

# Technical Data Sheet

## Blank Ammunition Sealant 48641HV

March 2012

Page 1 of 1

### Product Description

Hernon<sup>®</sup> Blank Ammunition Sealant 48641HV is a higher viscosity, UV and LED curable compound formulated to provide high performance, fast curing, coating and sealing of ammunition blank tips. This product is also used for shallow potting applications.

### Product Benefits

- UV fluorescence for in-process inspection
- LED curable
- NO Solvents 100% solid system
- Excellent adhesion to a variety of surfaces
- Excellent environmental resistance
- Good gap filling properties
- No shrinkage due to solvent evaporation
- Rapid room temperature cure

### Typical Properties (Uncured)

Property	Value
Chemical Type	Modified Acrylic Ester
Appearance	Purple, fluorescent liquid
Viscosity @ 25°C, cP	1200 to 1800
Specific Gravity @ 25°C	1.01
Flash Point	See MSDS

### Factors Affecting UV Curing

- All UV sources degrade with use. Check output with a radiometer.
- Thicker films require longer cures.
- Light intensity decreases as distance from UV source increases.
- Some clear plastics may contain UV inhibitors.

### Precautions When Using UV Lamps

- Never look directly at UV source.
- Wear protective UV goggles
- Use in a well-ventilated area. Some UV sources generate ozone. Provide shielding around high intensity UV sources.
- High intensity UV sources generate heat. Take appropriate precautions.

### Typical Curing Performance

Blank Ammunition Sealant 48641HV will cure rapidly at room temperature when exposed to high intensity ultraviolet light (365 nm). UV light intensities above 100 mW/cm<sup>2</sup> will insure optimum surface cure.

#### Fixture Time

100mW/cm<sup>2</sup> at 365 nm  
Glass microscope slides

Property	Value
Fixture time, seconds	≤ 3 secs

#### Tack Free Time

Property	Value
Tack free time, seconds	≤ 3 secs

### Typical Properties (Cured)

Cured for 24 hours @ 22°C tested to ISO 4587

Substrate	Value
Durometer Hardness	70 – 80 Shore D
Shear Strength Glass to Steel	≥ 300 psi

### General Information

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

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

#### Storage

Blank Ammunition Sealant 48641HV should be stored in a cool, dry location in unopened containers at a temperature between 46°F to 82°F (8°C to 28°C) unless otherwise labeled. Optimal storage is at the lower half of this temperature range. To prevent contamination of unused material, do not return any material to its original container.

#### Dispensing Equipment

Hernon<sup>®</sup> offers a complete line of semi and fully automated dispensing equipment. Contact **Hernon<sup>®</sup> Sales** for additional information.

These suggestions and data are based on information we believe to be reliable and accurate, but no guarantee of their accuracy is made. HERNON MANUFACTURING, INC. shall not be liable for any damage, loss or injury, direct or consequential arising out of the use or the inability to use the product. In every case, we urge and recommend that purchasers, before using any product in full scale production, make their own tests to determine whether the product is of satisfactory quality and suitability for their operations, and the user assumes all risk and liability whatsoever, in connection therewith. Hernon's Quality Management System for the design and manufacture of high performance adhesives and sealants is registered to the ISO 9001:2008 Quality Standard.