2017

HERNON®

MANUFACTURING, INC.

ISO-9001:2008

PRODUCT CATALOG

- High Performance Adhesives and Sealants
- Precision Dispensing Systems
- UV Curing Equipment

Total Solutions

HERNON.com

121 Tech Drive, Sanford, FL 32771 **Toll Free:** 800-527-0004 **Main Phone:** 407-322-4000

Hernon Manufacturing, Inc.® has been committed to delivering TOTAL SOLUTIONS including high-performance adhesives, sealants and coatings as well as precision dispensing equipment and UV curing systems for nearly four decades. A long-time member of Central Florida's industrial manufacturing community, **Hernon Manufacturing** provides solutions for a variety of industries including: Energy and Power Generation, Medical, Electronics, Electrical, LED, Automotive, Appliances, Sporting Goods, Ammunition, Communications, Aerospace, Aviation, High Tech Audio, Defense, Fire Suppression, Transportation, Marine Manufacturing and more all with products proudly made in the United States. **Hernon Manufacturing, Inc.®** is an ISO-9001:2008, ITAR registered company whose products meet or exceed Mil-Specs.

Hernon Manufacturing offers over 5,000 different formulas.

***HERNON*'s** world headquarters is located in Sanford (Orlando), Florida, USA - a high-tech community developing aerospace, power generation, electronic, and optical solutions for the world. The Central Florida region is also the birthplace of America's presence in space through Cape Canaveral. This location allows our Research and Development team an opportunity to work side-by-side with other companies developing cutting-edge technology.

Hernon Manufacturing, Inc.® has been recognized as a top company in Orlando and recently received the 2015 Presidential "E" award for exports. ***HERNON®*** was also recognized in 2015 as a community and business leader by the Seminole County and Sanford Chambers of Commerce. In addition, ***HERNON's*** CEO, Harry Arnon, was named 2015 CEO of the year by the Orlando Business Journal for his acumen displayed by guiding **Hernon Manufacturing** to record growth and expansion despite a subdued economy. **Hernon Manufacturing** has also been recently recognized at the 2016 Bright House Regional Business Awards as a leader of New Product Development for small caliber ammunition sealing.

HERNON's rapid growth includes an increase in export sales from 6 to 50 countries in just four years. As a result, **Hernon Manufacturing** has expanded its global headquarters and production facilities by 150%! The additional space and new team members will help this consistent growth continue for many years to come!

Adhesives Category				
Performance Attributes	**Acrylics**	**Cyanoacrylates**	**Epoxies**	**Silicones**
Benefits	Good impact resistance/flexibility	Excellent adhesion to rubber or plastics	Wide range of formulations	Excellent temperature resistance
Limitations	Primer required	Low solvent resistance	Mixing required	Low strength
Typical Temperature Resistance	-65°F to 300°F	-65°F to 180°F	-65°F to 180°F	-65°F to 400°F
Highest Temperature Resistance	400°F	250°F	275°F	600°F
Environmental Resistance				
Polar Solvents (ex, H^2O, Ethylene Glycol, IPA, Acetone)	Good	Poor	Very Good	Good
Non-Polar Solvents (ex, Motor Oil, Toluene, Gasoline, ATF)	Very Good	Good	Excellent	Poor
Adhesion to Substrates				
Metals	Excellent	Very Good	Exellent	Good
Plastics	Fair	Excellent	Fair	Fair
Glass	Excellent	Poor	Excellent	Very Good
Rubber	Poor	Very Good	Fair	Good
Wood	Good	Good	Very Good	Fair
Overlapping Shear Strength	High	High	High	Low
Peel Strength	Medium	Low	Medium	Medium
Tensile Strength	High	High	High	Low
Elongation/Flexibility	Medium	Low	Low	Very High
Hardness	Semi-Rigid	Rigid	Rigid	Soft
Process Considerations				
Number of Components	2	1	2	1
Cure Temperature	Room Temp.	Room Temp.	Room Temp.	Room Temp.
Fixture Time				
Average	10 min.	60 sec.	35 min.	25 min.
Fastest	30 sec.	10 sec.	3-5 min.	10 min.
Full Cure Time	24 hours	24 hours	12-24 hours	24 hours
Gap Fill				
Ideal	0.002" - .004"	0.001" - 0.003"	0.004" - 0.006"	0.004" - 0.006"
Maximum	0.040"	0.010"	0.125"	0.240"
Dispensing/Mixing Equipment Required	No	No	Yes	No
Light Cure Versions Available?	Yes	Yes	Yes	Yes
For more information on each Adhesive (Category, refer to pages…)	3 - 8	15-22	13-14	27-28

Index

Interactive Index:
Click the links below to move directly to your selected page. Click any page number to return to the index.

Bonding

Dissipator®.....Pg 6
Thermally Conductive Room Temp Cure Adhesive

Fusionbond®.....Pg 7-8
Two Component Methacrylate Structural Adhesives

H.A.S.A.....Pg 9-10
HERNON® Anaerobic Structural Adhesives

ReAct®.....Pg 11-12
Two Part Structural Acrylic Adhesives

Supertacker®.....Pg 13-14
One Component, High Performance Elastomeric Adhesive

Tuffbond®.....Pg 15-17
Single Component And Two Part Epoxies

Cyanoacrylate

Instantbond®.....Pg 18-20
Rapid Cure Cyanoacrylate Adhesives

Quantum®.....Pg 21-23
Rapid Cure Surface-Insensitive Cyanoacrylate Adhesives

Flange Sealing

Gasket Replacer.....Pg 24-26
Anaerobic Gasket Sealing Compound

Silastomer®.....Pg 27-29
Silicone Adhesives

Thread Sealing & Locking

Dripstop®.....Pg 30-33
Anaerobic Pipe Sealants

SelfSealer®.....Pg 34-35
Pre Applied Thread Sealants

Nuts N' Bolts®.....Pg 36-44
Anaerobic Threadlockers

ThreadPaste.....Pg 45
Anaerobic Threadlocking Compound

Powerseal®.....Pg 45
Non Hardening, Instant Seal Pipe Sealants

Self Locker.....Pg 46-47
Pre Applied Thread Locker

Retaining

Cylinlock®.....Pg 48-51
Anaerobic Adhesive for Bonding and Sealing Cylindrical Surfaces

Specific Application Products

Brake Bonder.....Pg 52
Nitrile/Phenolic Solvent-Based Adhesive

Windshield Welder.....Pg 53
U.V. Curing Adhesive for Windshield Repair

Voice Coil Bonder.....Pg 54
Vibration and Heat Resistant Coating

Weld Sealant.....Pg 55
One Component Anaerobic Penetrating Adhesive/ Sealant

Metal Cement.....Pg 56
High Strength Anaerobic Compound for Quick Repairs of Cylindrical Components

UV Curing Adhesive

Ultrabond®.....Pg 57-58
U.V. Curing Adhesives and Coatings

Support Products

Accelerators.....Pg 59
Accelerates Curing Process

Activators.....Pg 59
Activates Curing Process

Adhesion Promoters.....Pg 59
Improves Adhesion for Low Surface Energy Substrates

Primers.....Pg 60
Enhances the Cure Speed of Adhesives

Chemical Stripper.....Pg 61
Chemical Remo1er And Cleaner

CA Remover.....Pg 61
Solvent to Dissolve Cured Cyanoacrylate Based Adhesives

Cleaners.....Pg 61
Non-Aqueous, Non-CFC Industrial Solvents

Rust Eliminator.....Pg 61
Chemically Transforms Rust Into An Inert Coating

Tamper-Proof.....Pg 61
Water-based Masking Product

Kits.....Pg 62
Grouped Products for Specific Applications

Specialty Products

H.P.S.....Pg 63
HERNON® Porosity Sealant/Impregnation Resins

UV FOG®.....Pg 64
Form in Place and Cure in Place Gaskets

Ammunition Sealant.....Pg 64
Dual Cure (UV/Anaerobic) Ammunition Waterproofing Sealants

Tuffbond 323.....Pg 63
Two Component Flexible Epoxy

Equipment Information

Dispensing and UV Curing Equipment.....Pg 65

Miscellaneous Information

Military Specifications.....Pg 66
MIL-SPEC Compliant Products

NSF / UL Approvals.....Pg 67
Approved by the National Sanitation Foundation and Third Party Approved by Underwriters Laboratories

Charts.....Pg 67
Helpful Charts and Conversions

GSA.....Pg 68-69
Capabilities Statement for Government Customers

Awards & Contact Us

Awards and Honors.....Pg 70-71

Product Videos

Product Videos.....www.youtube.com/hernon

Index

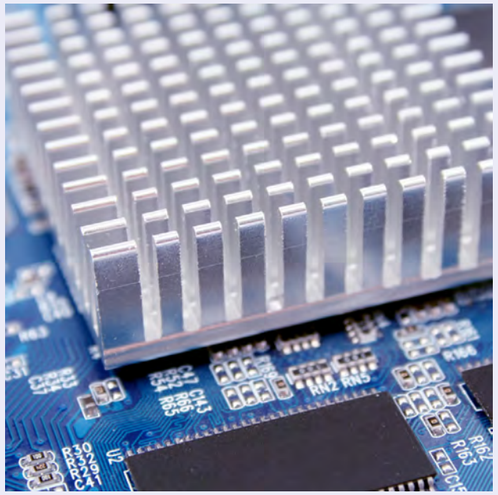
Interactive Index:
Click the links on the right to move directly to your selected page. Click any page number to return to the index.

Roger Alvarez
Quality Specialist

Contact Us!

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.

Click Here



Thermally Conductive Acrylics

Dissipator® structural acrylics provide specific adhesion for bonding electrical heat sink components with high thermal conductivity. Heat trapped and not dissipated by the components can lead to premature component failure and costly repair and replacement. Thermal conductivity is assured and electrical shorting is prevented by the insulation characteristics of the adhesives. The acrylic adhesives replace mechanical devices and silicone greases that can trap contaminants.

Typical Dissipator® Values

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

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 .005 - .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.

Recommended Dispensing Equipment For Dissipator®

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

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° to 121°C (-67° 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.

Fusionbond® Typical Values

	Color		Viscosity, cP					Mixed 1:1		
Grade	Part A	Part B	Part A	Part B	Temp. Range, °C (°F)	Fixture Time, Minutes	Gap Fill, mm (in.)	Shear Strength, N/mm² (psi)	Working Life, Min.	Hardness, Shore D
370	White	Blue	40,000 to 64,000	40,000 to 64,000	-55 to 121 (-67 to 250)	10 to 15	9.65 (0.38)	≥ 3000	10 to 15	75 to 80
371	White	Off-white	40,000 to 64,000	40,000 to 64,000	-55 to 121 (-67 to 250)	10 to 15	9.65 (0.38)	≥ 3000	15 to 30	75 to 80
372	White	Blue	30,000 to 50,000	30,000 to 50,000	-55 to 121 (-67 to 250)	10 to 12	9.65 (0.38)	≥ 3000	15 to 20	60 to 70
374	Amber	-	40,000 to 64,000	-	-55 to 121 (-67 to 250)	4 to 6	9.65 (0.38)	≥ 3000	4-6	-
375	Yellow	Blue	40,000 to 64,000	40,000 to 64,000	-55 to 121 (-67 to 250)	7 to 10	9.65 (0.38)	≥ 3000	4 to 6	75 to 80
37784	White	Blue	7,000 to 9,000	7,000 to 9,000	-55 to 121 (-67 to 250)	10 to 15	9.65 (0.38)	≥ 3000	5 to 10	75 to 80

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.

Fusionbond® 375

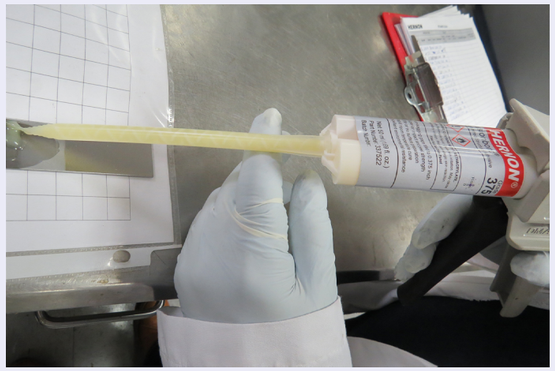
Fusionbond® 375 is formulated for bonding PVC, acrylic, ABS, stainless steel, and some type of fiberglass. **Fusionbond® 375** fixtures quickly in 7 to 10 minutes at room temperature to form a resilient and high-strength bond.

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

Fusionbond® 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



Recommended Dispensing Equipment For Fusionbond®

- Autobonder 2700
- Autobonder 2040
- Manual and Pneumatic Guns

HERNON® offers a complete line of structural anaerobics, the **HASA (*HERNON*® 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 .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 fixturing times and high production rates. Cured **HASA** materials are highly cross-linked structural thermoset plastics with excellent properties over a broad range of operational conditions.

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. EF Primer 56 accelerates the cure.

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 716

HASA 716 is a fast curing moderate viscosity structural anaerobic adhesive with gap filling capability to 0.015". **HASA 716** is an ideal production line adhesive providing quick cures on glass, ceramics, metal and thermoplastics, and reaches handling strengths in 30 seconds with primer application. Quick curing reduces in-process "float" times with shorter clamping and fixturing phases. This product delivers the highest tensile shear strength, excellent impact resistance and temperature integrity to 250°F.

Applications:

- Metal to thermoplastic
- Speaker magnets to housings and frames
- Wood and plastic components, arrowheads
- Fans to shafts (motors)
- Stemware
- Repair of cracked or broken ferrite magnets

HASA 722

HASA 722 is a single-component, anaerobic, structural adhesive designed for bonding rigid assemblies. **HASA 722** cure is accomplished when mating surfaces including metal, glass and ceramics are joined together.

Accelerated cures are possible with the application of primers or by a short, low temperature heat cycle. Upon cure, **HASA 722** is a highly cross linked thermoset plastic 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. EF® 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.

HASA® 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 HASA®

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

HASA Typical Values							
Grade	Color	Viscosity cP	Temp. Range, ºC (ºF)	Fixture Time at 22°C	Gap Fill, mm (in.)	Shear Strength, N/mm² (psi)	Recommended EF® Primer / Activator
714	Amber	1, 100	-55 to 121 (-65 to 400)	30	0.003	>10.0 (>1450)	EF® Primer 56
716	Amber	2,800	-55 to 121 (-65 to 250)	30 seconds	0.381 (0.015)	>10.3 (>1500)	EF® Primer 50
722	Amber	10,000	-55 to 105 (-65 to 221)	30 seconds	0.508 (0.020)	>10.3 (>1500)	EF® Primer 50
66071	Amber	16,000	-55 to 121 (-65 to 240)	20 seconds	0.381 (0.015)	>10.3 (>1500)	EF® Primer 50

Take your manufacturing to the next level with customized dispensing systems. *HERNON*® specializes in solving problems with a unique Total Solutions approach. By manufacturing both the adhesive materials in this catalog and building custom dispensing solutions, *HERNON*'s expert engineers can retrofit specialized manufacturing solutions into your assembly line with a precision that can't be matched by companies that only make a part of the solution.

The **ReAct®** family is a series of two part structural adhesives which feature the speed, versatility and incredible shear strength of acrylic adhesives. **ReAct®** offers high peel and flexure strength in a convenient two-component, no-mix system.

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® 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® 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 EF® 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

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® 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 EF® 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.

- (Translucent)
- High temperature resistance
- High impact and shock resistance
- Good gap filling properties
- Excellent adhesion to a variety of surfaces.
- Fast fixture times
- No pot life, no mixing
- Thixotropic

Applications

- 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.

ReAct® 784

Hernon 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 2511
- Manual and Pneumatic Guns

ReAct Typical Values

Grade	Color	Viscosity cP	Temperature Range °C (°F)	Fixture Time at 22°C	Gap Fill mm (in.)	Recommended EF® Primer / Activator
727	Off-White	55,000 to 65,000	-40 to 149 (-40 to 300)	25 seconds	0.508 (0.020)	EF® Activator 56
730	Light yellow	45,000 to 90,000	-51 to 121 (-60 to 250)	3 minutes	0.762 (0.030)	EF® Activator 56 or 59
761	Pale yellow	75,000 to 130,000	-40 to 204 (-40 to 400)	3 minutes	0.508 (0.020)	EF® Activator 59 or 63
766	Clear-yellow	70,000 to 90,000	-40 to 204 (-40 to 400)	3 minutes	0.508 (0.020)	EF® Activator 59 or 63
767	Off-White	50,000 to 70,000	-40 to 149 (-40 to 300)	25 seconds	0.508 (0.020)	EF® Activator 56
784	White	40,000 to 64,000	-55 to 121 (-65 to 250)	8 minutes	0.508 (0.020)	EF® Activator 15

Supertacker® is one of the most versatile elastomeric adhesives available. **Supertacker®** exhibits excellent bonding characteristics while providing a tough, waterproof bond that will not crack or become brittle. It outperforms silicones, acrylics and rubber cements with greater strength, durability and surface versatility.

Supertacker® is resistant to a wide-variety of chemicals and environments. It is impervious to dilute acids and dilute caustics and can be submerged in fresh or salt water once it is completely cured. **Supertacker®** is great for bonding objects subject to wear due to abrasion resistance. The temperature environmental range is from –40°C to 150°C (-40°F to 300°F). **Supertacker®** remains flexible in all weather conditions and it can be painted to match surrounding surfaces.

Supertacker® offers advanced strength characteristics including tensile strength up to 3500 psi according to ASTM D412 test standard. **Supertacker®** also offers superior peel strengths ranging from 30 psi on thermoplastic rubber to 40 psi on glass (ASTM D903). Electric dielectric strength is up to 400 volts/mil (ASTM D149).

Applications for **Supertacker®** range from bonding lead wires to loudspeakers to sealing tanks and pipes as well as repairing conveyor belts.

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** provides a tough, waterproof bond that won't crack or become brittle. **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

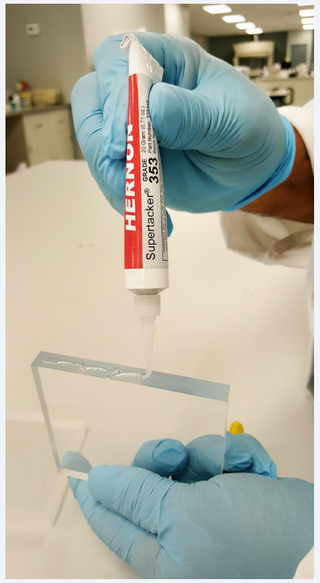
Supertacker® 352

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 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 surroundingarea or make UV-resistant
- Excellent resistance to dilute acids and dilute caustics

Supertacker® Typical Values

Grade	Color	Viscosity, cP	Temperature Range, Continuous, °C (°F)	Tack Free Time/ Full Cure at 75°F	Hardness, Shore A	% Elongation
351	Clear	50,000	-40 to 150 (-40 to 300)	5 minutes / 24 hours	80	900
352	Black	50,000	-40 to 150 (-40 to 300)	5 minutes / 24 hours	80	900
353	Clear	11,000	-40 to 150 (-40 to 300)	5 minutes / 24 hours	80	900
357	Clear	100,000	-40 to 150 (-40 to 300)	5 minutes / 24 hours	80	900



Supertacker® 353

Supertacker® 353 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® 353** provides a tough, waterproof bond that won't crack or become brittle. **Supertacker® 353** out-performs silicones, acrylics and rubber cement because it bonds to more surfaces with greater strength and durability.

- (Clear Liquid)
- Viscosity 11,000 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

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** is thicker, high viscosity sealant for vertical and overhead applications.

- (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

Recommended Dispensing Equipment For Supertacker®

- Autosealer 2650
- Autobonder 2101
- Manual and Pneumatic Guns
- Autosealer 2600-850
- Autobonder 2111
- Autosealer 2600
- Rambo

Tuffbond® epoxies present a full selection of single and two-component adhesives. **Tuffbond®** epoxies provide superior strength in addition to excellent moisture, chemical and heat resistance. **Tuffbond®** epoxies are 100% solids and can be customized for specific applications. The available curing mechanisms include two-component reactive cures and single component heat curing options.

- Multiple Cure Options
- 100% Solid – Solvent Free
- Wide Range Of Fixture Times

Heat Cure Tuffbond® Typical Values

Grade	Color	Viscosity cP	Temperature Range, ºC (ºF)	Optimum Cure	Shear Strength, N/mm² (psi)
309	Black	245,000	-54 to 177 (-65 to 350)	10 to 12 minutes at 149°C	11.7 (1700)

Tuffbond® Typical Values

Grade	Color	Viscosity cP	Temperature Range, ºC (ºF)	Hardness, Shore D	Shear Strength, N/mm² (psi)
394	Amber	50,000	-54 to 177 (-65 to 350)	80-85	>10.34 (>1500)
395	Light Amber	320,000	-54 to 177 (-65 to 350)	85-90	>10.34 (>1500)

Two-Part Tuffbond® Typical Values

Grade	Color	Viscosity cP	Temperature Range, ºC (ºF)	Working Life (100g), Minutes	Hardness, Shore D	Shear Strength, N/mm² (psi)
Ratio			Mixed 1:1	Mixed 1:1	Mixed 1:1	Mixed 1:1
302A	Clear	50,000	-54 to 82 (-65 to 180)	3	86	16.6 (2400)
302B	Light Amber	50,000	-54 to 82 (-65 to 180)	3	86	16.6 (2400)
305A	Clear	15,000	-54 to 82 (-65 to 180)	3	86	16.6 (2400)
305B	Yellow	15,000	-54 to 82 (-65 to 180)	3	86	16.6 (2400)
313A	Clear	21,500	-54 to 149 (-65 to 300)	50	79	22.1 (3200)
313B	Amber	21,500	-54 to 149 (-65 to 300)	50	79	22.1 (3200)
315A	Clear	13,000,000	-54 to 135 (-65 to 275)	15	75	>13.78 (>2000)
315B	Yellow	7,000,000	-54 to 135 (-65 to 275)	15	75	>13.78 (>2000)
316A	Black	12,000	-54 to 135 (-65 to 275)	90	82	15.9 (2300)
316B	Amber	10,000	-54 to 135 (-65 to 275)	90	82	15.9 (2300)
317A	Clear	12,000	-54 to 135 (-65 to 275)	90	82	15.9 (2300)
317B	Amber	10,000	-54 to 135 (-65 to 275)	90	82	15.9 (2300)

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.

Tuffbond® 305

General-purpose two-part epoxy. Fixtures in 4-6 minutes at room temperature. Full cure in 1 hour. Use to 220°F.

Tuffbond® 308

Tuffbond® 308 is a specially formulated, low chlorine, single component epoxy system which cures at temperatures of 212ºF (100ºC) and above. **Tuffbond® 308** is suitable for potting and encapsulation of electrical and electronic components. It has excellent storage stability and produces tough, flexible bonds with superior shear strengths when used on metals, ceramics and many plastics. Optimum strength can be obtained after ten to fifteen minutes cure at 300ºF (149ºC).

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 80 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

Two-part epoxy with variable mix ratio – cured bonds can be tough and flexible or hard and rigid – depending on ratio. Fixtures in 40 minutes. Clamp parts during cure. Full cure in 24 hours. Temperature limit is 275°F

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 150ºC 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 150ºC 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 250º to 300ºF range. The hardened adhesive is electrically insulative and heat conductive.

Applications

- Bonding drain valves
- Bonding wastewater treatment valves
- Potting components

Benefits

- Convenient mixing
- Solid, No Solvent
- Low Shrinkage
- Superior durability
- 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 multiples uses. **Tuffbond® 23932** is recommended for bonding metals, rubber, wood, ceramics, etc., and can be used for potting and encapsulation of components.

Applications

- Bonding drain valves
- Bonding wastewater treatment valves
- Potting components

Benefits

- Low shrinkage
- 100% reactive, non-solvent system
- Easy mixing ratio of resin and hardener
- No fuming on gelation
- Excellent chemical resistance
- Excellent water resistance

Recommended Dispensing Equipment For Tuffbond®

- Autobonder 2700
- Autobonder 2040
- Manual and Pneumatic Guns

Tuffbond® 47771

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

Applications

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

Benefits

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

Tuffbond® epoxies offer substantial moisture, chemical, and heat resistance.

Classic cyanoacrylates are represented by the ethyl and methyl chemistries. Generally, the methyls offer better bond strengths on metals, the ethyls providing better strengths on everything else. Substrate selection and bond line configuration directly influence adhesive performance. For example, two polished bare metal surfaces are best bonded with a methyl grade. By comparison, better results would be generated by an ethyl grade when bonding a single bare metal surface, such as an emblem to an automobile fender. Why? The automobile fender is painted, and while composed of metal, the adhesive is in contact with the acrylic paint layer, a plastic surface. To summarize; use methyls when bonding bare metal-to-metal, ethyls for everything else. Surface chemistry plays an important role in the cure of the classic cyanoacrylate adhesives. Instantbond grades cure as the result of contact with trace amounts of moisture. The reaction is called ionic polymerization. Any surface capable of absorbing moisture is a good surface for bonding. The water molecule is V-shaped and orients itself so that the two halves represent two OH- or "weak" hydroxyl groups. Instantbond cyanoacrylates require sufficient atmospheric moisture to cure or catalyze the liquid adhesive.

The **Instantbond** formulations cure best when surface pH is slightly alkaline or over 7.0. Poor bonding performance results on acidic surfaces such as: plastics and rubber covered by mold release gents, platings, wood and leather. These surface conditions should be viewed as limitations for the **Instantbond** cyanoacrylate types. *HERNON*'s **Quantum®** cyanoacrylates, discussed later, are formulated to overcome such limitations. Adhesive viscosity plays a vital role in the fixture time of cyanoacrylates. The lower the viscosity, the quicker the adhesive will fixture. The higher the viscosity, the slower the bonding action. Water has a viscosity of 1 centipoise (cP), and very thick maple syrup has a viscosity of approximately 2,500cP. Fillers can be added to the adhesive to create a "gel" or jelly-like consistency. Gels do not flow like liquids and can be easily used on vertical or overhead surfaces without migration.

Gap fill ability is directly related to the viscosity of the adhesive. Low viscosity adhesives have small gap filling capabilities. High viscosity adhesives have greater gap filling abilities. Gel grades have excellent gap filling properties. Use of cyanoacrylate accelerators can enhance gap-filling abilities. Cyanoacrylates are 100% adhesive and contain no solvents. However, cyanoacrylate particles can become airborne and can settle on surfaces during cure leaving a white residue. The action is called "blooming". Blooming is minimized by adequate ventilation at the bond line, selection of special chemistries and the use of Accelerators. Less is better. Always use cyanoacrylates sparingly. One drop is sufficient for bonding approximately one square inch of surface.

Typical Applications Ethyl Grades:

- Plastic and metal combinations
- Electronic components
- Toys, sporting goods
- Components of cosmetics packaging
- Speaker sub assembly
- Coil termination
- Attachment of rubber feet, grommets, and bumpers
- Permanent locking of plastic fasteners
- Attachment of weather stripping, air seals

Quantum® Benefits

- Near Instant Curing
- Simple No-Mix, Single-Component Application
- Cost Savings Over Mechanical Fasteners

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.

Approximate Number of Free-Fall Drops per milliliter from Standard Packaging

Viscosity (cP)	Drops/mL	Drops/lb.
1-100	100	42,800
100-1,000	70	29,960
1,000-5,000	50	21,400
5,000-10,000	30	12,840

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.

Instantbond Typical Values

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

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® 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

The **Quantum®** group of cyanoacrylates offers specialized performance attributes. This range of grades has been engineered to provide solutions to specific cyanoacrylate challenges. Three categories are offered: surface insensitive, toughened and low odor / low blooming. These products have specially modified formulations to eliminate vapor transmissions and adhesive residue that can settle on parts during curing and can therefore be used in poorly ventilated assemblies.

Surface insensitive grades function in environments hostile to the “classic” cyanoacrylates. These formulations will bond acidic, freshly plated, leather and wooden surfaces. Plastic and rubber parts not bondable with “regular” cyanoacrylates are bonded with surface insensitive types. Porous materials also respond well to this category of adhesives. The Quantum family is the best choice for bonding composite and exotic combinations of materials. Atmospheric moisture can be near zero when working with these products.

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® 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 fixturing 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 state-of-the-art, 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. **Quantum® 73421** develops handling strength within seconds and full functional strength in a few hours. **Quantum® 73421** can bond a wide variety of surfaces including metals, thermoplastics, elastomers, ceramics, leather, cork and paper, but is particularly suited for bonding typically hard-to-bond substrates. NOT recommended for long-term glass to glass bonding applications.

Applications

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

Quantum® Typical Values

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

Quantum® 80122

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

Applications

- On porous substrates such as wood, leather and foamed plastic or rubber
- Rapid bonding of a wide range of metal, plastic or elastomeric materials
- Acidic surfaces such as on dichromate or freshly plated parts

Recommended Dispensing Equipment For Quantum®

- Autobonder 2101
- Autobonder 2111
- Autobonder 2511
- Sureshot Valves: 2200, 3000, 3200, 4000T

The toughened grades have been modified with plasticizers to extend the impact, tensile shear, and stress resistance of the cyanoacrylates. Classic cyanoacrylates exhibit relative brittleness. Flexible CAs deliver strength and superior toughness. The toughened flexibility allows bonds to withstand severe thermal cycling on dissimilar substrate joints. Best for high impact and shock loaded applications, severe thermal cycling, high humidity, and peeling-load conditions. Good replacements for epoxies in many applications. Real problem solvers.

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

				Cure Speed, Hours		Gap Fill, mm (in.)		
Grade	Color	Viscosity cP	Temperature Range, ºC (ºF)	Unprimed	Primed	Unprimed	Primed	Recommended EF® Primer
906	Red	400,000 to 600,000	-55 to 150 (-65 to 300)	9 to 24	0.5 to 4	0.254 (0.010)	1.27 (0.050)	49 or 50
907	Red	165,000 to 500,000	-55 to 150 (-65 to 400)	4 to 24	0.5 to 4	0.254 (0.010)	0.508 (0.020)	49 or 50
910	Purple	700,000 to 1,700,000	-55 to 150 (-65 to 300)	1 to 12	0.25 to 2	0.254 (0.010)	1.27 (0.050)	49 or 50
916	Red	500,000 to 1,000,000	-55 to 150 (-65 to 300)	4 to 24	0.5 to 4	0.254 (0.010)	1.27 (0.050)	49 or 50

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

Recommended Dispensing Equipment For Gasket Replacer

- Autosealer 2650
- Autosealer 2600-850
- Autosealer 2600
- Rambo
- Manual and Pneumatic Guns

Bead Size and Length for Gasket Replacer Package Sizes		
Container Size	Bead Diameter (inches)	Bead Length (inches)
50ml Tube	.250	62
	.130	250
	.060	1,000
100ml Tube	.250	125
	.130	500
	.060	2,000
250ml Tube	.250	310
	.130	1,250
	.060	10,000
300ml Cartridge	.250	375
	.130	1,500
	.060	6,000
850ml Cartridge	.250	1,060
	.130	4,250
	.060	17,100
10 Liter Pail	.250	12,400
	.130	50,000
	.060	400,000

Silastomer® • Silicone Rubber Adhesives/Sealants • Sealing & Bonding

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®** adhesives 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. **EF 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 400ºF.

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 400ºF.

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® 336

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 400ºF.

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® 340

Silastomer® 340 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 ovens, heat treat units, dust collectors
- Humidifier gaskets
- Seal thermocouples, probes, elements

Silastomer® 343

Silastomer® 343 is a special advanced chemistry silicone adhesive. This grade does not have a vinegar odor like general-purpose silicones. **Silastomer® 343** is superior to other silicone compounds for use on electrical and electronic applications. The unique non-acidic chemistry does not attack or discolor copper or copper containing alloys. These grades offer compatibility with a wide range of surfaces, including: stone, masonry, ceramics, marble, wood, glass, copper, brass, bronze, steel aluminum, and many plastics.

Product Benefits

- Advance Chemistry
- Non-Corrosive
- No Vinegar Odor

Applications:

- Electronics & Electrical Applications
- Mount & seal meters and movements
- Seal and insulate circuit boxes, junction
- 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

Silastomer® Grade Details

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

HERNON's line of **Dripstop®** sealants for plumbing, refrigeration and hydraulics are engineered with many advantages over conventional pipe dopes. These materials harden without shrinkage in the joints creating a tough, insoluble, vibration proof seal that will not leak even if threads are damaged.

Dripstop® sealants are 100% active containing no solvents to evaporate. They do not shred like tape dope and they 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 (ie: threaded together), the plastic shim 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® tape, 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 cost. The Teflon® content in **Dripstop®** lubricates the threads during make-up and prevents galling and assures smooth disassembly.

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

Applications:

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

Dripstop® 921

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

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

Applications:

- Seals and locks most hydraulic an pneumatic fittings up to a 1" diameter. Seals and locks pipe threads and fittings up to a 1" diameter.
- Seals and locks fasteners subject to vibration and shock or corrosive and harsh environments.

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. **Dripstop® 923** delivers temperature integrity to 300°F continuous and intermittent exposures to 375°F are tolerated.

- (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.

- (White Paste)
- Designed for electrical power plants
- Lubricated for decreased galling
- Anaerobic cure

Applications:

- Electrical power generation plants

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.

- (White Paste)
- Instant seal
- Lubricates parts for easy assembly
- Prevents galling on stainless steel, aluminum and other metal pipe fittings

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 pipe threads and fittings. **Dripstop® 930** provides instant low pressure sealing and cures to 100% solid resin for a leak-proof seal that out performs traditional pipe dopes and threaded tape. Cured compound is solvent resistant and can withstand temperatures to 204ºC (400ºF).

- (White Paste)
- Designed for electrical power plants
- Lubricated for decreased galling
- Anaerobic cure

Applications:

- Pneumatic, hydraulic and fuel line fittings

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.

- (White Paste)
- **Dripstop® 940 is approved for DEF industry**
- **Dripstop® 940 is NSF and UL Approved**
- High Performance
- Stainless Steel Sealing
- Teflon® Filled
- Temperatures to 400°F

Applications:

- Plated flare fittings
- Pulp and paper mills
- Refinery piping
- Instrumentation fittings
- Waste treatment plants
- Textile equipment
- Piping for chlorine & caustic sodas

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.

- (Yellow Florescent Liquid)
- Effectively seals industrial fluids and gases
- Does not shrink or crack due to solvent evaporation
- (100% solid system)
- Ready to use single component
- Room temperature cure

Applications:

- Hydraulic systems
- Pneumatic fittings
- Chemical processing systems
- Air conditioners

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
- Safely and completely disperses in most hydraulic fluids

Applications:

- Hydraulic systems
- Pneumatic systems
- Refrigeration equipment
- Steam fittings up to 350°F

Dripstop® Usage Economy	
Fitting Size (NPT)	**Fittings per 50 ml Tube**
1/8”	400
1/4”	200
3/8”	135
1/2”	100
3/4”	65
1”	50

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
- Dose not shrink or crack due to solvent
- evaporation
- Ready to use, single component
- Room temperature cure

Applications:

- Hydraulic systems
- Air tioners
- 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

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 ¼” NPT threads.

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

Applications:

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

Treating Pipe Fittings with Dripstop® (Number of milliliters required to treat 1000 pipe fittings)		
Fitting Size*	Tumble Applied	Manual Application
1/8	25	40
1/4	45	60
3/8	60	90
1/2	90	130
3/4	190	250
1	360	440

Recommended Dispensing Equipment For Dripstop®

- Autosealer 2650
- Autosealer 2600-850
- Autosealer 2600
- Rambo
- Manual and Pneumatic Guns

The Autosealer® 2650 from *HERNON®* is ideal for dispensing Dripstop®

Dripstop® Typical Values

Grade	Color	Viscosity cP	Temperature Range, ºC (ºF)	Pressure Resistance, PSI	Breakaway Torque N•m (in-lbs)	Recommended EF® Primer
920	White	350,000	-55 to 204 (-65 to 400)	10,000	>0.6 (5)	49 or 50
921	Yellow	70,000	-73 to 149 (-100 to 300)	10,000	>11.3 (100)	49 or 50
923	White	300,000	-55 to 150 (-65 to 300)	10,000	>2.8 (25)	49 or 50
927	White	450,000	-55 to 204 (-65 to 400)	10,000	>5.6 (50)	49 or 50
929	White	400,000	-55 to 204 (-65 to 400)	10,000	>5.6 (50)	49 or 50
930	White	130,000	-55 to 204 (-65 to 400)	10,000	>2.8 (25)	49 or 50
940	White	550,000	-55 to 204 (-65 to 400)	10,000	>1.7 (15)	49 or 50
943	Yellow	175	-55 to 150 (-65 to 300)	10,000	>2.3 (20)	49 or 50
944	Browm	2,000	-55 to 150 (-65 to 300)	10,000	>2.8 (25)	49 or 50
945	Brown	500	-55 to 150 (-65 to 300)	10,000	>2.8 (24)	49 or 50
946	Brown	600	-55 to 150 (-65 to 300)	10,000	>15 (130)	49 or 50
947	Brown	14,000	-55 to 150 (-65 to 300)	10,000	>2.3 (20)	49 or 50
950	Light Green	1,000,000	-240 to 204 (-400 to 400)	10,000	Non-curing	Non-curing

*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, 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® 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.
- The preapplied coating is tough, resilient and resists 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.

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

Apply by Tumbling, Hand Application, or Brush "Flow" **SelfSealer® 604 and 618** are essentially the same with the exception of color. White is chosen for a "pipe sealant" look, and orange selected for an obvious indication of the presence of the special coating. The difference is strictly cosmetic. With the low viscosity grades, parts can be effectively tumbled with the SelfSealer® as a simple means of coating the threads. Similarly, parts can be placed into plastic bags and shaken to apply the coating. Low viscosity types can be hand applied and brushed onto the thread path.

- (White Liquid)
- (Orange Liquid)
- Low Viscosity Types

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 nonlocking 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®

Pipe Size*	Coating Width*	mL/1,000 Parts
1/16	5/16	30
1/8	3/8	50
1/4	7/16	112
3/8	1/2	155
1/2	9/16	285
3/4	5/8	400
1	3/4	725
1 1/4	13/16	980
1 1/2	7/8	1,150
2	1 1/16	1,525
2 1/2	1 1/8	3,225
3	1/8	4,000

*Values are based on machine treating fasteners with SelfSealer with a bond width of 1.5" X Diameter
*Usage is based on grams per 1,000 fasteners

SelfSealer® 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 2650
- Autosealer 2600-850
- Autosealer 2600
- 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.

Nuts N' Bolts® 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
- Seal porosity in welds, castings and powdered metal parts

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.

- 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® 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 which require 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® 240

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® 248

Nuts N' Bolts® 248 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®

Nuts N' Bolts® 410

Nuts N' Bolts® 410 is a single component, low viscosity 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 porosities 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® 418

Nuts N' Bolts® 418 is a single component anaerobic adhesive/sealant that is formulated for applications where a low viscosity, medium strength thread locker is desired.

- (Blue fluorescent liquid)

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

Nuts N' Bolts® 420

Nuts N' Bolts® 420 is engineered to eliminate vibrational loosening of set screws, cap screws and machine screws while allowing for easy disassembly or adjustment. It is recommended for fasteners with engagement L/D ratios of one or greater. This grade replaces expensive mechanical locking devices. The low strength characteristic of **Nuts N' Bolts® 420** allows easy adjustments of assembled parts with simple hand tools. It is non-migrating with predictable torque/tension and lubricity characteristics.

- (Purple Liquid)
- Small Diameter Fasteners
- Low Strength for Easy
- Adjustments or Disassembly
- Easy Removal with Simple Hand Tools

Applications:

- Adjustment screws
- Machine screws
- Calibration 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 ¼" or larger fasteners. Removable with hand tools. Curing occurs only when adhesive is confined between two mating surfaces. The cured adhesive is a thermoset plastic suitable for temperatures up to 300°F (149°C) and exposure to solvents.

- (Blue Fluorescent Liquid)
- High Temperature Resistance
- Prevents Movement of Screw Threads and Eliminates Self Loosening
- Seals Against leakage
- Prevents Rusting of Threads
- Cures Without Cracking or Shrinking

Applications:

- Hydraulic piston nuts
- Mounting bolts on motors, pumps, etc
- Railroad bolts on wear plates
- Carburetor adjusting screws
- Machinery keys
- Machine tool access bolts
- Conveyer 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 torquing characteristics. Treated fasteners are vibration and shockproof and resist solvents, lubricants and other foreign agents that might damage internal parts.

- (Blue Liquid)
- All Fasteners
- Medium Strength For Many General Applications

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 300ºF (150ºC).

- (Green fluorescent liquid)
- Ease Of Application
- Improved Reliability

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.

- (Red Liquid)
- Heavy Duty Fasteners
- High Strength with Predictable
- Lubricity and Torque/Tension

Applications:

- Refrigeration hardware
- Differential case bolts
- Railroad traction; motor mounting bolts
- Transmission loader bolts
- Heavy equipment studs
- G rade 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.

- (Green Liquid)
- Maximum Strength
- Severe Service
- Heavy Duty Studs

Applications:

- Motor housing studs
- Machine base studs
- Nuts onto 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 and gases. (*Registered Trademark, DuPont Co.)

- (Red Liquid)
- High Strength
- Sealing in Corrosive
- Environments & Refrigeration

Applications:

- Flange plate bolts and pump housing
- Transmission studs
- Valve seats
- Air conditioning, refrigeration and process 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 pitonrods
- Axle, front end, suspension frame bolts
- Conveyor 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® 433 / Weld Sealant 433

Weld Sealant 433 is a single component anaerobic penetrating adhesive and sealant. Utilizing capillary action, **Weld Sealant 433** penetrates and seals porosities and cracks as large as 0.127 mm. Once confined away from air **Weld Sealant 433** 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.

Nuts N' Bolts® 434

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

Nuts N' Bolts®

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

Number of milliliters required to treat nuts and bolts per 1,000 pieces

Bolt Size*	Manual Application From Bottle	Automated Application Equipment
1/4	27	17
5/16	45	30
3/8	75	50
7/16	105	70
1/2	135	90
9/16	180	120
5/8	225	150
3/4	340	130

Treating Screws by Tumbling Method with Nuts n' Bolts® & Self Lockers™
Number of milliliters required to treat 1,000 pieces of round head screws by tumbling

Diameter / Length	2	3	4	5	6	8	8	12	1/4	5/16	3/8	1/2
1/8	2	2	3	3	3	4	4	-	-	-	-	-
1/4	3	3	4	5	6	7	7	10	13	-	-	-
3/8	4	4	5	6	7	9	9	13	16	22	-	-
1/2	5	6	6	7	9	10	10	15	18	25	32	-
3/4	7	8	9	10	12	14	14	80	2	32	41	55
1	9	10	10	13	15	18	18	25	30	38	49	66
1 1/2	-	-	16	19	21	25	25	34	41	53	66	87
2	-	-	-	24	28	33	33	44	52	65	83	110
3	-	-	-	-	-	47	47	63	75	94	120	140

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

* Tested on M10 Zinc Phosphate Nuts and Bolts

Recommended Dispensing Equipment For Nuts N' Bolts®

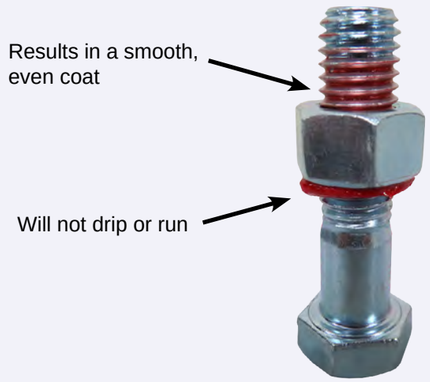
- Autosealer 2650
- Autosealer 2600-850
- Autosealer 2600
- Rambo
- Manual and Pneumatic Guns

ThreadPaste 432

ThreadPaste 432 is a single-component, anaerobic, threadlocking compound designed for heavy duty applications subject to operating temperatures to 450ºF (232ºC). 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, nonflammable 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.

Recommended Dispensing Equipment For Powerseal®

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

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

Self Locker products are preapplied, micro encapsulated anaerobic thread locking compounds that stay dry to the touch until the shearing action of thread engagement breaks the capsules and allows the released adhesive to begin to cure. Self Locker products provide resistance to vibrational loosening and fluid leakage.

Product benefits of the system include:

- The preapplied coating eliminates liquid and paste migration problems and concerns during installation.
- Precoated fasteners can be handled and stored dry.
- Grades are color coded to indicate strength range, easy inspection.
- Ideal for field assembly, inventoried precoated parts are always there and ready for the task.
- Coatings offer excellent solvent resistance and protect threads from corrosion.
- Precoated parts have a minimum shelf life of 48 months (4 years). No special handling or storage required.

Self Locker® 523

Self Locker® 523 is a pre-applied, microencapsulated adhesive for threaded fasteners. **Self Locker® 523** stays dry-to-the-touch until the shearing action of an engaging nut applied to the coated bolt causes the capsules to break allowing the adhesive to cure. This material securely locks and seals against vibration loosening and fluid leakage.

Applications:

Locking & Sealing:

- Head bolts
- Truck Axle bolts
- Transmission nuts
- Pipe plugs and fittings

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

Self Locker® 524

Self Locker® 524 is a pre-applied, microencapsulated adhesive for threaded fasteners. **Self Locker® 524** stays dry-to-the-touch until the shearing action of an engaging nut and bolt causes the capsules to break allowing the adhesive to cure. This material securely locks and seals against vibration loosening and fluid leakage.

Applications:

Locking & Sealing:

- Head bolts
- Truck Axle bolts
- Transmission nuts
- Pipe plugs and fittings

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

Self Locker Typical Values

Grade	Color	Fixture Time, Minutes	Temperature Range, °C (°F)	Breakaway Torque, N•m (in-lbs)
523	Light Grey	2-3	-54 to 150 (-65 to 300)	200
524	Pink	10	-54 to 150 (-65 to 300)	290

*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)

Treating nuts and bolts with Nuts n’ Bolts® & Self Lockers™
Number of milliliters required to treat nuts and bolts per 1,000 pieces

Bolt Size*	Manual Appilcation From Bottle	Automated Application Equipment
1/4	27	17
5/16	45	30
3/8	75	50
7/16	105	70
1/2	135	90
9/16	180	120
5/8	225	150
3/4	340	130
* Measured in inches		

Increased Profitability:

- Modify Existing Circuit Boards
- Fast, Reliable Assembly & Repairs
- Multipurpose Bonding System
- Replaces Mechanical Devices like clamps, clips, wire ties
- Superior to hot melts, silicones, epoxies, contact tapes

Recommended Dispensing Equipment For Self Locker®

- Autosealer 2650
- Autosealer 2600-850
- Autosealer 2600
- Rambo
- Manual and Pneumatic Guns

Resin Usage for Self Lockers™

Fastener Size*	Usage
#2	14
#4	22
#6	29
#8	37
#10	56
1/4	77
5/16	120
3/8	175
7/16	250
1/2	335
9/16	450
5/8	590
3/4	900
7/8	1,300
1	1,750
1 1/8	2,350
1 1/4	3,100
1 3/8	4,100
1 1/2	5,400

Treating Screws by Tumbling Method with Nuts n’ Bolts® & Self Lockers™
Number of milliliters required to treat 1,000 pieces of round head screws by tumbling

length / diameter	2	3	4	5	6	8	10	12	1/4	5/16	3/8	1/2
1/8	2	2	3	3	3	4	-	-	-	-	-	-
1/4	3	3	4	5	6	7	8	10	13	-	-	-
3/8	4	4	5	6	7	9	10	13	16	22	-	-
1/2	5	6	6	7	9	10	13	15	18	25	32	-
3/4	7	8	9	10	12	14	17	80	2	32	41	55
1	9	10	10	13	15	18	21	25	30	38	49	66
1 1/2	-	-	16	19	21	25	30	34	41	53	66	87
2	-	-	-	24	28	33	38	44	52	65	83	110
3	-	-	-	-	-	47	55	63	75	94	120	140

Assembly of cylindrical parts such as rotors, gears, bushings, collars and bearings can be effectively and reliably accomplished with *HERNON*'s line of **Cylinlock®** Retaining Compounds. **Cylinlock®** high strength products eliminate the need for mechanical methods of assembly while decreasing production and assembly cost.

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 formed when **Cylinlock®** cures fills the voids present in even the best shrink or press fits. These compounds also find utility in improving the performance of mechanical retaining methods such as splines, keyways and set screws. The reliability of cylindrical assemblies is determined by the frictional force between the male and female parts of the assembly. All surfaces under magnification exhibit waviness and surface variations, even the most brightly ground and polished. A good analogy is to picture these irregularities as a series of high and low points, like the knuckles of the hand. Bearing and shaft assemblies are subject to pounding forces in operation such that the high points rub and wear away at each other. Anaerobic adhesives increase the force required to initiate sliding and wearing of surfaces on each other. **Cylinlock®** retaining compounds create mechanical anchoring within mating surfaces. These anchors must first be overcome by the operational forces before any sliding or wearing can occur.

Cylinlock® retaining compounds provide 100% contact between mating surfaces when cured. **Cylinlock®** retaining compounds can be used between worn shafts or bearing housings, quickly restoring these otherwise useless assemblies without extensive and expensive restoration processes such as metal-flame spraying, rechroming, grinding, etc.

Application Note:
• Application of **Cylinlock®** retaining compounds should be to oil free, cleaned surfaces. Any primer used should be allowed to dry before applying **Cylinlock®**. Assemble immediately after primer solvent has evaporated.

Application Note:

- Disassembly: **Cylinlock®** compounds form permanent bonds. There are no solvents to dissolve the cured adhesive. Mechanical force or heat is required.
- Application of the necessary mechanical force needed to overcome the shear strength of the material will permit removal using a press or hydraulic ram. For example, a 3 inch diameter x 1inch wide bearing installed with grade 844 (3,500psi shear) requires approximately 32,986 pounds of force to dislodge the cup or outer ring from a housing. Yes, over 16 tons.
- Parts can also be removed by the application of heat, usually in the range of 500-600°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.

Cylinlock® 822

Cylinlock® 822 is a quick curing anaerobic for cylindrical assemblies that increase strength by providing 100% contact of mating surfaces. It is a free flowing green compound with excellent resistance to corrosion and solvents.

Product 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® 823

Cylinlock® 823 is specially 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.

- (Green Fluorescent Liquid)
- Bonds oily surfaces
- Rapid fixture time

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.

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

Applications:

- Pulleys, collars
- Rotors, flywheels
- Sprockets, gears

Cylinlock® 826

Cylinlock® 826 offers high strengths in the realm of 3,000psi shear strength (steel) and service temperature integrity to 400°F. The medium viscosity offers moderately fast cure times without primers.

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

Applications:

- Bushing & sleeves
- Rotors & shafts

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.

- (Green Liquid)
- Low Viscosity
- Medium Strength

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.

- (Green Liquid)
- High Viscosity
- High Strength
- High Temperature Use

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 300oF (149oC) 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 300ºF (149ºC) 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

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 2511
- Sureshot Valves: 2200, 3000, 3200, 3500, 4000
- Rotocoaters

Cylinlock® Typical Values

Grade	Color	Viscosity cP	Temperature Range, ºC (ºF)	Fixture Time at 22°C, Minutes	Gap Fill, mm (in.)	Shear Strength N/mm2 (psi)	Recommended EF® Primer
822	Green	125	-55 to 150 (-65 to 300)	10 to 15	0.127 (0.005)	17.2 (2500)	49 or 50
823	Green	150	-55 to 150 (-65 to 300)	1 to 5	0.127 (0.005)	24.1 (3500)	49 or 50
824	Green	2000	-55 to 150 (-65 to 300)	30 to 40	0.254 (0.010)	20.7 (3000)	49 or 50
826	Green	600	-55 to 204 (-65 to 400)	10 to 15	0.177 (0.007)	20.7 (3000)	49 or 50
840	Green	125	-55 to 150 (-65 to 300)	10 to 30	0.127 (0.005)	20.7 (3000)	49 or 50
842	Green	7000	-55 to 232 (-65 to 450)	45 to 60	0.381 (0.015)	22.1 (3200)	49 or 50
843	Green	2000	-55 to 150 (-65 to 300)	1 to 5	0.254 (0.010)	13.78 (2000)	49 or 50
844	Green	500	-55 to 150 (-65 to 300)	20 to 50	0.203 (0.008)	22.1 (3200)	49 or 50
846	Green	1200	-55 to 150 (-65 to 300)	15 to 30	0.152 (0.006)	22.1 (3200)	49 or 50
850	Green	Gel	-55 to 150 (-65 to 300)	50 to 100	0.254 (0.010)	22.1 (3200)	49 or 50
34323	Green	2000	-55 to 150 (-65 to 300)	10 to 15	0.254 (0.010)	19.3 (2500)	49 or 50
52631	Green	7000	-55 to 150 (-65 to 300)	10 to 30	0.381 (0.015)	22.1 (3200)	49 or 50

Brake Bonder

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

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

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 V**oice 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.

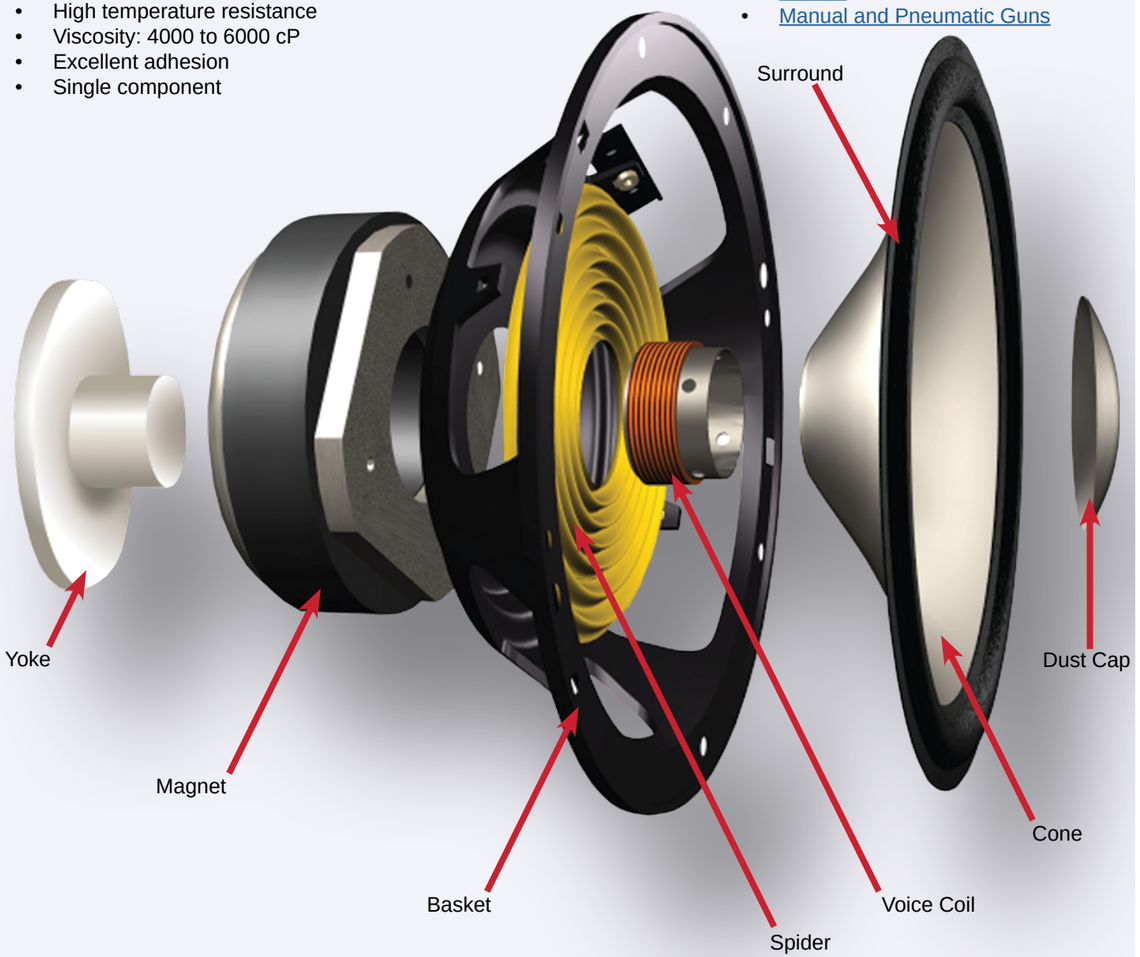
Voice Coil Bonder 360

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

Recommended Dispensing Equipment For Voice Coil Bonder®

- Autosealer 2650
- Autosealer 2600-850
- Autosealer 2600
- Rambo
- Manual and Pneumatic Guns



Weld Sealant

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 (240°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.

Recommended Dispensing Equipment For Weld Sealant

- Autosealer 2650
- Autosealer 2600-850
- Autosealer 2600
- Rambo
- Manual and Pneumatic Guns

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.
- Refits worn couplings.
- Refits loose screws, spun 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 EF® 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.

Recommended Dispensing Equipment For Metal Cement

- Autosealer 2650
- Autosealer 2600-850
- Autosealer 2600
- Rambo
- Manual and Pneumatic Guns

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 radiation. Twin or “dual-cure” types work in conjunction with a primer and provide production processing latitudes to maximize assembly efficiencies.

Dedicated UV cure types, or “UV cure only” grades cure when exposed to UV light. All **Ultrabond**® adhesives respond to exposure to high intensity medium pressure mercury arc UV lamps in the range of 365 nm (long wavelength) and 100- milliwatt/cm² intensity. Some **Ultrabond**® systems even function well with low intensity lamps such as “black lights”. Cure speeds are longer and gap fill ability is lower under these conditions.

Twin or dual-cure systems offer a choice of UV and/or primer to initiate curing. Use primers to fully cure the adhesives anaerobically or to obtain fixturing strength prior to final full UV curing. Primers also promote deeper cures.

Ultrabond® 736

Ultrabond® 736 is a high impact, UV curable structural anaerobic adhesive formulated for bonding glass to glass, glass to metal and for potting and tacking applications. **Ultrabond® 736** has very high light transmission and reflective index similar to that of glass. **Ultrabond® 736** cures on exposure to ultraviolet light, with a wavelength of 365 nm, or with EF® Activator 56.

- (Amber Liquid)
- One component
- Fast cure speed with UV light or EF® Activator 56
- Unlimited adjustment time until exposed to UV light
- Good adhesion to glass
- Bond is almost invisible

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.

Applications:

- 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.

Applications include: tamper proofing, terminal insulating, potting electronic components and assemblies in severe environments.

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

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 fixturing, 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. Use **Ultrabond® 758** for shallow potting and encapsulation on assembly line applications.

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

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

Ultrabond® Typical Values

Grade	Color	Viscosity, cP	Temperature Range, °C (°F)	UV Fixture Time, Seconds	Shear Strength, N/mm² (psi)	Hardness, Shore D
736	Amber	20,000	-55 to 177 (-65 to 350)	12	13.10 (1900)2	60
740	Clear	6,950	-55 to 121 (-65 to 250)	5	11.0 (1600)2	70
748	Clear	2,000	-55 to 177 (-65 to 350)	15	7.5 (1087)2	60
752	Amber	4,250	-55 to 135 (-65 to 275)	5	7.5 (1087)2	70
758	Clear	300	-55 to 177 (-65 to 350)	5	7.5 (1087)2	50
787	Pale yellow	5,000	-55 to 110 (-65 to 230)	5	23.4 (3392) 3	53

Recommended Dispensing Equipment For Ultrabond®

- Autobonders 2101
- Autobonder 2111
- Autobonder 2511
- Rambo
- Sureshots: 2200, 3000, 3200, 3500, 4000
- Manual and Pneumatic Guns

Recommended UV Curing Equipment For Ultrabond®

- Ultraspot 2000
- *HERNON*'s Ultracure Series
- Ultraspot 1000

EF® Accelerator 48

EF® Accelerator 48 is a solvent-based accelerator for instant adhesives. The accelerator is designed to speed the cure of cyanoacrylate adhesives. **EF® 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.

EF® Accelerator 58

EF® Accelerator 58 is a non-CFC solvent based Instantbond and Quantum® adhesive accelerator. **EF® Accelerator 58** increases the cure speed of these cyanoacrylate adhesives. The 24-hour on-part life allows pretreatment of bond substrates.

- Transparent, Colorless Liquid

EF® Accelerator 75

EF® Accelerator 75 is a low toxicity, nonflammable, non-combustible, non-ozone depleting, low volatile organic compound (VOC) accelerator which improves instant adhesive fixturing and curing peformance.

- Clear liquid

EF® Activator 15

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

EF® Activator 47

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

- Light Amber Liquid

EF® Activator 56

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

- Light Yellow Liquid

EF® Activator 59

EF® 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 **EF® 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

EF® Activator 63

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

- Light Yellow Liquid

EF® Adhesion Promoter 42

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

*Santoprene is a trademark of ExxonMobile Chemical

EF® Primer 46

EF® 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®**. **EF® 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

EF® Primer 49

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

- Amber Liquid

EF® Primer 50

EF® 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. **EF® Primer 50** is especially recommended for large gap bonds and inert metals.

- Green Liquid

EF® Primer 57

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

- Green Liquid

Primers				
Grade	Color	Viscosity, cP	Base	Drying Time
42	Clear	2	Heptane	30 sec.
46	Blue-Green	18	Monomer	None
49	Amber	2	Acetone	30 to 70 sec.
50	Green	2	Acetone	30 to 70 sec.
57	Light Blue	15	Monomer	None

Activators					
Grade	Color	Viscosity, cP	Base	Drying Time	On-Part Life
15	Yellow- Amber	35	Non-Solvent	None	2 hours
47	Light Amber	15	Monomer	None	2 hours
48	Light Amber	1	Isopropanol	≤ 30 seconds	≤ 1 min.
51	Light Yellow-Amber	18	Non-Solvent	None	2 hours
56	Light Yellow	2	Acetone	3 min.	2 hours
58	Clear	1	Heptane	60 seconds	24 hours
59	Light Yellow	2	Heptane/Alcohol	2 min.	2 hours
63	Light Yellow	2	Heptane/Alcohol	None	2 hours

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 oil, 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 scrapes off cleanly and easily with a putty knife.
- Use **Chemical Stripper 30** to remove old gasket cements, adhesives, shellacs, or sticky compounds from flange faces prior to Gasket Replacer applications.
- Use Gasket Replacer compounds to replace (form-in-place) conventional precut 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.

Cyanoacrylate Remover 14

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

- Clear Liquid

EF® Cleaner 62

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

- Clear Liquid

Rust Eliminator™ 32

Rust Eliminator™ 32 chemically changes rust to a tough protective coating and primes the surface for painting. A single treatment lasts for years. Simply wire brush and apply two or three coats without any need to sandblast or prime surfaces. Coating withstands constant temperatures to 200°F and intermittent exposure to 250°F. Makes easy work of routine maintenance on machinery.

- Light Yellow to Amber Liquid

EF® Waterproofer 25

EF® Waterproofer 25 is a high performance synthetic rubber based protective coating for adhesive bond lines. It provides a tack-free touch in 3 to 4 minutes and cures to a tough, flexible seal with superb environmental, chemical and temperature resistance.

- Black Liquid

EF® Tamper Proof 610

Tamper Proof 610 is a water-based masking product designed for tamper proofing applications. **Tamper Proof 610** can prevent or show evidence of adulteration on fasteners or other surfaces. It can be applied either by brush or dispensing equipment, and is dried either at room temperature or via an oven for a faster cure. To save application time **Tamper Proof 610** can be applied to oily surfaces, which saves surface preparation time.

Apply a thin coat of **Tamper Proof 610** from .002 to .004 inches by brush, dip, or flow. **Tamper Proof 610** can be diluted with water as needed. A thin coat will cure at room temperature in approximately 45 minutes, or as fast as 10 minutes in a 180°F (82°C) oven.

- Bright Blue Liquid

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**
- **EF® 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
- **EF Activator 63** -1.75oz

ReAct Kit 25ml

Kit Contains:
- **ReAct 730**-25ml,
- **EF Primer 56**-1.75oz

ReAct Kit 250ml

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

HASA Kit

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

Gasket Kit

Kit Contains:
- **Gasket Replacer 916**-300ml
- **EF 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
- **EF® Accelerator 52** 1.75fl oz. pump

Wire Tack
Heavy Duty Kit

Kit Contains:
- **Instantbond 140** Adhesive 20gm
- **EF® 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

UV FOG (Ultraviolet Formed-on-Gasket)

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.

Applications:

- Engine covers
- Oil pans
- Other fluid systems

UV FOG 702 Being Dispensed

Ammunition Sealants

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.

MIL-S-22473E ASTM D5363		
Grade	Grade	ASTM
49	T	Primer Grade T
50	N	Primer Grade N
220	AA	AN0111
223	AVV	AN0124
225	AV	AN0123
227	A	AN0121
230	B	AN0131
232	C	AN0141
234	CVV	AN0143
236	CV	AN0142
237	D	AN0122
238	EV	AN0152
240	E	AN0151
246	HV	AN0162
248	H	AN0161
943	JV	AN0171
944	HVV	AN0163

MIL-S-46163A ASTM D5363			
Grade	Type	Grade	ASTM
410	III	P	AN0241
420	II	M	AN0311
422	I	J	AN0231
423	II	M	AN0321
425	II	O	AN0331
427	I	K	AN0221
429	I	L	AN0211
431	III	R	AN0261

MIL-A-46050C		
Grade	Type	Class
48	IA or IIA	--
52	IA or IIA	--
58	IA or IIA	--
110	I	2
112	I	1
113	II	1
114	I	3
115	II	3
117	II	3
119	II	1
120	II	3
121	II	3
122	II	5
123	II	2
124	II	2
127	II	5
134	II	2
135	II	2
138	II	5

MIL-R-46082B ASTM D5363		
Grade	Type	ASTM
822	I	AN0411
826	II	AN0412
840	I	AN0411

MIL-A-46106B	
Grade	Type
333	Type I
334	Type I
336	Type I
340	Type I
343	Type I

ASTM D5363		
Grade	Class	ASTM
990	61	ANSI/NSF Standard 61

CID A-A-59720	
Grade	Grade
428	HT

MIL-I-17563C	
Grade	Class
990	1 & 3
991	1 & 3

CID A-A-3097		
Grade	Type	Class
48	I or II	--
52	I or II	--
58	I or II	--
110	I	2
112	I	1
113	II	1
114	I	3
115	II	3
117	II	3
119	II	1
120	II	3
121	II	3
122	II	5
123	II	2
124	II	1
127	II	1
134	II	2
135	II	2
138	II	5

NSF Approved
Grade
HPS 990
Dripstop 923
SelfSealer 604
SelfSealer 615
SelfSealer 616
SelfSealer 618
Cylinlock 824
Cylinlock 843
Cylinlock 845
Cylinlock 846

UL Classified
Grade
Dripstop 920
Dripstop 940
Nuts N Bolts 427
SelfSealer 604
SelfSealer 615
SelfSealer 616
SelfSealer 618

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
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 Grains
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-9001:2008 registered company with a Total Solutions approach offering adhesives, sealants and dispensing equipment. *HERNON®* has a 39 year history and is headquartered in Sanford, Florida where it has contributed to some of the nations most sensitive projects including Atlas rocket systems, Excaliber missile systems and even nuclear submarine manufacturing. Recent double digit growth has led to a $2MM expansion of manufacturing facilities and several awards and honors such as the 2015 Presidential "E" Award for exports and 2015 "CEO of the Year" for Harry Arnon by the Orlando Business Journal.

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

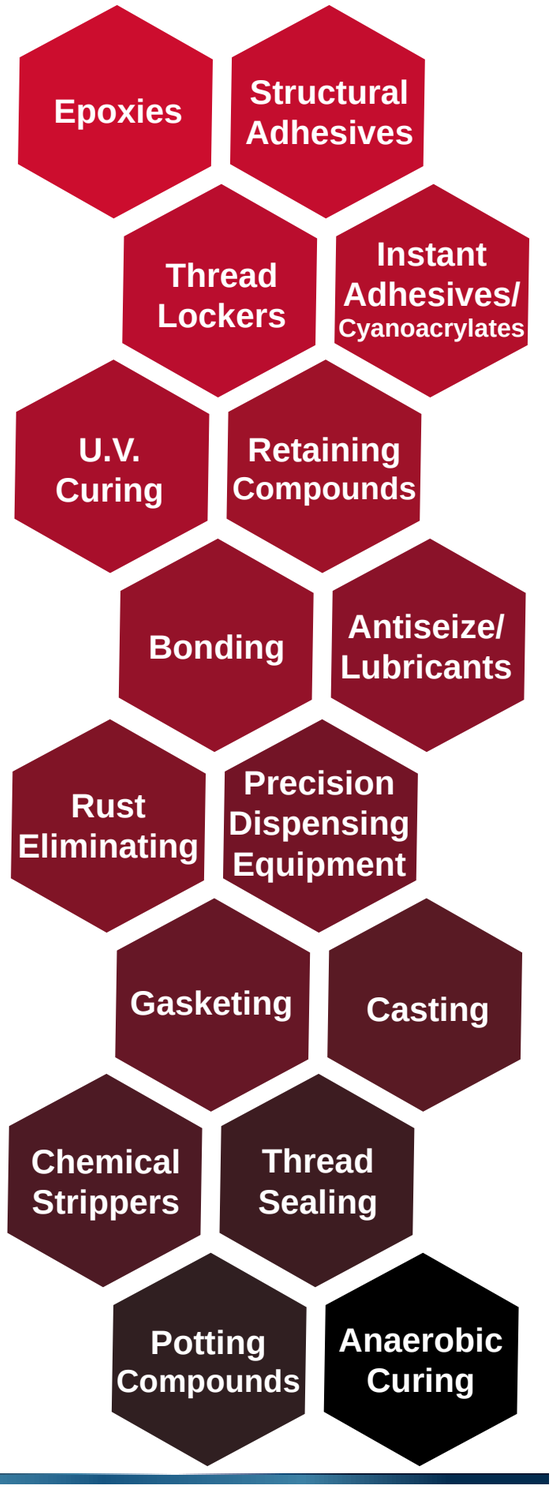
NAICS

- 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

Click a hexagon to learn more!



2016 Florida Manufacturer of the Year Award Nominee
Manufactuers Association of Florida (MAF)

2016 Manufacturing Leadership Award Winner
Frost and Sullivan

Bright House Regional Business Awards ~ 2nd Place
Bright House Networks

CEO of the Year
Orlando Business Journal

President's "E" Award
Office Of The President Of The United States

Top 10 Manufacturing Companies In Central Florida
Orlando Business Journal

See all Awards and Honors by clicking here

Contact Us (Download to submit forms directly from the catalog)

First Name:

Last Name:

Agency/Company:

Location:

Email Address:

Comments:

(Download to submit forms directly from the catalog)

Submit

Contact: Edgardo Rodriguez
Telephone: 1 (407) 322-4000 x314
Email: EdgardoRodriguez@hernon.com
Adhesives Website: www.hernon.com
Equipment Website: www.hernon-equipment.com

Registrations and Certifications

- ISO 9001:2008 - 6Z331-IS3
- ITAR - M31119
- NSF Certifications
- CID, ASTM and MILSPEC
- USDA Approved Products
- UL Classified Products
- National Stock Numbers

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

Your Solution for Today and Tomorrow!

Having Trouble? Click here to submit a comment online.

Awards & Honors

2016 Florida Manufacturer of the Year Award Nominee
Manufactuers Association of Florida (MAF)
August 2016
The MAF holds the Manufacturer of the Year Awards to recognize companies exemplifying Leadership, Strategic Planning, Customer & Market Focus, Measurement/Analysis & Knowledge Management, Workforce Focus, and Operations Focus. Hernon Manufacturing is proud to be nominated for this award again in 2016 after being a finalist in 2014. The awards dinner will be held Wednesday, November 16 in Gainesville, Florida. http://www.mafmfg.com/manufacturer-of-the-year

2016 Manufacturing Leadership Award Winner
Frost and Sullivan
June 2016
The Manufacturing Leadership Awards honor companies and individuals that are shaping the future of global manufacturing. Top companies/projects and individuals are honored as Manufacturing Leadership Award winners at a black tie gala dinner and awards ceremony during the June 6-9, 2016 Manufacturing Leadership Summit at the La Costa Resort in Carlsbad, CA.. Hernon Manufacturing received an award in the New Product Leadership category, for their Small Caliber Ammunition Waterproofing Technology Initiative.

Bright House Regional Business Awards ~ 2nd Place
Bright House Networks
March 2016
Hernon Manufacturing placed 2nd in the Medium Sized Business Category for the Bright House Regional Business Awards. Bright House Networks has teamed up with Chambers of Commerce in nine counties to host this event connecting local businesses in a celebration of best-in-class.

CEO of the Year
Orlando Business Journal
October 2015
Harry Arnon, CEO of **Hernon Manufacturing, Inc.®** was selected as CEO of the Year by the Orlando Business Journal. The Orlando Business Journal uses the CEO of the year award to recognize business leaders who show their ability to navigate current market conditions and leave a lasting legacy through their community involvement.

Harry Arnon
C.E.O.

President's "E" Award
Office Of The President Of The United States
June 2015
Hernon Manufacturing, Inc.® is honored and pleased to announce the company has received the highest award a company can receive - the President's "E" Award for U.S. Exporters. The President's "E" Award may be made to persons, firms and organizations engaged in the marketing of products who make significant contributions to the expansion of the export trade of the United States.

Top 10 Manufacturing Companies In Central Florida
Orlando Business Journal
April 2015
The list recognizes Central Florida's manufacturing companies with the highest manufacturing revenue for 2014. **Hernon Manufacturing, Inc.®** was pleased to place in the Top 10 in this list.
http://www.bizjournals.com/orlando/subscriber-only/2015/04/17/manufacturing-companies.html

Click here to see the full list

Contact Us

(Download to submit forms directly from the catalog)

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.

First and Last Name:

Email Address:

Company:

Location:

Comments:

Josef Arnon
Technical Director

Having Trouble? Click here to submit a comment online.

(Download to submit forms directly from the catalog)

Submit

HERNON®
MANUFACTURING, INC.

High Performance Adhesives, Sealants and
Precision Processing Solutions

800-527-0004

www.*HERNON*.com

Back to Index