HERNON ISO 9001 Registered
High Performance Adhesives and Sealants

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Technical Data Sheet
Ammunition Primer Sealant 59621

Product Description

Hernon® Ammunition Primer Sealant 59621 is a single component U.V. anaerobic sealant. **Ammunition Primer Sealant 59621** is a low viscosity penetrating material for bonding and sealing primer in ammunitions. It is specially formulated for pre-assembled components; it works by capillary action and it simplifies preventive maintenance. Curing occurs when adhesive is confined between mating surfaces. The cured adhesive is a thermoset plastic suitable for temperatures up to 400ºF (204ºC), and exposure to most solvents.

Ammunition Primer Sealant 59621 cures quickly at room temperature without the need for surface activators or heat to seal, mark and identify primer assemblies. Fixturing strength develops in two to three minutes, or within 10 seconds by exposing the edge fillets to high intensity long wavelength UV light (365 nm). Full strength will be reached in 24 hours. Cure fillets at UV light irradiances above 60 milliwatts/cm² to insure proper cure.

Product Benefits

- UV fluorescence for in-process inspection
- 100% solid system (no solvents).
- Excellent environmental resistance
- Good gap filling properties.
- No shrinkage due to solvent evaporation
- Rapid room temperature cure
- UV and anaerobic curing mechanism
- Excellent capillary performance.
- Color identification

Typical Properties

Property	Value
Appearance	Red fluorescent liquid
Specific gravity	1.03
Viscosity @ 25ºC, cP	8
Anaerobic fixture time, brass, m	2 to 3 minutes
UV tack free time, s	2
Flash point	See MSDS
Temperature range, ºF	-65 to 400

General Information

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials.

For safe handling information on this product, consult the Material Safety Data Sheet (MSDS).

Where aqueous washing systems are used to clean the surfaces before bonding, it is important to check for compatibility of the washing solution with the adhesive. In some cases these aqueous washes can affect the cue and performance of the adhesive.
This product is not normally recommended for use on plastics (particularly thermoplastic materials where stress cracking of the plastic could result). It is recommended to confirm compatibility of the product with such substrates.

Directions For Use
Shake well before use.
For best performance surfaces should be clean and free of grease. **Ammunition Primer Sealant 59621** should be applied in sufficient quantity to fill all primer sealant cavities.

Disassembly and Cleanup
Non-cured sealant can be removed with **Hernon® EF® Cleaner 62.**

Storage
Ammunition Primer Sealant 59621 should be stored in a cool, dry location in unopened containers at a temperature between 46ºF to 82ºF (8ºC to 28ºC) unless otherwise labeled. Optimal storage is at the lower half of this temperature range. To prevent contamination of unused material, do not return any material to its original container.

Dispensing Equipment
Hernon offers a complete line of semi and fully automated dispensing equipment. Contact **Hernon® Sales** for additional information.