

Technical Data Sheet

Shotshell Crimp Sealant 721

March 2014

Page 1 of 1

Product Description

Hernon[®] Shotshell Crimp Sealant 721 is a UV curable adhesive that can be used to seal the shotgun shell crimp when exposed to UV light. The sealant offers a water tight seal with excellent environmental resistance. Prevents material escaping through crimp seal. With Shotshell Crimp Sealant 721 a low powered UV lamp (Blacklight), can be used to inspect for the presence of adhesive on the crimp.

Product Benefits

- UV fluorescence for in-process inspection
- Excellent Water Resistance
- Good adhesion to a variety of plastics
- 100% solid system (no solvents)
- Good gap filling properties
- No shrinkage due to solvent evaporation
- Rapid UV cure and self leveling

Typical Properties (Uncured)

Property	Value
Chemical Type	Epoxy Acrylate
Appearance	Clear liquid
Specific Gravity @ 25°C	1.09
Viscosity @ 25°C, cP	180 to 250
Flash Point	See MSDS

Typical Curing Performance

Shotshell Crimp Sealant 721 will cure rapidly at room temperature when exposed to high intensity ultraviolet light (365 nm).

Fixture and Tack Free Time

100mW/cm² at 365 nm

Property	Value
Fixture time, glass, seconds	≤ 5
Cure time, seconds	≤ 5

Directions for Use

Apply a small amount of material around the crimp seal. Apply enough material to fill the voids and seal the crimp. Cure the material with a high intensity UV lamp for 3 – 5 seconds at 365 nm.

Typical Cured Properties

Property	Value
Shear strength, Glass / Glass	≥ 200 psi
Shear strength, Polycarbonate Blocks	≥ 200 psi

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.

Storage

Shotshell Crimp Sealant 721 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[®] offers a Total Solution for your adhesives and sealants including precision dispensing and curing equipment. Contact **Hernon[®] Sales** for additional information.

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).

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.