HERNON®
High Performance Adhesives and Sealants
ISO 9001 Registered

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Technical Data Sheet
Supertacker® 352

Product Description

Hernon® Supertacker® 352 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® 352** provides a tough, waterproof bond that won't crack or become brittle. **Supertacker® 352** out-performs silicones, acrylics, and rubber cement because it bonds to more surfaces with greater strength and durability.

Product Benefits

- 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

Typical Applications

- Bonding dust caps to surround and surround to basket on loudspeaker applications.
- Bonding lead wires on loudspeaker applications.
- Repair conveyor belts.
- Seal tanks and pipes.
- Insulate electrical connections and repair plastic containers.
- Mend hoses.
- Repair torn vinyl mats.
- Affix plastic moldings and trim.
- Reinforce and seal metal seams in trailers, garage doors and HVAC systems

Typical Properties (Uncured)

Property	Value
Appearance	Black liquid
Viscosity @ 25ºC, cP	50,000
Specific gravity	1.38
Solids, %	30 by weight, 40 by volume
Tack free time, minutes	5
Flash point	See MSDS

Typical Properties (Cured)

Property	Value
Tensile strength, psi, ASTM D412	3500
Elongation, %, ASTM D412	900
Hardness, Shore A, ASTM D2240	80
Dielectric strength, volts/mil, ASTM D149	400
Full Cure, thin film, hours	24
Temperature range, ºC (ºF)	-40 to 150 (-40 to 300)

Typical Cured Performance

180º Peel Strength, ASTM D903
Cured 7 Days at 22ºC

Substrate	180º Peel Strength, pli
Glass	40
Wood	29
Cement	25
Aluminum	30
Steel	25
ABS	32
Polycarbonate	37
PVC	27
Acrylic	36
Urethane	32
Rubber	20
Thermoplastic rubber	30
Neoprene	32

Typical Environmental Resistance

Chemical/Solvent Resistance

Supertacker® 352 exhibits excellent resistance to water, dilute acids and dilute bases. Thin films of **Supertacker® 352** were immersed in the chemicals/solvents listed below for two weeks and exhibited weight gains of less than 2% and tensile strength loss of less than 1%.

Chemical/Solvent	Chemical/Solvent
Acetic acid, 5%	Lactic acid, 3.8%
Acetic acid, 10%	Sodium chloride, 10%
Sulfuric acid, 3%	Sodium carbonate, 2.7%
Sulfuric acid, 10%	Potassium hydroxide, 3.4%
Nitric acid, 10%	Ammonium hydroxide, 3.4%
Nitric acid, 20%	Ammonium nitrate, 50%
Phosphoric acid, 30%	Distilled water
Phosphoric acid, 60% P_2O_5	Motor oil, 30w
Boric acid, 3.1%	Hydraulic oil
Oxalic acid, 3.1%	Antifreeze

Chemical/Solvent Non-Resistance

The following is a list of common solvents that dissolve **Supertacker® 352** when hardened samples are immersed. The dissolution with these solvents is not instantaneous and therefore does not preclude usage in all cases. Applications where an occasional splash or brief exposure is expected may be acceptable. Test a small area before full use.

Chemical/Solvent	Chemical/Solvent
Gasoline	Chlorothane NU
Cyclohexane	Chevron solvent 1100
Perchloroethylene	Propyl acetate
1,1,1-Trichlorethane	Toluene
Methylene chloride	

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).

Directions for Use

1. Surface should be clean and dry.
2. For porous surfaces (wood and concrete) apply a liberal bead of adhesive to surfaces and bond immediately.
3. For joining non-porous surfaces, apply a light coating of adhesive to each surface and allow to harden for 5 minutes. Then press both surfaces together.
4. **Supertacker® 352** hardens by solvent evaporation. At 70ºF (21ºC) the adhesive will provide significant "grab" in 5 minutes. However, normal bond lines require 24 hours and thick bond lines may require 48 to 72 hours.
5. Cure time increases with temperatures lower than 70ºF (21ºC) and decreases with temperatures above 70ºF (21ºC).
6. When finished, wipe excess adhesive from the tube neck and secure with cap.

Application Notes

1. Some substrates require light sanding for optimum adhesion.
2. As a contact adhesive: Apply **Supertacker® 352** directly to surface. Allow to partially cure, 2-10 minutes, before bringing surfaces together.
3. As a sealant: Use thin coats of **Supertacker® 352** to build up to thick coating, allowing each layer to set 3 to 4 hours.
4. Speed drying time by using a hand-held dryer. Set on low and do not hold directly on adhesive.
5. If product is used to adhere fabric, do not dry clean fabric.
6. **Supertacker® 352** is not recommended for use on Styrofoam™, polystrene, polyethylene or polypropylene plastics. Test a small area before extensive use.
7. **Supertacker® 352** is not recommended for use on aquariums.

Storage

Supertacker® 352 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.