. Temperature resistance is from –65°F (-54°C) to 275°F (135°C). Tuffbond® 316 offers shear strength up to 2300 psi.

**Tuffbond® 317**

Tuffbond® 317 is a two component room temperature cure system. By changing the ratio of resin and hardener the cured adhesive can change from a tough and flexible to a hard and rigid system. Tuffbond® 317 is recommended for bonding metal glass, wood, concrete and rubber and can be used for potting and encapsulation of electrical and electronic components.

**Tuffbond® 321**

Tuffbond® 321 is a flexible, low viscosity, general purpose resin system used for casting, potting and encapsulating of electrical and electronic components. This unique product has been formulated to combine ease in handling with optimum physical, thermal and electrical insulation properties.

- Clear and flexible
- Room temperature or heat curing

**Tuffbond® 322**

Tuffbond® 322 is a transparent 1:1 flexible, low viscosity, general purpose resin system used for casting, potting and encapsulating of electrical and electronic components. This unique product has been formulated to combine ease in handling with optimum physical, thermal and electrical insulation properties.

**Tuffbond® 394**

Tuffbond® 394 is a single component, high temperature resistant, heat activated epoxy. It cures to a high performance thermoset system with excellent adhesion properties to a wide variety of substrates. The rapid curing mechanism of 1.5 minutes at a bondline temperature of 150°C makes it ideal for production line use. Tuffbond® 394 will change from amber-yellow to a reddish brown upon cure.

**Tuffbond® 395**

Tuffbond® 395 is a single component, high temperature resistant, heat activated epoxy. It cures to a high performance thermoset system with excellent adhesion properties to a wide variety of substrates. The rapid curing mechanism of 1.5 minutes at a bondline temperature of 150°C makes it ideal for production line use. Tuffbond® 395 will change from amber-yellow to a reddish brown upon cure.

**Tuffbond® 3661**

Tuffbond® 3661 is a unique room temperature curing, two-component epoxy adhesive for high temperature bonding and potting applications. It is formulated to cure at room temperature, with a convenient mixing ratio of 1:1. Tuffbond® 3661 produces high strength bonds whose strength is maintained even after long exposure to temperatures in the 250° to 300°F range. The hardened adhesive is electrically insulating and heat conductive.

- Bonding drain valves, wastewater treatment valves
- Thermal shock and chemical resistance
- Versatile cure schedules, ambient temperature cure or fast-elevated temperature cure as required.

**Tuffbond® 23932**

Tuffbond® 23932 is a modified epoxy adhesive that provides a slow room temperature cure. Tuffbond® 23932 exhibits very good chemical and water resistance. This epoxy adhesive is formulated for multiplexes uses. Tuffbond® 23932 is recommended for bonding metals, rubber, wood, ceramics, etc., and can be used for potting and encapsulation of components.

- No fuming on gelation
- Excellent chemical resistance
- Excellent water resistance

**Tuffbond® 47771**

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

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

**Recommended Dispensing Equipment For Tuffbond®**

- Autobonder® 2700
- Manual and Pneumatic Guns

### Heat Cure Tuffbond® Typical Values

<table>
<thead>
<tr>
<th>Grade</th>
<th>Color</th>
<th>Viscosity cP</th>
<th>Temperature Range, °C (°F)</th>
<th>Optimum Cure</th>
<th>Shear Strength, N/mm² (psi)</th>
</tr>
</thead>
<tbody>
<tr>
<td>309</td>
<td>Black</td>
<td>245,000</td>
<td>-64 to 177 (-65 to 350)</td>
<td>10 to 12 minutes at 149°C</td>
<td>11.7 (1700)</td>
</tr>
</tbody>
</table>

### Two-Part Tuffbond® Typical Values

<table>
<thead>
<tr>
<th>Grade</th>
<th>Color</th>
<th>Viscosity cP</th>
<th>Temperature Range, °C (°F)</th>
<th>Working Life (100°C), Minutes</th>
<th>Hardness, Shore D</th>
<th>Shear Strength, N/mm² (psi)</th>
</tr>
</thead>
<tbody>
<tr>
<td>302A</td>
<td>Clear</td>
<td>50,000</td>
<td>-54 to 82 (-65 to 180)</td>
<td>3</td>
<td>86</td>
<td>16.8 (2400)</td>
</tr>
<tr>
<td>302B</td>
<td>Light Amber</td>
<td>50,000</td>
<td>-54 to 82 (-65 to 180)</td>
<td>3</td>
<td>86</td>
<td>16.8 (2400)</td>
</tr>
<tr>
<td>305A</td>
<td>Clear</td>
<td>15,000</td>
<td>-54 to 82 (-65 to 180)</td>
<td>3</td>
<td>86</td>
<td>16.8 (2400)</td>
</tr>
<tr>
<td>305B</td>
<td>Yellow</td>
<td>15,000</td>
<td>-54 to 82 (-65 to 180)</td>
<td>3</td>
<td>86</td>
<td>16.8 (2400)</td>
</tr>
<tr>
<td>313A</td>
<td>Clear</td>
<td>21,500</td>
<td>-54 to 149 (-65 to 300)</td>
<td>50</td>
<td>79</td>
<td>22.1 (3200)</td>
</tr>
<tr>
<td>313B</td>
<td>Amber</td>
<td>21,500</td>
<td>-54 to 149 (-65 to 300)</td>
<td>50</td>
<td>79</td>
<td>22.1 (3200)</td>
</tr>
<tr>
<td>315A</td>
<td>Clear</td>
<td>13,000,000</td>
<td>-54 to 135 (-65 to 275)</td>
<td>15</td>
<td>75</td>
<td>&gt;13.78 (&gt;2000)</td>
</tr>
<tr>
<td>315B</td>
<td>Yellow</td>
<td>13,000,000</td>
<td>-54 to 135 (-65 to 275)</td>
<td>15</td>
<td>75</td>
<td>&gt;13.78 (&gt;2000)</td>
</tr>
<tr>
<td>316A</td>
<td>Black</td>
<td>12,000</td>
<td>-54 to 135 (-65 to 275)</td>
<td>90</td>
<td>82</td>
<td>15.9 (2300)</td>
</tr>
<tr>
<td>316B</td>
<td>Amber</td>
<td>10,000</td>
<td>-54 to 135 (-65 to 275)</td>
<td>90</td>
<td>82</td>
<td>15.9 (2300)</td>
</tr>
<tr>
<td>317A</td>
<td>Clear</td>
<td>12,000</td>
<td>-54 to 135 (-65 to 275)</td>
<td>90</td>
<td>82</td>
<td>15.9 (2300)</td>
</tr>
<tr>
<td>317B</td>
<td>Amber</td>
<td>10,000</td>
<td>-54 to 135 (-65 to 275)</td>
<td>90</td>
<td>82</td>
<td>15.9 (2300)</td>
</tr>
<tr>
<td>321A</td>
<td>Clear</td>
<td>11,000-16,000</td>
<td>-51 to 121 (-60 to 250)</td>
<td>120-180</td>
<td></td>
<td></td>
</tr>
<tr>
<td>321B</td>
<td>Clear</td>
<td>10,000-16,000</td>
<td>-51 to 121 (-60 to 250)</td>
<td>120-180</td>
<td></td>
<td></td>
</tr>
<tr>
<td>322A</td>
<td>Lt. Yellow</td>
<td>10,000-16,000</td>
<td>-51 to 121 (-60 to 250)</td>
<td>180-240</td>
<td></td>
<td></td>
</tr>
<tr>
<td>322B</td>
<td>Pale Yellow</td>
<td>12,000-18,000</td>
<td>-51 to 121 (-60 to 250)</td>
<td>180-240</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

**Two-Part Tuffbond®**

- Manual and Pneumatic Guns
- Autobonder® 2700
- Autobonder® 2404
- Autobonder® 2220
- Autobonder® 3661

**Tuffbond® 23932**

Tuffbond® 23932 is a modified epoxy adhesive that provides a slow room temperature cure. Tuffbond® 23932 exhibits very good chemical and water resistance. This epoxy adhesive is formulated for multiplexes uses. Tuffbond® 23932 is recommended for bonding metals, rubber, wood, ceramics, etc., and can be used for potting and encapsulation of components.

- No fuming on gelation
- Excellent chemical resistance
- Excellent water resistance

**Heat Cure Tuffbond® Typical Values**

<table>
<thead>
<tr>
<th>Grade</th>
<th>Color</th>
<th>Viscosity cP</th>
<th>Temperature Range, °C (°F)</th>
<th>Optimum Cure</th>
<th>Shear Strength, N/mm² (psi)</th>
</tr>
</thead>
<tbody>
<tr>
<td>309</td>
<td>Black</td>
<td>245,000</td>
<td>-64 to 177 (-65 to 350)</td>
<td>10 to 12 minutes at 149°C</td>
<td>11.7 (1700)</td>
</tr>
</tbody>
</table>

**Tuffbond® 322**

Tuffbond® 322 is a transparent 1:1 flexible, low viscosity, general purpose resin system used for casting, potting and encapsulating of electrical and electronic components. This unique product has been formulated to combine ease in handling with optimum physical, thermal and electrical insulation properties.
Instantbond® is a state-of-the-art family of cyanoacrylate adhesives that provide instant bonding on a wide variety of surfaces. Instantbond® cyanoacrylates are single component, solventless and cure at room temperature when pressed into a thin film between parts. The presence of surface moisture commences the cure of the adhesive.

Hernon® offers classic ethyl and methyl variations along with special toughened / flexible, surface insensitive, low-orde, low-blooming and oil tolerant formulations. Viscosities range from very low to gel consistency and provide outstanding chemical and thermal resistance.

Instantbond® cyanoacrylates can bond an extremely wide variety of substrates including metals, thermoplastics, elastomers, ceramics, leather, cork and more. Notwithstanding the superior bonding capabilities of Instantbons, they are typically not recommended for long term glass to glass bonding applications.

Features:
- Multiple viscosities and curing times to choose from
- Specialty formulas for surface insensitive applications available
- Many MIL-SPEC grades available
- One drop is typically sufficient for bonding approximately one square inch of surface area
- Most grades are available in a variety of sizes ranging from 1oz to 2kg
- Thixotropic Gel
- Non-Migrating Gel
- High Temperature
- Maximum Gap Fill
- Gel formulation with heat resistance to 225°F
- Specially formulated for hard to bond plastics like vinyl, EPDM, and urethane.
- Viscosity 40cP
- Low Viscosity
- General Purpose
- This grade offers extra gap filling ability along with a very slow cure action. Well suited for bonding open cell foams (rubber, urethane), natural sponge, porous ceramics, insulators.
- Viscosity 1,500cP
- High Viscosity
- Slow Setting
- Porous Materials

Typical Applications:
- Plastic and metal combinations
- Electronic components
- Toys, sporting goods
- Components of oem packaging
- Speaker sub assembly
- Cell termination
- Attachment of rubber fast, grommets, and bumpers
- Permanent locking of plastic fasteners
- Attachment of weather stripping, air seals

Instantbond® 109
A general-purpose grade with .005” gap filling capabilities. Apply to one surface and then mate parts. Provides quick fixturing times.
- Viscosity 100cP
- Medium Viscosity
- General Bonding

Instantbond® 110
A general-purpose grade with .005” gap filling capabilities. Apply to one surface and then mate parts. Provides quick fixturing times.
- Viscosity 100cP
- Medium Viscosity
- General Bonding

Instantbond® 112
Used to penetrate into bond line between clamped or fixtured metal parts. Water thin viscosity adhesive is drawn into joint by capillarity. Very fast tacking action.
- Viscosity 5cP
- Very Low Viscosity
- Fast Fixturing
- “Wicking” Action

Instantbond® 113
This thin liquid is suitable for close tolerance bonding of a wide variety of materials.
- Viscosity 40cP
- Low Viscosity
- General Purpose

Instantbond® 117
This grade offers extra gap filling ability along with a very slow cure action. Well suited for bonding open cell foams (rubber, urethane), natural sponge, porous ceramics, insulators.
- Viscosity 1,500cP
- High Viscosity
- Slow Setting
- Porous Materials

Instantbond® 119
Water thin viscosity permits this grade to penetrate into tightly fitting or clamped parts by capillary action.
- Viscosity 5cP
- Very Low Viscosity
- Fast Fixturing
- “Wicking Action”

Instantbond® 121
Provides gap-filling ability to .010”. This thick liquid with slower fixturing allows extra time for alignment of parts.
- Viscosity 2,500cP
- High Viscosity
- Slow Cure

Instantbond® 122
Thixotropic Gel
- Non-Migrating Gel
- High Temperature
- Maximum Gap Fill
- Gel formulation with heat resistance to 225°F

Instantbond® 123
Specially formulated for hard to bond plastics like vinyl, EPDM, and urethane.
- Viscosity 110cP
- Moderate Viscosity
- Hard to Bond Plastics

Instantbond® 127
A general-purpose gel formulation that stays where applied without migration. Use on rubber, metal, plastics.
- Thixotropic Gel
- Non-Migrating Gel
- General Purpose
- Maximum Gap Fill
**Instantbond® 66793**

Instantbond® 66793 is a very high viscosity, state-of-the-art, single component, solventless, room temperature curing cyanoacrylate adhesive that polymerizes rapidly when pressed into a thin film between parts.

- **Rapid Cure** - forms a strong bond at room temperature in less than a minute with contact pressure.
- **Surfaces** - will bond almost any combination of similar or dissimilar materials.
- **Easy Use** - single component feature, eliminates any mixing.

**HERNON®** offers a very complete selection of cyanoacrylate adhesives. Two different categories are offered: **Instantbond & Quantum®**. The Instantbond grades offer “classic” performance, while the Quantum® grades deliver “special” or “advanced” performance. The differences between the two categories are the result of formulation, modification, and molecular engineering.

<p>| Approximate Number of Free-Fall Drops per milliliter from Standard Packaging |
|-----------------------------|-------------------|----------------|</p>
<table>
<thead>
<tr>
<th>Viscosity (cP)</th>
<th>Drops/mL</th>
<th>Drops/lb.</th>
</tr>
</thead>
<tbody>
<tr>
<td>1-100</td>
<td>100</td>
<td>42,800</td>
</tr>
<tr>
<td>100-1,000</td>
<td>70</td>
<td>29,960</td>
</tr>
<tr>
<td>1,000-5,000</td>
<td>50</td>
<td>21,400</td>
</tr>
<tr>
<td>5,000-10,000</td>
<td>30</td>
<td>12,840</td>
</tr>
</tbody>
</table>

**Instantbond Typical Values**

<table>
<thead>
<tr>
<th>Grade</th>
<th>Color</th>
<th>Viscosity cP</th>
<th>Temperature Range, °C (°F)</th>
<th>Fixture Time at 22°C, Seconds</th>
<th>Shear Strength, N/mm² (psi)</th>
<th>Gap Fill min (in.)</th>
<th>Resin Base</th>
</tr>
</thead>
<tbody>
<tr>
<td>109</td>
<td>Clear</td>
<td>12</td>
<td>-55 to 82 (-65 to 180)</td>
<td>10 to 20</td>
<td>13.8 (2000)</td>
<td>0.102 (0.004)</td>
<td>Ethyl</td>
</tr>
<tr>
<td>110</td>
<td>Clear</td>
<td>100</td>
<td>-55 to 82 (-65 to 180)</td>
<td>20 to 40</td>
<td>25.2 (3650)</td>
<td>0.127 (0.005)</td>
<td>Methyl</td>
</tr>
<tr>
<td>112</td>
<td>Clear</td>
<td>5</td>
<td>-55 to 82 (-65 to 180)</td>
<td>20 to 40</td>
<td>25.2 (3650)</td>
<td>0.050 (0.002)</td>
<td>Ethyl</td>
</tr>
<tr>
<td>113</td>
<td>Clear</td>
<td>40</td>
<td>-55 to 82 (-65 to 180)</td>
<td>10 to 30</td>
<td>19.1 (2775)</td>
<td>0.102 (0.004)</td>
<td>Ethyl</td>
</tr>
<tr>
<td>117</td>
<td>Clear</td>
<td>1500</td>
<td>-55 to 82 (-65 to 180)</td>
<td>20 to 50</td>
<td>22.1 (3200)</td>
<td>0.203 (0.008)</td>
<td>Ethyl</td>
</tr>
<tr>
<td>119</td>
<td>Clear</td>
<td>5</td>
<td>-55 to 82 (-65 to 180)</td>
<td>10 to 30</td>
<td>20.7 (3000)</td>
<td>0.050 (0.002)</td>
<td>Ethyl</td>
</tr>
<tr>
<td>121</td>
<td>Clear</td>
<td>2500</td>
<td>-55 to 82 (-65 to 180)</td>
<td>20 to 50</td>
<td>22.1 (3200)</td>
<td>0.203 (0.008)</td>
<td>Ethyl</td>
</tr>
<tr>
<td>122</td>
<td>Clear</td>
<td>Gel</td>
<td>-55 to 82 (-65 to 180)</td>
<td>50 to 100</td>
<td>22.1 (3200)</td>
<td>0.254 (0.010)</td>
<td>Ethyl</td>
</tr>
<tr>
<td>123</td>
<td>Clear</td>
<td>110</td>
<td>-55 to 82 (-65 to 180)</td>
<td>15 to 30</td>
<td>22.1 (3200)</td>
<td>0.152 (0.006)</td>
<td>Ethyl</td>
</tr>
<tr>
<td>127</td>
<td>Clear</td>
<td>Gel</td>
<td>-55 to 82 (-65 to 180)</td>
<td>50 to 100</td>
<td>22.1 (3200)</td>
<td>0.254 (0.010)</td>
<td>Ethyl</td>
</tr>
<tr>
<td>66793</td>
<td>Clear</td>
<td>3400</td>
<td>-55 to 82 (-65 to 180)</td>
<td>10 to 20</td>
<td>13.8 (2000)</td>
<td>0.203 (0.008)</td>
<td>Ethyl</td>
</tr>
</tbody>
</table>

**Quantum® 124**

Offers aggressive bonding on rubber compounds that are difficult to bond. **Excellent O-ring bonder.**

- Viscosity 20cP
- Low viscosity
- Quick cure
- Difficult to bond rubber compounds

**Quantum® 132**

Quantum® 132 is an advanced odorless and non-blooming high performance cyanoacrylate adhesive. Quantum® 132 develops handling strength within seconds and full functional strength in hours. Quantum® 132 can be used on metals, thermoplastics, elastomers, ceramics, leather and cork.

- Viscosity 1000 cP
- Pale yellow liquid

**Quantum® Benefits**

- Specially Formulated for Challenging Bonds
- Surface Insensitive for Tough-to-Bond Substrates
- Low-Odor, Low-Blooming to Eliminate Vapor
- Toughened for Flexible Bonds
- Withstand Severe Thermal Cycling
- Suited For Dissimilar Substrate Joints
- High Impact Resistance
- High Humidity Resistance

**Quantum® 133**

A single-component cyanoacrylate adhesive formulated for impact, thermal shock and peel resistance.

- Single-component; no mixing
- Good shock and impact resistance
- Cures at room temperature
- Easy to apply

**Applications**

- For bonding parts that require a higher humidity resistance then regular cyanoacrylates
- For parts subjected to shock and/or vibration
- For parts subjected to thermal cycling
- For most rubber, plastic or metal substrates
### Quantum® Typical Values

**Grade**
- 124 Clear
- 132 Clear
- 133 Black
- 134 Clear
- 135 Clear
- 136 Yellow
- 138 Clear Gel
- 140 Clear
- 149 Clear
- 150 Clear
- 73421 Clear
- 80122 Clear

<table>
<thead>
<tr>
<th>Grade</th>
<th>Color</th>
<th>Viscosity (cP)</th>
<th>Temperature Range, °C (°F)</th>
<th>Fixture Time @ 22°C, Sec.</th>
<th>Shear Strength, N/mm² (psi)</th>
<th>Gap Fill mm (in.)</th>
<th>Resin Base</th>
</tr>
</thead>
<tbody>
<tr>
<td>124</td>
<td>Clear</td>
<td>20</td>
<td>-55 to 79 (-65 to 175)</td>
<td>10 to 30</td>
<td>17.2 (2500)</td>
<td>0.102 (0.004)</td>
<td>Ethyl</td>
</tr>
<tr>
<td>132</td>
<td>Clear</td>
<td>1000</td>
<td>-55 to 100 (-65 to 212)</td>
<td>30 to 60</td>
<td>17.9 (2600)</td>
<td>0.203 (0.008)</td>
<td>Beta-Methoxyethyl</td>
</tr>
<tr>
<td>133</td>
<td>Black</td>
<td>1600</td>
<td>-55 to 120 (-65 to 248)</td>
<td>60-120</td>
<td>22.1 (3200)</td>
<td>0.203 (0.008)</td>
<td>Ethyl</td>
</tr>
<tr>
<td>134</td>
<td>Clear</td>
<td>600</td>
<td>-55 to 92 (-65 to 180)</td>
<td>10 to 30</td>
<td>22.1 (3200)</td>
<td>0.177 (0.007)</td>
<td>Ethyl</td>
</tr>
<tr>
<td>135</td>
<td>Clear</td>
<td>100</td>
<td>-55 to 82 (-65 to 180)</td>
<td>5 to 20</td>
<td>22.1 (3200)</td>
<td>0.127 (0.005)</td>
<td>Ethyl</td>
</tr>
<tr>
<td>136</td>
<td>Yellow</td>
<td>50</td>
<td>-55 to 82 (-65 to 180)</td>
<td>30 to 60</td>
<td>13.8 (2000)</td>
<td>0.102 (0.004)</td>
<td>Ethyl</td>
</tr>
<tr>
<td>138</td>
<td>Clear Gel</td>
<td>50</td>
<td>-55 to 82 (-65 to 180)</td>
<td>10 to 30</td>
<td>22.1 (3200)</td>
<td>0.254 (0.010)</td>
<td>Ethyl</td>
</tr>
<tr>
<td>140</td>
<td>Clear</td>
<td>2400</td>
<td>-55 to 120 (-65 to 248)</td>
<td>20 to 50</td>
<td>22.1 (3200)</td>
<td>0.203 (0.008)</td>
<td>Ethyl</td>
</tr>
<tr>
<td>149</td>
<td>Clear</td>
<td>1600</td>
<td>-55 to 120 (-65 to 248)</td>
<td>60-120</td>
<td>22.1 (3200)</td>
<td>0.203 (0.008)</td>
<td>Ethyl</td>
</tr>
<tr>
<td>150</td>
<td>Clear</td>
<td>73421 Clear</td>
<td>-40 to 100 (-40 to 212)</td>
<td>5 to 10</td>
<td>15 (2000)</td>
<td>0.102 (0.004)</td>
<td>Ethyl</td>
</tr>
<tr>
<td>80122</td>
<td>Clear</td>
<td>1300</td>
<td>-55 to 120 (-65 to 248)</td>
<td>10 to 20</td>
<td>15 (2000)</td>
<td>0.203 (0.008)</td>
<td>Ethyl</td>
</tr>
</tbody>
</table>

### Quantum® 134
This heavier bodied general use adhesive provides excellent results on porous materials like cork, wood, cardboard, etc.
- Viscosity 600cP
- Medium Viscosity
- Alignment Time
- Better Gap Fill

### Quantum® 135
Possesses broad range capabilities for general purpose bonding. Provides .005” gap filling abilities and fast fixture times.
- Viscosity 100cP
- Medium Viscosity
- General Purpose
- All Surfaces

### Quantum® 136
Quantum® 136 is a state-of-the-art odorless and non-frosting single component, solventless, room temperature curing cyanoacrylate adhesive that polymerizes rapidly when pressed into a thin film between parts. The presence of surface moisture commences the cure of the adhesive.
- Odorless, non-frosting cyanoacrylate.
- Rapid Cure - forms a strong bond at room temperature in less than a minute with contact pressure.
- Surfaces - will bond almost any combination of similar or dissimilar materials.
- Easy Use - single component feature, eliminates any mixing.

### Quantum® 138
This gel formulation provides maximized gap filling along with longer working times to complete final adjustment and alignment after mating parts.
- Thixotropic Gel
- Non-Migrating Gel
- Long Fixture Times
- Maximum Gap Fill

### Quantum® 149
Bonds a wide-variety of substrates including metals, thermoplastics, elastomers, ceramics, cork, leather, and paper. Temperature resistance to 250°F (121°C).
- (Clear Liquid)
- Viscosity 2000 to 2800 cP

### Quantum® 156
Quantum® 156 is a single-component cyanoacrylate adhesive formulated for impact, thermal shock and peel resistance.
- Single-component: no mixing
- Good shock and impact resistance
- Cures at room temperature
- Easy to apply

### Quantum® 73421
Quantum® 73421 is a single-component, fast curing cyanoacrylate adhesive specially formulated for difficult to bond substrates.

### Quantum® 80122
Quantum® 80122 is a single component, fast curing cyanoacrylate adhesive especially formulated for difficult to bond substrates.

### Applications
- Rubber bumpers
- Speaker Components
- Fasteners
- Shock Mounts
- Gears to Shafts
- Wiper Blades
- O-rings
- Acrylic Windows

### Recommended Dispensing Equipment For Quantum®
- Autobonder® 2101
- Autobonder® 2111
- Autobonder® 2512
- Sureshot® Valves: 2200, 3000, 3200, 4000T
Gasket Replacer anaerobic adhesives are single component, 100% active, ready-to-use gel-like materials that cure at room temperature. Gasket Replacer products cure only after confinement (the nature of anaerobic adhesives) between mating surfaces. They remain wet during assembly. After curing and filling all imperfections, Gasket Replacer products form a thin, tough, resilient, solvent and temperature resistant seal.

Gasket Replacer adhesives are superior to other gasketing methods. They contain no solvents and do not shrink, stretch, split, rot, distort, wear-out or relax. Joints never need retorquing. Because the gasket is formed when parts are made-up (ie: bolted together), the plastic shim formed is a truly "custom" gasket seal. Gel not forced out cures to a shim as an exacting match of the surface irregularities. The shim mirrors and fills all the voids, nicks and scratches present in even the best-machined flanges.

Gasket Replacer 906
Gasket Replacer 906 is a single component room temperature cure gel-like anaerobic gasketing compound formulated to provide instant sealing capabilities. Once cured between mating metal flanges filling voids in the surface, Gasket Replacer 906 provides a thin, flexible, solvent and temperature resistant seal. Gasket Replacer 906 can replace or be used as a dressing for conventional gaskets.

- (Red Gel)
- Provides reliable seal
- Excellent chemical resistance

Gasket Replacer 907
Gasket Replacer 907 forms a high temperature seal between mated parts. Use on rigid, close fitting parts, operating to 400°F continuous duty. Fills gaps to .010” unprimed and gaps to .020” with primer. Suitable for application by tracing, screen printing and roll coating. Excellent for dressing gaskets in rigid assemblies.

- (Red Gel)
- High Temperature
- Rigid Assemblies

Applications:
- High temperature dimensional or spacer gaskets
- Outboard engine water jacket covers
- Split crankcases on two-cycle engines

Gasket Replacer 910
Gasket Replacer 910 is a general purpose product. It is a smooth gel that is easily applied and cures after confinement into a thin, tough, flexible, resilient and reliable seal. It flexes with flanges during pressure and/or thermal cycling, and withstands vibration effects. Fills gaps to .010” unprimed, .050” primed. Excellent supplement to dress hard or soft precut gaskets. Assures adequate gasket performance on less than optimum flange faces. Suitable for application by tracing, screen-printing, and roll coating. Use to replace all gaskets up to .030” thick.

- (Purple Gel)
- Multi-Purpose
- Stays Flexible

Applications:
- Gearbox covers
- Vacuum pump flanges
- Fuel and water pumps
- Automotive and truck axle covers

Gasket Replacer Typical Values

<table>
<thead>
<tr>
<th>Grade</th>
<th>Color</th>
<th>Viscosity, cP</th>
<th>Temperature Range, °C (°F)</th>
<th>Cure Speed, Hours</th>
<th>Gap Fill, mm (in.)</th>
<th>Unprimed</th>
<th>Primed</th>
<th>Unprimed</th>
<th>Primed</th>
<th>Recommended Primer</th>
</tr>
</thead>
<tbody>
<tr>
<td>906</td>
<td>Red</td>
<td>400,000 to 600,000</td>
<td>-55 to 150 (-65 to 300)</td>
<td>9 to 24</td>
<td>0.5 to 4</td>
<td>0.254 (0.010)</td>
<td>1.27 (0.050)</td>
<td>49 or 50</td>
<td></td>
<td></td>
</tr>
<tr>
<td>907</td>
<td>Red</td>
<td>165,000 to 500,000</td>
<td>-55 to 150 (-65 to 400)</td>
<td>4 to 24</td>
<td>0.5 to 4</td>
<td>0.254 (0.010)</td>
<td>0.508 (0.020)</td>
<td>49 or 50</td>
<td></td>
<td></td>
</tr>
<tr>
<td>910</td>
<td>Purple</td>
<td>700,000 to 1,700,000</td>
<td>-55 to 150 (-65 to 300)</td>
<td>1 to 12</td>
<td>0.25 to 2</td>
<td>0.254 (0.010)</td>
<td>1.27 (0.050)</td>
<td>49 or 50</td>
<td></td>
<td></td>
</tr>
<tr>
<td>916</td>
<td>Red</td>
<td>500,000 to 1,000,000</td>
<td>-55 to 150 (-65 to 300)</td>
<td>4 to 24</td>
<td>0.5 to 4</td>
<td>0.254 (0.010)</td>
<td>1.27 (0.050)</td>
<td>49 or 50</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

Gasket Replacer 916
Gasket Replacer 916 is a single component room temperature cure gel-like anaerobic gasketing compound specially formulated for use on mating aluminum flanges, without requiring primer. Instant seal integrity is provided. Once cured between mating metal flanges filling voids in the surface, Gasket Replacer 916 provides a thin, flexible, solvent and temperature resistant seal. Gasket Replacer 916 can replace or be used as a dressing for conventional gaskets.

- (Red Gel)
- For Aluminum Parts
- Stays Flexible
Gasket Replacer

### Recommended Dispensing Equipment For Gasket Replacer

- **Autosealer® 2600**
- **Autosealer® 2650**
- **Rambo®**
- **Manual and Pneumatic Guns**

### Bead Size and Length for Gasket Replacer

<table>
<thead>
<tr>
<th>Container Size</th>
<th>Bead Diameter (inches)</th>
<th>Bead Length (inches)</th>
</tr>
</thead>
<tbody>
<tr>
<td>50ml Tube</td>
<td>.250</td>
<td>62</td>
</tr>
<tr>
<td></td>
<td>.130</td>
<td>250</td>
</tr>
<tr>
<td></td>
<td>.060</td>
<td>1,000</td>
</tr>
<tr>
<td>100ml Tube</td>
<td>.250</td>
<td>125</td>
</tr>
<tr>
<td></td>
<td>.130</td>
<td>500</td>
</tr>
<tr>
<td></td>
<td>.060</td>
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<td>250ml Tube</td>
<td>.250</td>
<td>310</td>
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<tr>
<td></td>
<td>.130</td>
<td>1,250</td>
</tr>
<tr>
<td></td>
<td>.060</td>
<td>10,000</td>
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<tr>
<td>300ml Cartridge</td>
<td>.250</td>
<td>1,500</td>
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<tr>
<td></td>
<td>.130</td>
<td>6,000</td>
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<tr>
<td>850ml Cartridge</td>
<td>.250</td>
<td>1,060</td>
</tr>
<tr>
<td></td>
<td>.130</td>
<td>4,250</td>
</tr>
<tr>
<td></td>
<td>.060</td>
<td>17,100</td>
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<tr>
<td>10 Liter Pail</td>
<td>.250</td>
<td>12,400</td>
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<td>.130</td>
<td>50,000</td>
</tr>
<tr>
<td></td>
<td>.060</td>
<td>400,000</td>
</tr>
</tbody>
</table>

### Silastomer® sealants

Silastomer® sealants are high performance, single component, moisture curing RTV (room temperature vulcanizing) silicone gasketing materials that cure into a strong, silicone rubber that maintains long term durability and flexibility. They have a nonslumping, paste-like consistency, which cures when exposed to moisture in the air. Gap filling is excellent with these systems. Silastomer® adhesives are 100% silicone compounds and are excellent for weatherproofing. They offer excellent resistance to moisture, temperature extremes, vibration, weathering effects, ozone, ultraviolet radiation, freeze-thaw cycles, and most airborne chemicals. The adhesives can be applied to sub-zero weather with no loss in performance. Fully cured Silastomer® can be used for extended periods at temperatures up to 500°F and for shorter periods, as high as 600°F.

The high viscosity of Silastomer® sealants allows application to vertical, horizontal and overhead joints without sagging or running off. The Silastomer® sealants will adhere to clean metals, glass, most types of wood, silicone resin, vulcanized silicone rubber, natural and synthetic fibers, ceramics, many plastics and other non-porous surfaces. Silastomer® adhesives begin curing immediately upon contact with air. High humidity accelerates the cure of the Silastomer® adhesives. Parts should be mated and the sealant worked (tooled) before the adhesive surface “skins over”, or becomes tack free, normally within 30 minutes at 50% relative humidity and 75°F. Part surfaces should be clean and dry. Best bonding results are obtained by wiping surfaces with solvents. **Cleaner™ 62** is recommended. When working with plastic substrates verify the suitability of prep solvents prior to application.

Silastomer® 333

Silastomer® 333 is a high performance, single component, ready to use adhesive / sealant. It has a paste-like consistency, which cures to a tough, resilient and durable silicone rubber when exposed to moisture in the air. Since it will not flow of its own weight, Silastomer® 333 can be applied to vertical, horizontal and overhead joints without sagging or running off. It will adhere to clean metals, glass, most types of wood, silicone resin, vulcanized silicone rubber, natural and synthetic fiber, ceramic, many plastics and painted surfaces.

Silastomer® 333 provides excellent resistance to moisture, weathering, vibration, ozone and extreme temperatures. It can be applied in surface temperatures of 0°F to above 120°F with no loss in performance. Fully cured Silastomer® 333 can withstand extended periods at temperatures up to 400°F.

### Product Benefits

- One component – no mixing
- Room temperature cure
- Non-sagging for use on horizontal, vertical or overhead surfaces
- Excellent high and low temperature resistance
- Excellent weatherability
- Versatile electrical insulation
- Cured rubber is non-toxic
- Good solvent resistance
Silastomer® 334
Silastomer® 334 is a high performance, single component, ready to use adhesive / sealant. It has a paste-like consistency, which cures to a tough, resilient and durable silicone rubber when exposed to moisture in the air. Since it will not flow of its own weight, Silastomer® 334 can be applied to vertical, horizontal and overhead joints without sagging or running off. It will adhere to clean metals, glass, most types of wood, silicone resin, vulcanized silicone rubber, natural and synthetic fiber, ceramic, many plastics and painted surfaces.

Silastomer® 334 provides excellent resistance to moisture, weathering, vibration, ozone and extreme temperatures. It can be applied in surface temperatures of 0°F to above 120°F with no loss in performance. Fully cured Silastomer® 334 can withstand extended periods at temperatures up to 400°F.

**Product Benefits**

- One component – no mixing
- Room temperature cure
- Non-sagging for use on horizontal, vertical or overhead surfaces
- Excellent high and low temperature resistance
- Excellent weatherability
- Versatile electrical insulation
- Cured rubber is non-toxic
- Good solvent resistance

**Applications:**

- Advance Chemistry
- Non-Corrosive
- No Vinegar Odor

**Electronic & Electrical Applications**

- Mount & seal meters and movements
- Seal and insulate circuit boxes, junctions
- Weatherproofing circuit boards and electrical motor components

Silastomer® 334 is our high temperature silicone gasketing compound designed for severe service. Continuous operating temperature to 500°F and intermittent exposure to 600°F is tolerated by the adhesive.

**Product Benefits**

- High Temperature
- Severe Service

**Applications:**

- Pump and compressor gaskets
- Gasketing oven doors, furnace windows, kiln “peep holes”
- Air conditioner & heat pump gaskets, oven, heat treat units, dust collectors
- Humidifier gaskets
- Seal thermocouples, probes, elements

Silastomer® 336 is a high performance, single component, ready to use adhesive / sealant. It has a paste-like consistency, which cures to a tough, resilient and durable silicone rubber when exposed to moisture in the air. Since it will not flow of its own weight, Silastomer® 336 can be applied to vertical, horizontal and overhead joints without sagging or running off. It will adhere to clean metals, glass, most types of wood, silicone resin, vulcanized silicone rubber, natural and synthetic fiber, ceramic, many plastics and painted surfaces.

Silastomer® 336 provides excellent resistance to moisture, weathering, vibration, ozone and extreme temperatures. It can be applied in surface temperatures of 0°F to above 120°F with no loss in performance. Fully cured Silastomer® 336 can withstand extended periods at temperatures up to 400°F.

**Product Benefits**

- One component – no mixing
- Room temperature cure
- Non-sagging for use on horizontal, vertical or overhead surfaces
- Excellent high and low temperature resistance
- Excellent weatherability
- Versatile electrical insulation
- Cured rubber is non-toxic
- Good solvent resistance

**Applications:**

- Seal thermocouples, probes, elements
- Humidifier gaskets
- Units, dust collectors
- Air conditioner & heat pump gaskets
- Ovens, heat treat holes
- Gasketing oven doors, furnace windows, kiln “peep windows”
- Pump and compressor gaskets
- Seal and insulate circuit boxes, junctions
- Weatherproofing circuit boards and electrical motor components

Silastomers® 333, 334 and 336, differ by color alone. These grades offer performance to 400°F continuous operation, and gap filling capability to .250 inch.

**Silastomer® 333, 334, 336 Applications:**

- Differential, junction box, axle housing, and flange gaskets
- Bonding trim strips, name plates, and sealing appliances
- Bonding outdoor signs
- Bonding gaskets and attaching insulation batts to heating & cooling units

**Recommended Dispensing Equipment For Silastomer®**

- 300ML Pneumatic Cartridge Dispense Guns

<table>
<thead>
<tr>
<th>Grade</th>
<th>Color</th>
<th>Viscosity</th>
<th>Temperature Range, °C (°F)</th>
<th>Tack Free Time / Full Cure at 75°F</th>
<th>Gap Fill, mm (in.)</th>
<th>Cure Type</th>
<th>Hardness, Shore A</th>
<th>% Elongation</th>
</tr>
</thead>
<tbody>
<tr>
<td>333</td>
<td>Clear</td>
<td>Thixotropic Paste</td>
<td>-71 to 232 (-95 to 450)</td>
<td>30 minute / 24 hours</td>
<td>6.35 (0.250)</td>
<td>Acetoxy</td>
<td>30</td>
<td>600</td>
</tr>
<tr>
<td>334</td>
<td>White</td>
<td>Thixotropic Paste</td>
<td>-71 to 232 (-95 to 450)</td>
<td>30 minute / 24 hours</td>
<td>6.35 (0.250)</td>
<td>Acetoxy</td>
<td>30</td>
<td>600</td>
</tr>
<tr>
<td>336</td>
<td>Black</td>
<td>Thixotropic Paste</td>
<td>-74 to 204 (-95 to 400)</td>
<td>30 minute / 24 hours</td>
<td>6.35 (0.250)</td>
<td>Acetoxy</td>
<td>30</td>
<td>600</td>
</tr>
<tr>
<td>340</td>
<td>Red</td>
<td>Thixotropic Paste</td>
<td>-71 to 316 (-95 to 600)</td>
<td>30 minute / 24 hours</td>
<td>6.35 (0.250)</td>
<td>Acetoxy</td>
<td>33</td>
<td>370</td>
</tr>
<tr>
<td>343</td>
<td>Black</td>
<td>Thixotropic Paste</td>
<td>-71 to 316 (-95 to 450)</td>
<td>20 minutes / 24 hours</td>
<td>6.35 (0.250)</td>
<td>Oxime</td>
<td>33</td>
<td>300</td>
</tr>
</tbody>
</table>
**Dripstop®**

Dripstop® sealants are 100% active containing no solvents to evaporate. They do not shred like tape dope and are not subject to cold flow, pressure and temperature phenomena like non-hardening dopes. Grade numbers 920, 940, and 427 have been tested and classified by the Underwriters Laboratory’s (UL) File Number MH14222.

Anaerobic pipe sealants/adhesives are superior to other sealing methods. They contain no solvents and do not shrink, stretch, split, rot, distort, wear-out, or relax and joints never loosen under vibration. Pressure cycling does not weaken or loosen the sealant path. Because the sealant path is formed when parts are made-up (i.e. threaded together), the plastic shimm formed during cure is truly a “custom” seal. Sealant not forced out cures to a helical path in the thread roots to form an exacting match of the surface irregularities. The shim mirrors and fills all the voids, scratches, and thread nicks present in even the best machined straight or pipe threads. Unlike Teflon®, any non-confined or excess sealant material does not cure and pose the threat presented by shredded tape fouling valves or circuit elements.

**Dripstop® 920**

Dripstop® 920 is a general-purpose plumbers’ aid, seals moderate pressures instantly while sealing to 250psi steam pressures in 24 hours. It is a highly reliable sealant, which resists the attack of chemicals and solvents. Dripstop® 920 is used for all types of threaded pipe, pipe plugs, hydraulic and pneumatic fittings, and steam lines up to 400°F (204°C). Dripstop® 920 is superior to tapes and non-hardening dopes while resulting in money savings from reduced leakage and reduced assembly costs. The Teflon® content in Dripstop® lubricates the threads during make-up and prevents galling and assures smooth disassembly.

- **Applications:**
  - Fuel line fittings
  - Air compressor hose
  - Steam lines to 250 psig
  - Pneumatic lines
  - Electrical conduit
  - Air conditioning lines
  - Machine bed fittings
  - Railroad equipment
  - Fluid connections

- **Applications:**
  - (White Paste)
  - General Purpose
  - Teflon® Filled
  - Temperatures to 400°F

**Dripstop® 921**

Dripstop® 921 is a single component multiple purpose anaerobic adhesive gel for locking, lubricating and sealing threaded fasteners and pipe fittings.

- **Applications:**
  - (Yellow gel)
  - General Purpose
  - Teflon® Filled
  - Temperatures to 400°F

**Dripstop® 923**

Dripstop® 923 is specially formulated for use on tapered threads and provides a lower break-loose torque than Dripstop® 940. Tapered threads “cone” together, so Dripstop® 923 is formulated for easier disassembly.

- **Applications:**
  - (White Paste)
  - For Tapered Threads
  - Teflon® Filled

**Dripstop® 927**

Dripstop® 927 is a high-performance sealant for tapered pipe threads. This creamy paste-like anaerobic compound is designed for sealing threaded fittings in fossil fuel, solar and hydro power plant plumbing systems.

- **Applications:**
  - Electric power generation plants

**Dripstop® 940**

Dripstop® 940 is a high-speed thread sealant used on inactive metals such as stainless steel and monel and in chemical process piping. Normally, inactive materials like stainless steel would require a primer to assure predictable curing. Dripstop® 940 is formulated to cure without a primer, but priming does reduce cure time. The enhanced chemistry of Dripstop® 940 delivers fast cure speeds on conventional materials, like carbon steel, brass, etc. Dripstop® 940 withstands high pressures, sealing up to 250psig steam at 400°F (204°C) continuous service while maintaining its chemical inertness.

- **Applications:**
  - Plated flare fittings
  - Pulp and paper mills
  - Refinery piping
  - Instrumentation fittings
  - Waste treatment plants
  - Textile equipment
  - Piping for chlorine & caustic sodas
  - Diesel Exhaust Fluid systems

**Dripstop® 943**

Dripstop® 943 is a specially formulated sealant for sealing and mildly locking hydraulic and pneumatic threaded components. Dripstop® 943 seals all pipe threads, standard nuts and bolts, and fittings in hydraulic, pneumatic, air conditioning and refrigeration systems. Dripstop® 943 is chemical and temperature resistant for use in chemical processing and steam up to 300°F.

- **Applications:**
  - Hydraulic systems
  - Pneumatic fittings
  - Chemical processing systems
  - Air conditioners

**Dripstop® 929**

Dripstop® 929 is a general purpose anaerobic pipe sealant. It has superior sealing and mild locking performance compared to tapes and non-hardening dopes. Dripstop® 929 seals to moderate pressure immediately and to 250psig steam pressure in just 24 hours. This sealant lubricates threads during make-up, prevents galling and assures smooth disassembly.

- **Applications:**
  - Pneumatic, hydraulic and fuel line fittings

**Dripstop® 930**

Dripstop® 930 is a single component high performance pipe sealant. The product is a white creamy compound, exhibiting high lubricating properties, preventing galling on stainless steel, aluminum and all other metal pipe fittings.

- **Applications:**
  - Diesel Exhaust Fluid systems
  - Piping for chlorine & caustic sodas
  - Waste treatment plants
  - Textile equipment
  - Refinery piping
  - Pulp and paper mills
  - Hydronic systems
Dripstop® 944

Dripstop® 944 is designed for the locking and sealing of metal tapered threads and fittings. The product cures when confined in the absence of air between close fitting metal surfaces and prevents loosening and leakage from shock and vibration.

- (Brown Liquid)
- Designed for electrical power plants
- Lubricated for decreased galling
- Anaerobic cure

Applications:
- Replaces the fastener locking device of all kinds
- Sealing and locking tapered threads

Dripstop® 945

Dripstop® 945 is a high performance sealant specifically formulated for sealing and mildly locking hydraulic and pneumatic threaded components. Safe for most hydraulic systems, Dripstop® 945 disperses to prevent system contamination.

- (Brown Liquid)
- Seals a wide-range of industrial fluids and gases
- Does not shrink or crack due to solvent evaporation
- Ready to use, single component
- Room temperature cure

Applications:
- Hydraulic systems
- Air conditioners
- Refrigeration components
- Chemical processing valves

Dripstop® 947

Dripstop® 947 is a filler-free sealant for all hydraulic fluids. It will not contaminate hydraulic systems while sealing against fluid loss due to shock, pulsing and vibration. This product is designed for “fluid-power” hydraulic and pneumatic service.

- (Brown Liquid)
- Hydraulic & Pneumatic Sealant
- Thick Liquid

Applications:
- Fork lift hydraulics
- Mobile power trucks
- Machine tools
- Hydraulic cylinders

<table>
<thead>
<tr>
<th>Fitting Size (NPT)</th>
<th>Fittings per 50 ml Tube</th>
</tr>
</thead>
<tbody>
<tr>
<td>1/8”</td>
<td>400</td>
</tr>
<tr>
<td>1/4”</td>
<td>200</td>
</tr>
<tr>
<td>3/8”</td>
<td>135</td>
</tr>
<tr>
<td>1/2”</td>
<td>100</td>
</tr>
<tr>
<td>3/4”</td>
<td>65</td>
</tr>
<tr>
<td>1”</td>
<td>50</td>
</tr>
</tbody>
</table>

Dripstop® 946

Dripstop® 946 is a sealant specially formulated for sealing and mildly locking hydraulic and pneumatic threaded components. Dripstop® 946 seals pipe threads, standard nuts and bolts, fittings for hydraulic and pneumatic systems, air conditioners, and refrigeration systems. It is chemical and temperature resistant up to 300°F. This thixotropic sealant will prevent leakage and loosening from shock and vibration.

- Effectively seals a wide range of industrial fluids and gases
- Does not shrink or crack due to solvent evaporation
- Ready to use, single component
- Room temperature cure

Applications:
- Hydraulic systems
- Air conditioners
- Refrigeration components
- Chemical processing valves

Dripstop® 948

Dripstop® 948 is designed for pipe threads in the harshest environments including oxygen and aggressive chemicals such as chlorine or powerful oxidizers. Dripstop® 948 is ideal for applications where repeated disassembly and reassembly are required. Seals up to 10,000 psi on ½” NPT threads.

Applications:
- Water treatment systems
- Water purification systems
- Drainage systems
- Fluorination systems
- Oxygen delivery systems

Recommended Dispensing Equipment For Dripstop®

- Autosealer® 2600
- Autosealer® 2650
- Rambo®
- Manual and Pneumatic Guns

Dripstop® 950

Dripstop® 950 is designed for pipe threads in the harshest environments including oxygen and aggressive chemicals such as chlorine or powerful oxidizers. Dripstop® 950 is ideal for applications where repeated disassembly and reassembly are required. Seals up to 10,000 psi on ½” NPT threads.

Applications:
- Fluorination systems
- Water treatment systems
- Diving equipment
- Oxygen delivery systems

Recommended Dispensing Equipment For Dripstop®

- Autosealer® 2600
- Autosealer® 2650
- Rambo®
- Manual and Pneumatic Guns

Dripstop® 950

Dripstop® 950 is designed for pipe threads in the harshest environments including oxygen and aggressive chemicals such as chlorine or powerful oxidizers. Dripstop® 950 is ideal for applications where repeated disassembly and reassembly are required. Seals up to 10,000 psi on ½” NPT threads.

- (Light Green Liquid)
- Chemically inert
- Nonflammable
- Nontoxic
- Temperature resistant to 450°F
- Non-migrating

Applications:
- Oxygen delivery systems
- Diving equipment
- Water treatment systems
- Fluorination systems

Recommended Dispensing Equipment For Dripstop®

- Autosealer® 2600
- Autosealer® 2650
- Rambo®
- Manual and Pneumatic Guns

Dripstop® Typcal Values

<table>
<thead>
<tr>
<th>Grade</th>
<th>Color</th>
<th>Viscosity cP</th>
<th>Temperature Range, °C (°F)</th>
<th>Pressure Resistance, PSI</th>
<th>Breakaway Torque Nm (in-lbs)</th>
<th>Recommended Primer</th>
</tr>
</thead>
<tbody>
<tr>
<td>920</td>
<td>White</td>
<td>350,000</td>
<td>-55 to 204 (-65 to 400)</td>
<td>10,000</td>
<td>&gt;9.6 (6)</td>
<td>49 or 50</td>
</tr>
<tr>
<td>921</td>
<td>Yellow</td>
<td>70,000</td>
<td>-73 to 149 (-100 to 300)</td>
<td>10,000</td>
<td>&gt;11.3 (100)</td>
<td>49 or 50</td>
</tr>
<tr>
<td>923</td>
<td>White</td>
<td>300,000</td>
<td>-55 to 150 (-65 to 300)</td>
<td>10,000</td>
<td>&gt;2.8 (25)</td>
<td>49 or 50</td>
</tr>
<tr>
<td>927</td>
<td>White</td>
<td>450,000</td>
<td>-55 to 204 (-65 to 400)</td>
<td>10,000</td>
<td>&gt;5.6 (50)</td>
<td>49 or 50</td>
</tr>
<tr>
<td>929</td>
<td>White</td>
<td>400,000</td>
<td>-55 to 204 (-65 to 400)</td>
<td>10,000</td>
<td>&gt;5.6 (50)</td>
<td>49 or 50</td>
</tr>
<tr>
<td>930</td>
<td>White</td>
<td>130,000</td>
<td>-55 to 204 (-65 to 400)</td>
<td>10,000</td>
<td>&gt;2.8 (25)</td>
<td>49 or 50</td>
</tr>
<tr>
<td>940</td>
<td>White</td>
<td>550,000</td>
<td>-55 to 204 (-65 to 400)</td>
<td>10,000</td>
<td>&gt;1.7 (15)</td>
<td>49 or 50</td>
</tr>
<tr>
<td>943</td>
<td>Yellow</td>
<td>175</td>
<td>-55 to 150 (-65 to 300)</td>
<td>10,000</td>
<td>&gt;2.3 (20)</td>
<td>49 or 50</td>
</tr>
<tr>
<td>944</td>
<td>Brown</td>
<td>2.00</td>
<td>-55 to 150 (-65 to 300)</td>
<td>10,000</td>
<td>&gt;2.8 (25)</td>
<td>49 or 50</td>
</tr>
<tr>
<td>945</td>
<td>Brown</td>
<td>500</td>
<td>-55 to 150 (-65 to 300)</td>
<td>10,000</td>
<td>&gt;2.8 (24)</td>
<td>49 or 50</td>
</tr>
<tr>
<td>946</td>
<td>Brown</td>
<td>600</td>
<td>-55 to 150 (-65 to 300)</td>
<td>10,000</td>
<td>&gt;15 (130)</td>
<td>49 or 50</td>
</tr>
<tr>
<td>947</td>
<td>Brown</td>
<td>14,000</td>
<td>-55 to 150 (-65 to 300)</td>
<td>10,000</td>
<td>&gt;2.3 (20)</td>
<td>49 or 50</td>
</tr>
<tr>
<td>950</td>
<td>Light Green</td>
<td>1,000,000</td>
<td>-240 to 204 (-400 to 400)</td>
<td>10,000</td>
<td>Non-curing</td>
<td>Non-curing</td>
</tr>
</tbody>
</table>

*Measured in inches
SelfSealer® products are tough, preapplied, non-hardening thread sealants. They provide instant seals on different pipe threads and can be used up to eight (8) times without recoating. SelfSealer® products are water based, non-toxic and can be applied without special handling precautions. SelfSealer® products generate prevailing torque to resist loosening from vibration and are very effective on non-locking applications.

The key features of the SelfSealer® products are:

- No cure time is required. The preapplied film provides instant sealing for NPT threads up to 4 inches in diameter.
- Mechanically, the dry film generates prevailing torque characteristics — approximately 75 inch lbs. On 3/8 – 16 fasteners — makes threaded parts resistant to vibrational loosening after installation. (The system also imparts a slight increase in the break-loose torque of parts.)
- Corrosion is inhibited between mating threads. The threads are safely sealed from contact with the atmosphere by the coating.

SelfSealer® 604

SelfSealer® 604 is a low viscosity, tough, preapplied, non-hardening threaded sealant. When dried, it becomes a resilient, light clinging, non-curing sealant for tapered or straight threads. It provides an instant seal on different pipe threads and can be used up to eight (8) times without recoating.

SelfSealer® 604 is water based, non-toxic, safe and can be applied easily without special handling precautions. It contains a bacteria and fungus preservative to inhibit growth of microorganisms. It also provides resistance to vibrational loosening because of its prevailing torque characteristics. It is very effective on non-locking applications.

Benefits:

- The preapplied coating eliminates liquid and paste migration problems and concerns during installation.
- Precoated fittings can be stored for immediate delivery and assembly.
- Ideal for field assembly — precoated parts are always there and ready for the task.
- Precoated parts have a shelf life of several years.

SelfSealer® 604 Applications

- Plumbing Parts
- Door Closure Hardware
- Pipe Fittings
- Compressor Pipe Plugs
- Shower Heads
- Bearing Adjuster Nuts
- Overhead Fire Sprinklers
- Brake Fittings
- Pressure Gauges
- Valves

SelfSealer® 615

SelfSealer® 615 is a high viscosity, tough, preapplied, non-hardening thread sealant. When dried, it becomes a resilient, tight clinging, non-curing sealant for tapered or straight threads. It provides an instant seal on different pipe threads and can be used up to eight (8) times without recoating. SelfSealer® 615 is water based, non-toxic and can be applied without special handling precautions. It generates prevailing torque to resist loosening from vibration and is very effective on non-locking applications.

- (Burnt Orange Liquid)
- Viscosity: 30,000 cP
- Seals NPT threads up to 4-inches in diameter
- Generates prevailing torque to resist loosening from vibration
- Limits corrosion of components
- Safe for plastics

SelfSealer® 616

SelfSealer® 616 is a high viscosity, tough, preapplied, non-hardening threaded sealant. When dried, it becomes a resilient, tight clinging, non-curing sealant for tapered or straight threads. It provides an instant seal on different pipe threads and can be used up to eight (8) times without recoating. SelfSealer® 616 is water based, non-toxic, safe and can be applied easily without special handling precautions. It provides resistance to vibrational loosening because of its prevailing torque characteristics. Therefore, it is very effective on non-locking applications.

- (White Liquid)
- Viscosity: 30,000 cP
- Seals NPT threads up to 4-inches in diameter
- Generates prevailing torque to resist loosening from vibration
- Limits corrosion of components
- Safe for plastics

SelfSealer® 618

SelfSealer® 618 provides an instant seal on different pipe threads and can be used up to eight (8) times without recoating. The system also imparts a slight increase in the break-loose torque of parts.

- (White Liquid)
- Viscosity: 30,000 cP
- Seals NPT threads up to 4-inches in diameter
- Generates prevailing torque to resist loosening from vibration
- Limits corrosion of components
- Safe for plastics

SelfSealer® 622

SelfSealer® 622 is a tough, preapplied, nonhardening threaded sealant. SelfSealer® 622 provides an instant seal on different pipe threads and can be used up to eight (8) times without recoating. SelfSealer® 622 is water based, non-toxic, safe and can be applied easily without special handling precautions. SelfSealer® 622 provides resistance to vibrational loosening because of its prevailing torque characteristics. Therefore, it is very effective on non-locking applications.

- (White Liquid)
- Viscosity: 30,000 cP
- Seals NPT threads up to 4-inches in diameter
- Generates prevailing torque to resist loosening from vibration
- Limits corrosion of components
- Safe for plastics

Usage Chart for SelfSealer®

<table>
<thead>
<tr>
<th>Pipe Size</th>
<th>Coating Width</th>
<th>mL/1,000 Parts</th>
</tr>
</thead>
<tbody>
<tr>
<td>1/16</td>
<td>5/16</td>
<td>30</td>
</tr>
<tr>
<td>1/8</td>
<td>3/8</td>
<td>50</td>
</tr>
<tr>
<td>1/4</td>
<td>7/16</td>
<td>112</td>
</tr>
<tr>
<td>3/8</td>
<td>1/2</td>
<td>155</td>
</tr>
<tr>
<td>1/2</td>
<td>9/16</td>
<td>285</td>
</tr>
<tr>
<td>3/4</td>
<td>5/8</td>
<td>400</td>
</tr>
<tr>
<td>1</td>
<td>3/4</td>
<td>725</td>
</tr>
<tr>
<td>1 1/4</td>
<td>13/16</td>
<td>980</td>
</tr>
<tr>
<td>1 1/2</td>
<td>7/8</td>
<td>1,150</td>
</tr>
<tr>
<td>2</td>
<td>1 1/6</td>
<td>1,525</td>
</tr>
<tr>
<td>2 1/2</td>
<td>1 1/8</td>
<td>3,225</td>
</tr>
<tr>
<td>3</td>
<td>1/8</td>
<td>4,000</td>
</tr>
</tbody>
</table>

*Usage is based on grams per 1,000 fasteners

Benefits:

- The preapplied coating eliminates liquid and paste migration problems and concerns during installation.
- Precoated fittings can be stored for immediate delivery at assembly.
- The preapplied coating is tough, resilient and will resist shredding and peeling during assembly.
- Ideal for field assembly — precoated parts are always there and ready for the task.
- Precoated parts have a shelf life of several years. No special handling or storage required.
- Increased Profitability: Lower Costs, Less Down Time
- Reduced Inventories- no need to supply separate bottles of sealant with your products for assembly.
- Reduced Warranty claims- parts installed as engineered, prevents operator errors.
- Superior Reliability- field installations go smoothly, no costly repeat installations.
- Allows several reuses.

Recommended Dispensing Equipment For SelfSealer®

- Autosealer® 2600
- Autosealer® 2650
- Rambo®
- Manual and Pneumatic Guns
HERNON® offers a complete line of Nuts N’ Bolts® adhesives & sealants. These anaerobic adhesives are designed for use with assemblies with threaded fasteners.

They are single component, 100% active liquids that self-harden when air is omitted such as between the mating surfaces of a nut and bolt, while remaining a stable liquid in its container.

A wide selection of Nuts N’ Bolts® adhesives & sealants are available to provide specialized performance to meet your product specification and maintenance requirements. Adhesive properties such as maximum gap filling, cure time, shear strength (breakaway and prevailing torque) and viscosities can be matched to meet your specific needs.

Nuts N’ Bolts® adhesives & sealants replace lock washers and other expensive methods to prevent vibration and loosening of parts, thus improving machine reliability. These adhesives also seal against leakage eliminating internal corrosion for the life cycle of the assembly. All fasteners have manufacturing tolerances varying by the “class of fit” specified for the threads. Application of Nuts N’ Bolts® adhesives allows uniform distribution of the adhesive material into the voids between thread pressures – flanks and thread roots. The statistical variability of each thread path is filled with liquid adhesive which then cures into a tough helical path and prevents leakage past the seal of the polymer and self-loosening of the mated parts due to transverse vibration. Before the fastener pressure flanks can move, the cured adhesive in the thread roots must be overcome by the magnitude of vibration. Adhesives with greater “strength” possess greater mechanical shear strengths to resist greater magnitudes of vibration.

Benefits:
- Increased Profitability: Lower Costs, Less Down Time
- Reduced Inventories: No Need For “Special” Fasteners
- Reduced Maintenance: Parts Don’t Vibrate Loose
- Superior Reliability: Assembly Integrity Assured

Nuts N’ Bolts® 128

Nuts N’ Bolts® 128 is a unique thread locking concept. A plasticized cyanoacrylate is applied to threads and parts mated. The quick cure system delivers excellent breakaway torques and rapidly reducing prevailing torques. Because the 128 is non-anaerobic it is safe for use on plastic fasteners, fasteners threading into plastics, and threaded inserts molded into plastics. No chemical attack or crazing of the plastic occurs.

- (Blue Liquid)
- Specially Modified Cyanoacrylate
- Medium Strength
- Plastic Fasteners
- Fasteners in Plastics
- Fast Fixturing Time

Applications:
- Electronic parts, housings, components, coils, trim
- Consumer electronics, decorative trim, toys, hobbies
- Repair of stripped-out holes in plastic

Nuts N’ Bolts® 220

Nuts N’ Bolts® 220 is a single component, high strength, anaerobic compound used to lock and seal fine threaded nuts, bolts, and studs in a wide variety of applications.

- Single component (no mixing)
- Predictable and reliable performance
- No shrinkage or cracking due to solvent evaporation

Applications:
- Replaces the fastener locking device of all kinds
- Thread sealer
- Locking adjustment screw

Nuts N’ Bolts® 223

Nuts N’ Bolts® 223 is a single component, high strength, anaerobic compound used to lock and seal coarse threaded nuts, bolts and studs in a wide variety of applications.

- Single component (no mixing)
- Predictable and reliable performance
- Reduces inventory
- No shrinkage or cracking due to solvent evaporation

Applications:
- Replaces the fastener locking device of all kinds
- Thread sealer
- Locking adjustment screw

Nuts N’ Bolts® 225

Nuts N’ Bolts® 225 is a single component, high strength, anaerobic compound used to lock and seal coarse threaded nuts, bolts and studs in a wide variety of applications.

- Single component (no mixing)
- Predictable and reliable performance
- Reduces inventory
- No shrinkage or cracking due to solvent evaporation

Applications:
- Replaces the fastener locking device of all kinds
- Thread sealer
- Locking adjustment screw

Nuts N’ Bolts® 227

Nuts N’ Bolts® 227 is a single component, high strength, anaerobic compound used to lock and seal coarse threaded nuts, bolts and studs in a wide variety of applications.

- Single component (no mixing)
- Predictable and reliable performance
- Reduces inventory
- No shrinkage or cracking due to solvent evaporation

Applications:
- Replaces the fastener locking device of all kinds
- Thread sealer
- Locking adjustment screw

Nuts N’ Bolts® 230

Nuts N’ Bolts® 230 is a single component medium strength, anaerobic compound used to lock and seal fine threaded nuts, bolts and studs in a variety of applications where possible removal with hand tools is needed.

- Single component (no mixing)
- Predictable and reliable performance
- Reduces inventory
- No shrinkage or cracking due to solvent evaporation

Applications:
- Replaces the fastener locking device of all kinds
- Thread sealer
- Locking adjustment screw

Nuts N’ Bolts® 232

Nuts N’ Bolts® 232 is a single component medium strength, anaerobic compound used to lock and seal fine threaded nuts, bolts and studs in a variety of applications where possible removal with hand tools is needed.

- Single component (no mixing)
- Predictable and reliable performance
- Reduces inventory
- No shrinkage or cracking due to solvent evaporation

Applications:
- Replaces the fastener locking device of all kinds
- Thread sealer
- Locking adjustment screw

Nuts N’ Bolts® 234

Nuts N’ Bolts® 234 is a single component medium strength, anaerobic compound that locks and seals fine threaded nuts, bolts and studs in a variety of applications where possible removal with hand tools is needed.

- Single component (no mixing)
- Predictable and reliable performance
- Reduces inventory
- No shrinkage or cracking due to solvent evaporation

Applications:
- Replaces the fastener locking device of all kinds
- Thread sealer
- Locking adjustment screw
Nuts N’ Bolts® 236
Nuts N’ Bolts® 236 is a single component medium strength, anaerobic compound used to lock and seal fine threaded nuts, bolts and studs in a wide variety of applications where removal with hand tools is needed.

- Single component (no mixing)
- Predictable and reliable performance
- Reduces inventory
- No shrinkage or cracking due to solvent evaporation

Applications:
- Replaces the fastener locking device of all kinds
- Thread sealer
- Locking adjustment screw

Nuts N’ Bolts® 237
Nuts N’ Bolts® 237 is a single component, high strength, anaerobic compound used to lock and seal fine threaded nuts, bolts, and studs in a wide variety of applications. It is engineered to eliminate vibrational loosening of assembled parts with simple hand tools. It is non-migrating with predictable torque/tension and lubricity characteristics.

- Replaces the fastener locking device of all kinds
- Thread sealer
- Locking adjustment screw

Nuts N’ Bolts® 238
Nuts N’ Bolts® 238 is a single component anaerobic compound used to lock and seal coarse threaded nuts, bolts and studs in a wide variety of applications requiring easy removal or adjustment.

- Single component (no mixing)
- Predictable and reliable performance
- Reduces inventory
- No shrinkage or cracking due to solvent evaporation

Applications:
- Replaces the fastener locking device of all kinds
- Thread sealer
- Locking adjustment screw

Nuts N’ Bolts® 237
Nuts N’ Bolts® 240 is a single component anaerobic compound used to lock and seal fine threaded nuts, bolts and studs in a wide variety of applications requiring easy removal or adjustment.

- Single component (no mixing)
- Predictable and reliable performance
- Reduces inventory
- No shrinkage or cracking due to solvent evaporation

Applications:
- Replaces the fastener locking device of all kinds
- Thread sealer
- Locking adjustment screw

Nuts N’ Bolts® 246
Nuts N’ Bolts® 246 is a single component anaerobic compound used to lock and seal coarse threaded nuts, bolts and studs in a wide variety of applications where removal with ordinary hand tools is necessary.

- Single component (no mixing)
- Predictable and reliable performance
- Reduces inventory
- No shrinkage or cracking due to solvent evaporation

Applications:
- Replaces the fastener locking device of all kinds
- Thread sealer
- Locking adjustment screw

Nuts N’ Bolts® 240
Nuts N’ Bolts® 240 is a single component anaerobic adhesive/sealant designed especially for wicking applications. It has the ability to penetrate porous structures and cracks by capillary action, filling voids as large as 0.005 in.

- Easy to use, one part, self hardening.
- Eliminates leakage through porousities and cracks.
- Reduces warranty costs by sealing microporosity.

Applications:
- Sealing porous welds on storage and fuel tanks.
- Sealing welded transformer housings.
- Sealing brazed and soldered joints on air conditioner coils, heater cores and piping systems.
- Sealing porous die and sand castings such as engine blocks, manifolds and compressor parts.
- Sealing press fitted and other cylindrical assemblies.

Nuts N’ Bolts® 410
Nuts N’ Bolts® 410 is a single component, low viscosity anaerobic adhesive/sealant that is formulated for applications where a low viscosity, medium strength thread locker is desired.

- (Blue fluorescent liquid)

Applications:
- Adjustment screws
- Machine screws
- Set screws
- Control mechanisms
- Tool holder screws
- Thermostat screws

Nuts N’ Bolts® 419
Nuts N’ Bolts® 419 is a single component, no-mix, anaerobic-cure adhesive/sealant for small fasteners. It provides a controlled low-strength prevailing and locking torque on metal fasteners. It only cures once it is confined between mating surfaces. Nuts N’ Bolts® 419 prevents loosening from vibration and leakage of threaded fasteners.

- (Purple Fluorescent Liquid)
- Single component
- Will not cure outside the joints
- Cures without cracking or shrinking
- No mixing
- Prevents rusting of threads
- Seals against leakage
- Prevents movement of screw threads and eliminates self-loosening

Applications:
- Adjustment screws
- Machine screws
- Set screws
- Control mechanisms
- Tool holder screws
- Thermostat screws
Nuts N Bolts® 422
Nuts N Bolts® 422 is a medium strength, general-purpose threadlocking adhesive. It is ideal for all nut and bolt applications but it is especially suited for ½” or larger fasteners. Removable with hand tools. Curing occurs only when adhesive is confined between two mating surfaces. The cured adhesive is a thermostet plastic suitable for temperatures up to 300°F (149°C) & exposure to solvents. The cured adhesive is a thermoset plastic suitable for when adhesive is confined between two mating surfaces. The adhesive is suitable for temperatures up to 300°F (150°C).

Applications:
- Hydraulic piston nuts
- Mounting bolts on motors, pumps, etc
- Railroad bolts on wear plates
- Carburetor adjusting screws
- Machinery keys & machine tool access bolts
- Conveyor roller bolts & gear box bolts
- Bearing cover cap screws
- Drive shaft fasteners
- Rocker nuts
- Shaft coupling bolts

Nuts N Bolts® 423
Nuts N Bolts® 423 is formulated to meet the requirements of 75% of all fastener assemblies. This product is non-migrating for easy assembly line application while reliably replacing more expensive jam nuts, lock washers or other mechanical devices. Nuts N Bolts® 423 is 100% active anaerobic material that cures quickly to produce a resilient seal with predictable torqueing characteristics. Treated fasteners are vibration and shockproof and resist solvents, lubricants and other foreign agents that might damage internal parts.

Applications:
- Replace most fastener locking devices
- Hydraulic system bolts
- Gear-box bolts
- Bearing cover cap screws
- Drive shaft fasteners
- For reuse of worn or previously treated fasteners
- Countersunk screws
- Machine tool access bolts
- Conveyor roller bolts

Nuts N Bolts® 424
Nuts N Bolts® 424 is an anaerobic thread locking and sealing compound. Nuts N Bolts® 424 is a very high strength adhesive for locking and sealing all fasteners up to 1 inch in diameter. Nuts N Bolts® 424 is a perfect adhesive for harsh and corrosive environments. Curing occurs only when the adhesive is confined between mating surfaces. The adhesive is suitable for temperatures up to 300°F (150°C).

Applications:
- Locking and sealing
- Flange plate bolts and pump housings
- Transmission studs
- Air conditioning, refrigeration and process equipment studs
- Wheel mounting studs on heavy duty trucks
- All vibrating machinery fasteners

Nuts N Bolts® 425
Nuts N Bolts® 425 is designed to yield 30% higher breaking torque while sustaining predictable lubricity or torque/ tension relationships. Nuts N Bolts® 425 is especially effective for heavy-duty fasteners with poor tolerance under heavy stress and shock vibration levels. Nuts N Bolts® 425 is non-migrating and also effectively seals against penetration and leakage of most lubricants and solvents.

Applications:
- Refrigeration hardware
- Differential case bolts
- Railroad traction; motor mounting bolts
- Transmission loader bolts
- Heavy equipment studs
- Grade 5 and Grade 8 high strength bolts

Nuts N Bolts® 426
Nuts N Bolts® 426 offers the maximum locking and prevailing strength. The product resists vibration loosening in the most demanding situations.

Applications:
- Motor housing studs
- Machine base studs
- Pump housing studs

Nuts N Bolts® 427
Nuts N Bolts® 427 is a general purpose, high strength anaerobic with excellent sealing properties to eliminate thread corrosion. This product allows you to use less expensive threaded parts while improving the reliability and simplicity of assembly operations. Nuts N Bolts® 427 is especially suited for corrosive environments as well as refrigeration assemblies where resistance to Freon® or ammonia refrigerants is essential. This adhesive/sealant also resists the corrosive attack of lubricants, fuels, chemicals & gases. *(Registered Trademark, DuPont Co.)*

Applications:
- Flange plate bolts and pump housing
- Transmission studs
- Valve seats
- Air conditioning, refrigeration & equipment studs
- Wheel mounting studs on heavy duty trucks
- All vibrating machinery fasteners
Nuts N’ Bolts® 428

Nuts N’ Bolts® 428 is an anaerobic adhesive designed for tough applications demanding high strength and high temperature resistance to 450°F.

- (Red Liquid)
- High Strength
- High Temperature
- Heavy Duty Service

Applications:

- Heat treat furnaces
- Annealing equipment
- Rolling mill conveyors, components

Nuts N’ Bolts® 429

Nuts N’ Bolts® 429 is engineered for applications requiring maximum locking strength for fasteners over 1” in diameter. This highly viscous grade, permits utility where fasteners are under high vibration, shear leads and extreme shock.

- (Red Liquid)
- High Strength
- Bolts & Studs Greater than 1” Diameter

Applications:

- Studs on large presses
- Hydraulic cylinder tie-rod and pinto rods
- Axle, front end, suspension frame bolts
- Converyor roller bolts

Nuts N’ Bolts® 431

Nuts N’ Bolts® 431 is a wicking anaerobic used for preassembled equipment and structures where penetration into fastener connection points is required. This product allows very simple preventive maintenance by permitting thread locking without dismantling equipment. The product "wicks" into voids by capillary action. Use Nuts N’ Bolts® 431 to seal pores or pinhole porosity in welded seams, tanks, castings, or metal parts. Brush apply.

- (Green Liquid)
- Medium – High Strength
- Preassembled Fasteners of all Sizes
- Porosity Sealing

Nuts N’ Bolts® 431 cont’d

Applications:

- Air compressor fasteners
- Refrigeration safety valves, compressor coils
- Emission control valve screws
- Fasteners on equipment for shipment
- Calibration & adjustment screws
- Tamper proofing assemblies
- Bicycles, motorcycles
- Children’s swings, toys
- Gun smithing

Nuts N’ Bolts® 432

Weld Sealant 432 is a single component anaerobic penetrating adhesive and sealant. Utilizing capillary action, Weld Sealant 432 penetrates and seals porosities and cracks as large as 0.127 mm. Once confined away from air Weld Sealant 432 cures to a hard thermoset plastic. Sealant remaining on the surface will not cure and can be easily wiped clear. Benefits include retention of fluids and pressures as well as corrosion and contamination elimination. Temperature resistance is up to 400ºF (204ºC). Weld Sealant 433 is impervious to most solvents. Welds, castings and powder metal parts can be sealed to their rupture pressure.

- (Red Liquid)
- High Temperature
- Permanent Locking
- Heavy Duty Applications
- Fast Curing

Nuts N’ Bolts® 432 / Weld Sealant 433

Weld Sealant 433 is a wicking anaerobic used for threaded parts. This fast curing adhesive reduces and possibly eliminates the need for primers. Nuts N’ Bolts® 433 is well suited for large fasteners in harsh vibration and environmental areas.

- (Red Liquid)
- High Strength
- Permanent Locking
- Heavy Duty Applications
- Fast Curing

Nuts N’ Bolts® 433

Nuts N’ Bolts® 434 is a medium strength anaerobic offering ease of disassembly with hand tools. Well suited for use on less active surfaces like plated and stainless steel fasteners.

- (Blue Liquid)
- Medium Strength
- Hand Tool Disassembly

Applications:

- Mounting bolts for pumps, motors, gearboxes, etc.
- Bolts on housings, motors, power transmission units
- Rocker arm nuts, conveyors, access panels

Treating Screws by Tumbling Method with Nuts n’ Bolts® & Self Lockers™

| Number of milliliters required to treat nuts and bolts per 1,000 pieces |
|-----------------|-----------------|-----------------|-----------------|-----------------|
| Bolt Size*      | Manual Application | Automated Application |
| From Bottle     | Equipment        | From Bottle     | Equipment        |
| 1/4             | 27              | 17              | 1/4             | 27              | 17              |
| 5/16            | 45              | 30              | 5/16            | 45              | 30              |
| 3/8             | 75              | 50              | 3/8             | 75              | 50              |
| 7/16            | 105             | 70              | 7/16            | 105             | 70              |
| 1/2             | 135             | 90              | 1/2             | 135             | 90              |
| 9/16            | 180             | 120             | 9/16            | 180             | 120             |
| 5/8             | 225             | 150             | 5/8             | 225             | 150             |
| 3/4             | 340             | 130             | 3/4             | 340             | 130             |

Notes:

- Number of milliliters required to treat nuts and bolts per 1,000 pieces are rounded to the nearest whole number.
- Manual Application: Bolts per 1,000 pieces
- Automated Application: Number of milliliters per 1,000 pieces

Nuts N’ Bolts® 439

Nuts N’ Bolts® 439 is a high strength, anaerobic locking and sealing adhesive for threaded parts. This fast curing adhesive reduces and possibly eliminates the need for primers. Nuts N’ Bolts® 439 is well suited for large fasteners in harsh vibration and environmental areas.

- (Red Liquid)
- High Strength
- Permanent Locking
- Heavy Duty Applications
- Fast Curing

Applications:

- Transmissions
- Construction equipment
- Railroad assemblies
- High-performance automobiles
Threadpaste 432

**Threadpaste 432** is a single-component, anaerobic, threadlocking compound designed for heavy duty applications subject to operating temperatures to 450°F (232°C). The product delivers high strength locking and sealing on screws, nuts, bolts, studs and fittings. Excellent break loose and prevailing torque values assure maximized resistance to transverse vibration loosening at elevated temperatures.

**Product Benefits**
- Single component - no mixing
- Room temperature cure
- Non-sagging for use on vertical or overhead surfaces
- Excellent high and low temperature resistance
- Excellent weatherability
- Versatile electrical insulation
- Cured rubber is non-toxic
- Good solvent resistance

**Powerseal® 932**

**Powerseal® 932** is a non-curing, single component pipe thread sealant designed for instant seal ability to 600 psi. This versatile sealant is also unaffected by exposure to water, oil, ammonia, glycerin, steam, and all types of gases. **Powerseal® 932** withstands extreme environmental conditions including temperatures from -55°C (-65°F) to 232°C (450°F).

The increased lubricity of **Powerseal® 932** assists with tightening and adjustment of pipe threads and prevents galling of threads. **Powerseal®** is safe to use with all metals and on plastics without concern of crazing. This non-hardening pipe sealant will not shred and threaten delicate pneumatic and hydraulic systems. **Powerseal® 932** also prevents corrosion, which could lead to eventual seizing of mated components.

**Powerseal® 932** will not shrink, crack, or crumble. **Powerseal® 932** is a low-odor sealing solution that is non-volatile, non-toxic, non-flammable and non-conductive. In addition to threaded components, versatile **Powerseal® 932** can also seal flanges where traditional custom-cut gaskets would be utilized. It makes for easy assembly, disassembly and repairs. It also prevents corrosion and seizing of metal parts.

**Applications:**
- Seals and lubricates plastic and metal fittings.
- Seals fittings of one inch diameter or smaller.
- Seals flanges.
- Lubricates O-Rings.

**Benefits:**
- Prevents galling
- Never shreds (no contamination)
- Seals instantly to more than 600 psi (1" std. NPT pipe fittings at 60 ft-lb of torque)
- Surface insensitive
- Safe to use on plastic and metal
- Non-volatile
- Non-toxic
- Non-migrating
- Non-curing for easy disassembly
- Excellent lubrication for stainless steel
- Non-flammable
- Non-conductive

**Recommended Dispensing Equipment For Powerseal®**
- Powerseal® 932...

**Recommended Dispensing Equipment For Powerseal®**
- Autossealer® 2600
- Autossealer® 2600
- Rambo®
- Manual and Pneumatic Guns

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**Nuts N’ Bolts**

- **Threadpaste**
- **Powerseal®**

**Nuts N’ Bolts® Grade Details**

<table>
<thead>
<tr>
<th>Grade</th>
<th>Color</th>
<th>Viscosity cP</th>
<th>Temperature Range, °C (°F)</th>
<th>Fixture Time at 22°C, Minutes</th>
<th>Gap Fill mm (in.)</th>
<th>Prevailing Torque N•m (in-lbs)</th>
<th>Thixotropic Breakaway Torque N•m (in-lbs)</th>
<th>Recommended Primer</th>
</tr>
</thead>
<tbody>
<tr>
<td>128</td>
<td>Blue</td>
<td>80</td>
<td>-55 to 82 (-65 to 182)</td>
<td>0.102 (0.004)</td>
<td>1</td>
<td>NA</td>
<td>No</td>
<td>2.3-17.0 (20-150)</td>
</tr>
<tr>
<td>418</td>
<td>Blue</td>
<td>15</td>
<td>-55 to 150 (-65 to 300)</td>
<td>0.102 (0.004)</td>
<td>10-15</td>
<td>10.1-28.2 (90-250)</td>
<td>No</td>
<td>49 or 50</td>
</tr>
<tr>
<td>419</td>
<td>Purple</td>
<td>130</td>
<td>-55 to 150 (-65 to 300)</td>
<td>0.127 (0.005)</td>
<td>10 to 15</td>
<td>4.0 (35)</td>
<td>No</td>
<td>8.5 (75)</td>
</tr>
<tr>
<td>420</td>
<td>Purple</td>
<td>1200</td>
<td>-55 to 150 (-65 to 300)</td>
<td>0.127 (0.005)</td>
<td>0 to 15</td>
<td>4.0 (35)</td>
<td>Yes</td>
<td>5.6 (50)</td>
</tr>
<tr>
<td>421</td>
<td>Blue</td>
<td>130</td>
<td>-55 to 150 (-65 to 300)</td>
<td>0.127 (0.005)</td>
<td>15 to 20</td>
<td>11.3 (100)</td>
<td>No</td>
<td>16.9 (150)</td>
</tr>
<tr>
<td>423</td>
<td>Blue</td>
<td>1200</td>
<td>-55 to 150 (-65 to 300)</td>
<td>0.127 (0.005)</td>
<td>1 to 15</td>
<td>5.6 (50)</td>
<td>Yes</td>
<td>11.3 (100)</td>
</tr>
<tr>
<td>425</td>
<td>Red</td>
<td>1800</td>
<td>-55 to 150 (-65 to 300)</td>
<td>0.127 (0.005)</td>
<td>5 to 15</td>
<td>31.6 (280)</td>
<td>Yes</td>
<td>21.5 (190)</td>
</tr>
<tr>
<td>426</td>
<td>Green</td>
<td>500</td>
<td>-55 to 150 (-65 to 300)</td>
<td>0.305 (0.012)</td>
<td>5 to 10</td>
<td>39.5 (350)</td>
<td>No</td>
<td>26.0 (230)</td>
</tr>
<tr>
<td>427</td>
<td>Red</td>
<td>500</td>
<td>-55 to 150 (-65 to 300)</td>
<td>0.178 (0.007)</td>
<td>5 to 10</td>
<td>33.9 (300)</td>
<td>No</td>
<td>22.6 (200)</td>
</tr>
<tr>
<td>428</td>
<td>Red</td>
<td>6000</td>
<td>-55 to 232 (-65 to 450)</td>
<td>0.178 (0.007)</td>
<td>45 to 80</td>
<td>24.9 (220)</td>
<td>Yes</td>
<td>22.6 (200)</td>
</tr>
<tr>
<td>429</td>
<td>Red</td>
<td>7000</td>
<td>-55 to 150 (-65 to 300)</td>
<td>0.254 (0.010)</td>
<td>30 to 45</td>
<td>31.6 (280)</td>
<td>No</td>
<td>31.6 (280)</td>
</tr>
<tr>
<td>431</td>
<td>Green</td>
<td>15</td>
<td>-55 to 204 (-65 to 400)</td>
<td>0.102 (0.004)</td>
<td>10 to 15</td>
<td>29.4 (260)</td>
<td>No</td>
<td>10.2 (90)</td>
</tr>
<tr>
<td>434</td>
<td>Blue</td>
<td>2250</td>
<td>-55 to 150 (-65 to 300)</td>
<td>0.127 (0.005)</td>
<td>5 to 10</td>
<td>7.3 (65)</td>
<td>Yes</td>
<td>20.3 (180)</td>
</tr>
<tr>
<td>439</td>
<td>Red</td>
<td>3000</td>
<td>-55 to 150 (-65 to 300)</td>
<td>0.127 (0.005)</td>
<td>1 to 5</td>
<td>22.6 (200)</td>
<td>Yes</td>
<td>28.2 (250)</td>
</tr>
</tbody>
</table>

* Tested on M10 Zinc Phosphate Nuts and Bolts

**Recommended Dispensing Equipment For Nuts N’ Bolts®**
- Autossealer® 2600
- Autossealer® 2600
- Rambo®
- Manual and Pneumatic Guns

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**Powerseal®** offers a complete line of semi and fully automated dispensing equipment. Contact HERNON® Sales for additional information.

www.hernon-equipment.com
**Self Locker® 523**

**Self Locker® 524**

- **Product Benefits:**
  - Improves reliability
  - Prevents loosening of bolts due to vibration
  - Seals against leakage
  - Prevents threads from corroding
  - Easily visible for inspection
  - Pre-coated parts can be packaged and shipped in normal fashion
  - Excellent solvent resistance

- **Applications:**
  - Locking & Sealing:
    - Head bolts
    - Truck Axle bolts
    - Transmission nuts
    - Pipe plugs and fittings

**Product Benefits:**

- **Product Benefits:**
  - Improves reliability
  - Prevents loosening of bolts due to vibration
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  - Prevents threads from corroding
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  - Excellent solvent resistance

- **Applications:**
  - Locking & Sealing:
    - Head bolts
    - Truck Axle bolts
    - Transmission nuts
    - Pipe plugs and fittings

**Self Locker Typical Values**

<table>
<thead>
<tr>
<th>Grade</th>
<th>Color</th>
<th>Fixture Time, Minutes</th>
<th>Temperature Range, °F</th>
<th>Breakaway Torque, Nm (in-lbs)</th>
</tr>
</thead>
<tbody>
<tr>
<td>523</td>
<td>Light Grey</td>
<td>2-3</td>
<td>-54 to 150 (-65 to 300)</td>
<td>200</td>
</tr>
<tr>
<td>524</td>
<td>Pink</td>
<td>10</td>
<td>-54 to 150 (-65 to 300)</td>
<td>290</td>
</tr>
</tbody>
</table>

*Values are based on machine treating fasteners with Self Locker with a bond width of 1.5” X Diameter

*Usage is based on grams per 1,000 fasteners

*Self Locker is sold by the pound (454 g)
Cylinlock® Retaining Compounds are highly engineered, 100% active, high strength anaerobic liquids that cure to a tough plastic when air is excluded. The plastic shim is a tough plastic when air is excluded. The plastic shim is a viscous green retaining compound with excellent resistance to corrosion and solvents.

Application Benefits:
- (Green Liquid)
- General Purpose
- Low Viscosity
- Quick Cure Time

Applications:
- Pins, bushings
- Keyways, press fits
- Knobs on shafts
- Oil impregnated bushings
- Gears, pulleys, fans
- Rotors to shafts

Cylinlock® 826
Cylinlock® 826 offers high strengths in the range of 500-900°F. Press out or drive assemblies apart while at temperature and while the adhesive is softened. Electric strip heaters or torch flame are the most commonly used practice for large assemblies, ovens or furnaces for smaller parts.

Application Benefits:
- (Green Liquid)
- Medium Viscosity
- High Strength
- Temperatures to 400°F

Applications:
- Bushing & sleeves
- Rotors & shafts

Cylinlock® 823
Cylinlock® 823 is specifically designed for bonding cylindrical fitting parts where clean surfaces cannot be assured such as oil impregnated bushings. Cylinlock® 823 cures between components in the absence of oxygen.

Applications:
- Oil pumping equipment
- Emergency repairs

Cylinlock® 824
Cylinlock® 824 is a thick liquid retaining compound capable of delivering 4,000psi shear strengths (steel to steel) to assemblies. The heavy bodied adhesive cures slowly to permit readjustment of parts during the assembly process.

Applications:
- (Green Liquid)
- High Viscosity
- High Strength
- Excellent Gap Filling

Cylinlock® 827
Cylinlock® 827 is a single component anaerobic retaining adhesive for cylindrical joints. The product cures when confined in the absence of air between close fitting metal surfaces. This product develops medium strength to facilitate disassembly.

Applications:
- Used to bond cylindrical fitting parts, particularly where disassembly is required for service operations.
- Applications included retention of bearings onto shafts and into housings.

Cylinlock® 840
Cylinlock® 840 is recommended to supplement press fits. The low viscosity of this retaining compound provides good wetting action.

Applications:
- Pressed metal bearings, bushings
- Drill bushings
- Morse taper fits

Cylinlock® 842
Cylinlock® 842 is a viscous green retaining compound specifically engineered for high temperature applications (continuous service to 450°F). Cylinlock 842 cures at room temperature providing superior heat and chemically resistant bonds.

Applications:
- Heat exchanger tubes
- Brazed or soldered joints
- Engine cylinder liners
Cylinlock® 843
Cylinlock® 843 is a fast curing, high strength anaerobic adhesive yielding higher shear strengths with temperature resistance up to 300°F (149°C). It provides relatively quick cures, outstanding solvent resistance, and improved reliability for metal service applications. Flexible and good for use on brass.
- (Green fluorescent liquid)
- High strength
- Fast curing

Applications:
- Pipe fittings, threaded assemblies
- Bushings
- Pins, wheels, gears, pulleys

Cylinlock® 844
Cylinlock® 844 is a specialized retaining compound, yielding shear strengths of 3,500psi after full cure, but offering super fast fixturing time. Can be used for applications up to 350°F operation.
- (Green Liquid)
- Low Viscosity
- High Strength
- Fast Fixturing

Applications:
- Bushings, sleeves
- Bearings, pulleys

Cylinlock® 846
Cylinlock® 846 is the high strength analog of grade 822, yielding shear strengths of 4,000psi. Providing relatively quick cures, outstanding solvent resistance and improved reliability for severe service applications.
- (Green Liquid)
- Moderate Viscosity
- High Strength
- Severe Service

Applications:
- Keys in worn keyways
- Bushings
- Pins, wheels, gears, pulleys, etc.

Cylinlock® 34323
Cylinlock® 34323 is a fast curing, high strength anaerobic adhesive yielding higher shear strengths with temperature resistance up to 300°F (149°C). It provides relatively quick cures, outstanding solvent resistance and improved reliability for metal service applications.
- (Green fluorescent liquid)
- High strength
- Fast curing
- High temperature resistant

Applications:
- Pipe fittings, threaded assemblies
- Bushings
- Pins, wheels, gears, pulleys

Cylinlock® 52631
Cylinlock® 52631 is a single component, anaerobic retaining adhesive designed for the bonding of cylindrical parts. The product cures when confined in the absence of air between close fitting metal surfaces.
- (Green fluorescent liquid)
- High strength
- Fast curing
- High temperature resistant

Recommended Dispensing Equipment For Cylinlock®
- Autobonder® 2101
- Autobonder® 2111
- Autobonder® 2512
- Sureshot® Valves: 2200, 3000, 3200, 3500, 4000
- Rotocoaters®

Cylinlock® Typical Values

<table>
<thead>
<tr>
<th>Grade</th>
<th>Color</th>
<th>Viscosity cP</th>
<th>Temperature Range, °C (°F)</th>
<th>Fixture Time at 22°C, Minutes</th>
<th>Gap Fill, mm (in.)</th>
<th>Shear Strength N/mm² (psi)</th>
<th>Recommended Primer</th>
</tr>
</thead>
<tbody>
<tr>
<td>822</td>
<td>Green</td>
<td>125</td>
<td>-55 to 150 (-65 to 300)</td>
<td>10 to 15</td>
<td>0.127 (0.005)</td>
<td>17.2 (2500)</td>
<td>49 or 50</td>
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<tr>
<td>823</td>
<td>Green</td>
<td>150</td>
<td>-55 to 150 (-65 to 300)</td>
<td>1 to 5</td>
<td>0.127 (0.005)</td>
<td>24.1 (3500)</td>
<td>49 or 50</td>
</tr>
<tr>
<td>824</td>
<td>Green</td>
<td>2000</td>
<td>-55 to 150 (-65 to 300)</td>
<td>30 to 40</td>
<td>0.254 (0.010)</td>
<td>20.7 (3000)</td>
<td>49 or 50</td>
</tr>
<tr>
<td>826</td>
<td>Green</td>
<td>600</td>
<td>-55 to 204 (-65 to 400)</td>
<td>10 to 15</td>
<td>0.177 (0.007)</td>
<td>20.7 (3000)</td>
<td>49 or 50</td>
</tr>
<tr>
<td>840</td>
<td>Green</td>
<td>125</td>
<td>-55 to 150 (-65 to 300)</td>
<td>10 to 30</td>
<td>0.127 (0.005)</td>
<td>20.7 (3000)</td>
<td>49 or 50</td>
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<td>22.1 (3200)</td>
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FILLS SURFACE IMPERFECTIONS & PROVIDES 100% CONTACT BETWEEN MATING PARTS
Brake Bonder 362

Brake Bonder 362 is a black heat curing, nitrile/phenolic, solvent-based adhesive. Cured Brake Bonder 362 furnishes excellent resistance to thermal shock, chemicals and water. The cured bond withstands temperatures exceeding 600ºF (315ºC). The primary application for Brake Bonder 362 is bonding brake, clutch and other friction materials to metal.

Product Benefits

- Single component
- Excellent resistance to high temperature, chemicals, and water
- Flexible, thermal shock resistant bond
- Excellent adhesion
- High strength at room temperature and elevated temperatures.

Applications

- Friction materials (brakes, clutches, etc.) to metal
- Aluminum, steel, and other metals to themselves and each other.

Recommended Dispensing Equipment For Brake Bonder

- HERNON® offers a complete line of semi and fully automated dispensing equipment. Contact HERNON® Sales for additional information. www.hernon-equipment.com

Windshield Welder 772

Windshield Welder 772 is a single component ultra violet curing adhesives. It is especially formulated for repair of windshields in automobiles. Windshield Welder 772 is an ideal product to use for penetration and long cracks where vibration is expected.

Recommended Dispensing Equipment For Windshield Welder

- HERNON® offers a complete line of semi and fully automated dispensing equipment. Contact HERNON® Sales for additional information. www.hernon-equipment.com
Voice Coil Bonder is a single-component, heat cure adhesive designed for bonding and coating loudspeaker voice coil components. Voice Coil Bonder offers excellent resistance to high temperatures, chemicals and water. Voice Coil Bonder is applied to loudspeaker voice coil wire and passed through an oven for approximately 30 seconds to stabilize the product. When wire is ready to be coiled, acetone or MEK can be used to make Voice Coil Bonder tacky again. This system allows for more flexibility in a high speed-manufacturing environment.

Voice Coil Bonder is suitable for coating aluminum, copper-clad and copper wire coils. Voice Coil Bonder can coat a wide-variety of form materials including Kapton® H, HN, HPPST, NTB, fiberglass composite, aluminum and Nomex®. Cured Voice Coil Bonder can withstand temperatures exceeding 600°F (316°C) for today’s high-powered, small loudspeaker designs. Peel strengths of 9 pounds per square inch have been obtained in bonding Kapton® film to steel and aluminum. Flexibility is maintained through thermal shock resistance.

Voice Coil Bonder 360

Voice Coil Bonder 360 offers shear strength up to 3750 PSI on grit-blasted steel according to ISO 4587. The cured bond withstands temperatures up to 600°F (316°C).

- High temperature resistance
- Viscosity: 4000 to 6000 cP
- Excellent adhesion
- Single component

Weld Sealant is a single component anaerobic penetrating adhesive and sealant. It is designed for sealing weld seams against leakage as well as lock threaded metal fasteners that are already assembled. Weld Sealant can fill seams up to 0.127 mm wide. The anaerobic sealant seeps into voids and then cures in the absence of air to a hard thermoset plastic. The excess surface Weld Sealant can easily be wiped away. Weld Sealant can retain fluids and pressure on welded seams up to 400°F (204°C). Weld Sealant is impervious to most solvents. Welds, castings and powder metal parts can be sealed to their rupture pressure. Weld Sealant can also be used to lock assembled metal fasteners. The adhesive penetrates the threaded components and cures to prevent vibration loosening. According to ISO 10964 testing Weld Sealant has a breakaway torque greater than 60 psi and a prevailing torque greater than 170 psi. Weld Sealant is an economical choice. Only 3 milliliters are required to cover 254 cm of weld when using a 12.7 mm wide brush.

Weld Sealant 433

Weld Sealant 433 is a single component anaerobic penetrating adhesive and sealant. The primary use for Weld Sealant 433 is sealing welded metal joints, but it can also be used to lock threaded metal fasteners. Benefits include fluid and pressure retention as well as corrosion and contamination protection.

- Amber Fluorescent Liquid
- Fill Seams Up To 0.127 mm
- Temperature Resistant Up To 400°F (204°C)
- Also A Thread Sealant

Weld Seals

*3mL of low viscosity Threadlocker will cover 100 linear inches of weld when applied with a ½ inch brush.
Metal Cement 850

Metal Cement 850 is a single component, silver color paste designed for quick repairing of worn machinery parts. The compound develops a high strength polymer with superior compression strength, excellent chemical and temperature resistance. The bonded assembly often doubles the strength of press fitted parts.

- (Silver Paste)
- Fast Repairs
- (Fixtures in 10-20 minutes)
- Fast Cures at Room Temperature
- (1-3 hours without primers)
- Fills Gaps to .020" (diametric)
- A True "Have-to-Have" Product

Applications:

- Repairs worn metal parts like bushings, shafts, etc.
- Repairs worn housings, end bells, salvage severely worn parts.
- Repairs wallowed keyways in shaft and spline assemblies.
- Refills worn couplings.
- Refills loose screws, split bearings, etc.
- Use on new installations to prevent backlash and wear.
- On new installations, corrosion is minimized (no air pockets).

Special Physical Properties:

- Superior Ultimate Compression Strength; Greater than 46,000 PSI
- Shear Strength = 3,000psi (steel), 600psi on unetched aluminum

*Note: use of Primer 50 will significantly reduce cure time, but may reduce ultimate strength. Gently heat the assembly so that the bondline is subjected to a temperature of 250°F for 30 minutes for full cure. Primer is recommended to restore cure speed when used at temperatures below 50°F, and when gaps exceed .010 inches diametrically.

HERNON® offers a complete line of ultraviolet curing adhesives and compounds aptly named the Ultrabond® line of products. These products are single component systems offering either ultraviolet light or ultraviolet light & primer initiated curing mechanisms. All Ultrabond® products cure upon exposure to UV light. Twin or “dual-cure” types work in conjunction with a primer and provide production processing latitudes to maximize assembly efficiencies.

Ultrabond® 740

Ultrabond® 740 is formulated for bonding glass to glass or glass to metals. Ultrabond® 740 is excellent for bonding tacking and potting many parts. Ultrabond® 740 provides an excellent bond, high light transmittance and a refractive index similar to glass. Exposure to a high intensity UV light will cure these adhesives to a dry, hard surface.

- (Clear Liquid)
- Bonding glass to glass
- Bonding glass to metals
- Potting
- Wire tacking
- Coating

Ultrabond® 748

Ultrabond® 748 is a high temperature, dual cure anaerobic adhesive with working temperatures up to 350°F and gap filling capabilities up to .125 inch. Ultrabond® 748 provides excellent impact and fatigue resistance as well as resistance to solvents, oil and moisture.

- (Clear Liquid)
- UV or Primer 56 Cure
- High Temperature
- Bonding & Sealing
- Deep Potting

Recommended Dispensing Equipment

For Metal Cement

- Autosealer® 2600
- Autosealer® 2650
- Rambo®
- Manual and Pneumatic Guns
**Ultrabond® 752**

Ultrabond® 752 is a UV curable adhesive product that provides excellent adhesion to glass and to plastics such as polyester, PVC, cellulose acetate or nylon.

- (Amber Liquid)
- Excellent adhesion to a variety of surfaces
- Excellent environmental resistance
- Good gap filling properties
- No shrinkage due to solvent evaporation
- Rapid room temperature cure

**Ultrabond® 758**

Ultrabond® 758 is a fast fixtureing, general purpose and shallow potting compound with gap filling capabilities to .100 inch. In assembly line applications the low viscosity promotes rapid self-leveling and excellent penetration. Thermal integrity is 350°F. Ultrabond® 758 for shallow potting and encapsulation on assembly line applications.

- (Clear Liquid)
- UV Cure Only
- High Temperature
- Low Viscosity
- Shallow Potting

**Ultrabond® 786**

Ultrabond® 786 is an EB/UV curable product that provides excellent adhesion to a wide variety of substrates like metals, glass, ceramics and plastics. The sealant offers a water tight seal with excellent environmental and high impact resistance.

- (Clear to Pale Yellow Liquid)
- Metals
- Glass
- Ceramics
- High Impact Resistance

**Ultrabond® 787**

Ultrabond® 787 is designed to bond a wide-variety of substrates including glass, many plastics and most metals. Tensile strength is up to 2700 psi according to ASTM D882 testing. Ultrabond® 787 is an ultraviolet light only cure product.

- (Clear, Yellow Liquid)
- Bonds rigid and flexible PVC
- Large gap filling
- Flexible joint

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### Ultrabond® Typical Values

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<tr>
<th>Grade</th>
<th>Color</th>
<th>Viscosity, cP</th>
<th>Temperature Range, °C (°F)</th>
<th>UV Fixture Time, Seconds</th>
<th>Shear Strength, N/mm² (psi)</th>
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<td>758</td>
<td>Clear</td>
<td>300</td>
<td>-55 to 177 (-65 to 350)</td>
<td>5</td>
<td>7.5 (1087)</td>
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<td>787</td>
<td>Pale yellow</td>
<td>5,000</td>
<td>-55 to 110 (-65 to 230)</td>
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<td>23.4 (3392)</td>
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**Recommended Dispensing Equipment For Ultrabond®**

- Autobonder®, 2101
- Autobonder®, 2111
- Autobonder®, 2512

**Recommended UV Curing Equipment For Ultrabond®**

- Ultraspot®, 2000
- HERON's Ultracure Series

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**Accelerator 48**

Accelerator 48 is a solvent-based accelerator for instant adhesives. The accelerator is designed to speed the cure of cyanoacrylate adhesives. **Accelerator 48 is used where increased cure speed of cyanoacrylate adhesives is required. Especially recommended for applications involving printed circuit boards, wire tacking and/or tamper proofing of adjustable components.**

- Transparent, Colorless Liquid

**Accelerator 75**

**Accelerator 75 is a low toxicity, nonflammable, non-combustible, non-ozone depleting, low volatile organic compound (VOC) accelerator which improves instant adhesive fixing and curing performance.**

- Clear liquid

**Activator 15**

Activator 15 is designed to be used with ReAct® two-component, no-mix adhesives.

**Activator 47**

Activator 47 is a solvent-free and environmentally friendly activator designed for toughened acrylic adhesives such as ReAct®. Since Activator 47 does not contain solvents there is no waiting time for evaporation.

- Light Amber Liquid

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**Activator 56**

Activator 56 is a non-CFC solvent based activator to enhance the cure speed of HASA anaerobic structural adhesives. **Activator 56 is especially recommended on inert or passive metals or where large gaps are present.**

- Light Yellow Liquid

**Activator 59**

Activator 59 is a solvent based product specially formulated to promote the cure of adhesives. A faster fixture time and cure speed is achieved as a result of using Activator 59 depending on the adhesive used, the substrate bonded, surface cleanliness and whether one or two surface activations are used.

- Amber-Light Yellow Liquid

**Activator 63**

Light Yellow Liquid Activator 63 is a solvent-based activator for the two-component, no-mix ReAct® adhesive system.

- Light Yellow Liquid

**Adhesion Promoter 42**

Adhesion Promoter 42 is a single component surface preparation which improves the adhesion of low surface energy plastics including polyethylene, polypropylene and Santoprene®. **Adhesion Promoter 42 is formulated for use with Quantum® and Instantbond® cyanoacrylate adhesives.**

*Santoprene is a trademark of ExxonMobile Chemical
Primer 46
Primer 46 is a solvent-free primer which enhances the cure speed of anaerobic adhesives and sealants including Nuts N’ Bolts®, Dripstop®, Cylinlock®, and HASA®. Primer 46 speeds the cure on passive metals or inert surfaces as well as with large bond gaps. It is recommended for use when the ambient temperature is under 15°C (59°F).
- Blue-Green Liquid

Primer 49
Primer 49 is a single component, non-CFC solvent based primer designed to promote the cure speed of anaerobic adhesives and sealants.
- Amber Liquid

Primer 50
Primer 50 is a designed to increase the cure speed of anaerobic adhesives and sealants including Nuts N’ Bolts®, Dripstop®, and Cylinlock®. Long-term pretreatment is available with an on-part life of up to 30 days. Primer 50 is especially recommended for large gap bonds and inert metals.
- Green Liquid

Primer 57
Primer 57 is a single-component, solvent-free cure speed promoter. Primer 57 is designed for use with anaerobic adhesives and sealants to enhance cure speeds without the use of solvents.
- Green Liquid

Chemical Stripper 30
Chemical Stripper 30 is a chemical liquid that works to remove pre-cut conventional gasket cements as well as formed in place chemical gaskets. Chemical Stripper 30 lifts off baked-on gaskets, gasket cements, formed-in-place gaskets, carbon deposits, dried oils, grease and paint on any type of metal in minutes. Also suitable for use on wood. It is packaged in a convenient spray liquid that penetrates and cleans intricate shapes, but will not run off, even on vertical surfaces.

Benefits
- Reduces time and labor costs associated with difficult-to-remove old gaskets.
- Eliminates or reduces excessive scraping and potential damage to flanged surfaces.

Application Tips
- Removal of cured Gasket Replacer compound is easy. Old material scraps off cleanly and easily with a putty knife.
- Use Chemical Stripper 30 to remove old gasket cements, adhesives, shells, or sticky compounds from flange faces prior to Gasket Replacer applications.
- Use Gasket Replacer compounds to replace (form-in-place) conventional precure hard or soft gaskets. Save the day when that critical gasket is needed.
- Use Gasket Replacer compounds to “dress” conventional precut gaskets when leakage is probable due to rough, worn, porous, or pitted surfaces. Smear product on both sides of the precut gasket and assemble with confidence.

Cyanocrylate Remove 14
Cyanocrylate Remover 14 is designed to remove cured Instantbond® and Quantum® cyanocrylate adhesives from parts, clothing and dispensing equipment. Cyanocrylate Remover 14 can also be used for the reworking of bonded substrates.

- Clear Liquid

Cleaner 62
Cleaner 62 is a non-aqueous, non-CFC industrial cleaner which removes oil and grease. Cleaner 62 is suited to prepare contaminated surfaces to enhance the adhesion of adhesives and sealants.

- Black Liquid

Chemical Stripper 30
Chemical Stripper 30.

Applicaton Tips

Benefits

Cleaning

Cleaner 62
Cleaner 62

Rust Eliminator™ 32
Rust Eliminator™ 32

Application Tips

Chemical Stripper 30

Primer 46
Primer 46

Primer 50
Primer 50

Primer 49
Primer 49

Primer 57
Primer 57

Chemical Stripper 30
Chemical Stripper 30

Cyanocrylate Remover 14
Cyanocrylate Remover 14

Cleaner 62
Cleaner 62

Rust Eliminator™ 32
Rust Eliminator™ 32
### Specialty Products

**Kits & Packages**

#### Handy Kit Set
A general assortment of our most widely used adhesives. Includes: threadlocking, retaining, pipe sealing, gasketing, bonding and surface primer items.

**Kit Contains:**
- Nuts N' Bolts® 423
- Nuts N' Bolts® 425
- Metal Cement® 850
- Gasket Replacer®
- 916, Silastomer® 346
- Quantum® 138
- Primer 50

#### O-Ring Splicing Kit
Fabricate O-Rings as needed. Avoid stocking special sizes. Unique cutting fixture assures a perfect face squareness at the correct O-Ring diameter during cutting to yield perfect circles every time when bonded.

**Kit Contains:**
- Slicing Fixture & Cutting Blade
- Instantbond® 123
- Waterproofer
- Equipment Flushing Solvent
- Cord Stock, 3 feet each:
  - 3/32, 1/8, 3/16, and 1/4 inch

#### Dissipator® Kit

**Kit Contains:**
- Dissipator® 746-25ml
- Activator 63 - 1.75oz

#### ReAct® Kit 25ml

**Kit Contains:**
- ReAct® 730-25ml
- Primer 56-4oz

#### ReAct® Kit 250ml

**Kit Contains:**
- ReAct® 730-250ml
- Primer 56-4oz

#### HASA® Kit

**Kit Contains:**
- HASA® 714-50ml
- Primer 56-1.75oz

#### Gasket Kit

**Kit Contains:**
- Gasket Replacer® 916-300ml
- Primer 50-4oz

#### Needle Evaluation Kit

**Kit Contains:**
- Contains a variety of dispensing needles & plastic tips with different gauges

#### Wire Tacking

**Heavy Duty General Purpose Kit**

**Kit Contains:**
- Instantbond® 115 Adhesive 20gm
- Accelerator 52 1.75fl oz.

**Wire Tacking Heavy Duty Kit**

**Kit Contains:**
- Instantbond® 140 Adhesive 20gm
- Accelerator 52 1.75fl oz. Pump

HERNON® also offers several additional families of specialty products including Impregnation Resins, UV Formed-On-Gasket Sealants and an extensive line of Ammunition Sealants. Contact your HERNON® Sales Representative for more information about any of HERNON’s Specialty Products.

**HERNON® Porosity Sealant (HPS)**

HERNON® Porosity Sealant (HPS) is the solution to leak proofing parts. HPS offers improved machinability and surface quality for painting and plating. The hardened resins exhibit superior chemical resistance and elevated temperature stability.

The microscopic voids in the parts where potential leaks occur are filled by the low viscosity resin and sealed permanently. The parts leave the impregnating process without surface residue and can then be used in production. When used in preparation for plating or painting processes the impregnation process also eliminates absorption of plating materials like acids or painting rep solvents that could later bleed out of the pores causing finishes to discolor, blister, pit or peel. Porosity problems cause castings, powder metal parts, plastics, ceramics and other porous substrates to leak through the body. Production management is challenged to solve this problem due to increased production demands, soaring scrap costs as well as quality control. Inherently, powdered metal parts have high percentages of voids. After sintering and the loss of the wax binders, impregnation improves the machinability of sintered parts.

HPS promotes consistent (rather than intermittent) tool contact on the filled surfaces. Less shock translates into greater tool life and better dimensional control on impregnated parts. HERNON® Porosity Sealant systems offer superior stability and predictability during the impregnation process. By comparison to “classic” sealing materials like sodium silicate shows the clear performance superiority of HPS impregnation. Full and complete sealing without any limitations is the norm.

**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

**Recommended Dispensing Equipment For HERNON’s Specialty and Support Products:**
- HERNON® offers a complete line of semi and fully automated dispensing equipment. Contact HERNON® Sales for additional information. [www.hernon-equipment.com](http://www.hernon-equipment.com)
Applications:

- Oil Shaft Seals
- Engine covers
- Oil pans
- Other fluid systems

UV FOG (Ultraviolet Formed-on-Gasket) is an EB/UV curable product that provides excellent adhesion to shaft seals, oil seals, metals, glass ceramics and plastics. UV FOG is engineered to be used as a Form-in-Place gasket in oil and coolant systems. Multiple grades are available to meet many unique needs.

Hernon Manufacturing is widely regarded as the World Leader in Ammunition Sealant Technology with nearly four decades of experience in developing high performance sealants for all sizes and types of ordnance ranging from virtually all calibers of bullets, blank ammunition, shotshells and grenades to mortar rounds. HERNON’s ammunition sealants are 100% solid systems with no solvents and exceed US Army, US Navy and NATO leak tests just minutes after being applied. HERNON® also offers numerous State-of-the-Art UV LED curing components and customized dispensing and sealing solutions to be an effective single source provider and Total Solutions option for most of the leading ammunition manufacturers around the globe today.
Many HERNON® products meet or exceed the standardized objectives set by the U.S. Department of Defense. These objectives are known as military standard, mil specs, or “MIL-STD.” Please consult Customer Service for more information about test reports and certificates of conformance needs.

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### UL CLASSIFIED

**MH62248**

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**MH6228**

### Useful Conversion Factors

#### Volume

- 1 Fluid Ounce = 29.57 Cubic Centimeters
- 1 Gallon = 3785 Cubic Centimeters
- 1 Gallon = 3.785 Liters
- 1 Gallon = 128 Fluid Ounces
- 1 Gallon = 4 Quarts
- 1 Gallon = 8 Pints
- 1 Gallon = 16 Cups
- 1 Gallon = 231 Cubic Inches
- 1 Gallon = 0.134 Cubic Feet
- 1 Liter = 0.264 Gallons
- 1 Liter = 1000 Milliliters
- 1 Cubic Foot = 1728 Cubic Inches
- 1 Cubic Foot = 7.48 Gallons
- 1 Cubic Inch = 16.387 Cubic Centimeters
- 1 Cubic Centimeter = 1 Milliliter
- 1 Milliliter = 1000 Microliters
- 1 Microliter = 1000 Nanoliters

#### Weight

- 1 Kilogram = 1000 Grams
- 1 Kilogram = 2.2 Pounds
- 1 Pound = 16 Ounces
- 1 Pound = 453.6 Grams
- 1 Pound = 7000 Grams
- 1 Ounce = 28.35 Grams

#### Length

- 1 Centimeter = 10 Millimeters
- 1 Inch = 2.54 Centimeters
- 1 Inch = 1000 Mils
- 1 Foot = 30.48 Centimeters
- 1 Yard = 91.44 Centimeters
- 1 Mile = 5280 Feet
Hernon Manufacturing Inc. is an ISO-9001 registered company with a Total Solutions approach offering adhesives, sealants and dispensing equipment. Hernon® has a 40-year history and is headquartered in Sanford, Florida where it has contributed to some of the nation’s most sensitive projects including Atlas rocket systems, Excalibur ordnance systems and even nuclear submarine manufacturing. Consecutive years of double digit growth has led to a $2MM expansion of manufacturing facilities and several awards and honors such as the 2018 “CEO of the Year” award by the Orlando Business Journal and 2015 Presidential “E” Award for exports.

Overview
Company: Hernon Manufacturing Inc.
Address: 121 Tech Drive Sanford, FL. 32771
Contact: Edgardo Rodriguez
Telephone: 1 (407) 322-4000 x314
Email: EdgardoRodriguez@hernon.com
DUNS: 293050331
CAGE: 61603
Year Established: 1978

Federal Contract Vehicles and Listings
- GSA Contract: GS-21F-0168Y
- DLA Registered
- SBA Registered

NAICS
- 325520 Adhesive Manufacturing

Notable Clients:
- US Army
- US Navy
- NY City Transit Authority
- SEPTA (South East Pennsylvania Transit Authority)
- DLA Troop Support
- General Dynamics
- Lockheed Martin
- Northrop Grumman
- Boeing
- Winchester
- Peterbilt
- Combined Systems
- CBC (Companhia Brasileira de Car-tuchos)
- Ruag
- Bose
- General Motors
- Ford
- Fastenal
- ATK

Differentiators
- Adhesives and dispensing equipment are designed, manufactured and assembled in Sanford, Florida, U.S.A.
- Proven history with 39 years of continuous operation.
- Total Solutions approach: manufacturer of adhesives, sealants and the optimal dispensing and curing equipment.
- Direct contact with engineers and chemists is encouraged to develop custom adhesive solutions.
- Large selection of MILSPEC products available. Click here
- Ships world-wide including APO, FPO, DPO and FOB addresses

Recent Awards and Honors:
- 2018 Fast 50 - Orlando Business Journal
- 2018 CEO of the Year - Orlando Business Journal
- 2018 SMART Awards Finalist - Association for Corporate Growth (ACG) Orlando
- 2017 Manufacturing Leadership Award winner - Frost and Sullivan
- 2016 Small Manufacturer of the Year - Manufacturing Association of Central Florida (MACF)
- 2015 President’s “E” Award - Office Of The President Of The United States

Registrations and Certifications
- ISO 9001:2015
- ITAR - M31119
- Certifications to NSF Standards
- CID, ASTM and MILSPEC
- USDA Approved Products
- UL Classified Products
- National Stock Numbers

See all Awards and Honors by clicking here
Awards & Honors

2018 Top 100 Companies (to work for)
Orlando Sentinel
August 2018
Hernon Manufacturing, has been named to the 2018 Orlando Sentinel Top 100 Companies list! The "Top 100 Companies" program is produced by the Orlando Sentinel in partnership with Best Companies Group; an independent research firm specializing in identifying and recognizing great places to work. This survey and award program was designed to identify, recognize and honor the best places of employment in Central Florida, benefiting the region’s economy, its work force and businesses.

2018 State of Florida FAST 100
Orlando Business Journal
August 2018
Hernon Manufacturing, has been selected as a Honoree of the 2018 State of Florida FAST 100! The Fast 100 list recognizes the 100 fastest-growing private companies headquartered in the entire state of Florida. They are ranked based on the companies' percentage of growth from 2015-2017. The rankings will be revealed and the honorees will be recognized at the upcoming Fast 100 event, which will be held on September 10 at the Citrus Club in Orlando, FL.

2018 Central Florida FAST 50
Orlando Business Journal
May 2018
Hernon Manufacturing, has been selected as a member of the 2018 Central Florida FAST 50! The Fast 50 list recognizes the 50 fastest-growing private companies headquartered in Central Florida’s four county region: Orange, Seminole, Lake and Osceola. They are ranked based on the companies’ percentage of growth from 2015-2017. The rankings will be revealed and the honorees will be recognized at the upcoming Fast 50 event, which will be held on June 9.

2018 CEO of the Year
Orlando Business Journal
April 2018
Harry Arnon, CEO of Hernon Manufacturing, has been selected as a 2018 CEO of the Year by the Orlando Business Journal. The Orlando Business Journal recognizes the highest-level company executives who have had significant achievements in their careers in the past year, have a strong record of innovation, outstanding performance in their work and are actively involved in our community.

Get Expert Assistance!

If you have any questions about our products, equipment or processes, we want to hear from you! We pride ourselves on making our engineers directly available to our customers to ensure that all of their needs are met as effectively and efficiently as possible. Simply complete the form below and one of our experts will contact you as soon as possible. We will be happy to answer any questions you may have.

Please visit us today at www.hernon.com.