

Technical Data Sheet Metal Cement 850

April 2020

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Product Description

Hernon® Metal Cement 850 is a single component, silver color gel, that is designed for quick repairing of worn machinery parts. Once confined between parts, it develops a high strength bond with excellent chemical and temperature resistance. The bonded assembly often doubles the strength of press fitted parts.

Typical Applications

Use **Metal Cement 850** in the new assembly to fill the gaps between parts to prevent wear, corrosion and backlash.

- Repairs worn metal parts like bushings, shafts, and housings.
- Repairs worn keyways.
- Refits worn coupling.
- Refits loose screws.

Typical Properties (Uncured)

Property	Value
Chemical Type	Methacrylate Ester
Appearance	Dark Silver gel
Specific Gravity	1.12
Viscosity @ 25°C, cP	1,000,000 to 3,000,000
Flash Point	See SDS

Typical Properties (Cured)

Property	Value
Temperature Range, °F	-65 to 300

Typical Cured Performance

Shear Strength was performed according to ASTM D4562, using Steel Pins and Collars.
Tested at RT.

Cure Time	Shear Strength, N/mm ² (psi)
24 hours at 22°C	≥ 2,000
72 hours at 22°C, 24 hours at 200°C	≥ 1,000

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 Safety Data Sheet (SDS).

Where aqueous washing systems are used to clean the surfaces before bonding, it is important to check for compatibility of the washing solution with the adhesive. In some case, these aqueous washes can affect the cure and performance of the adhesive.

This product is not normally recommended for use on plastics (particularly thermoplastic materials where stress cracking of the plastic could result). It is recommended to confirm compatibility of the product with such substrates.

Directions for Use

For best results, clean all surfaces (external and internal) with a **Hernon®** cleaning solvent and allow to dry. If the material is an inactive metal or the cure speed is too slow, apply **Activator 49 or 50** and allow to dry.

For Slip Fitted Assemblies, apply adhesive around the leading edge of the pin and the inside of the collar and use a rotating motion during assembly to ensure good coverage.

For Press Fitted Assemblies, apply adhesive thoroughly to both bond surfaces and assemble at high press on rates.

For Shrink Fitted Assemblies the adhesive should be coated onto the pin, the collar should then be heated to create sufficient clearance for free assembly.

Parts should not be disturbed until sufficient handling strength is achieved.

Disassembly and Cleanup

To aid in disassembly anaerobic compounds can be weakened by heating to at least 500°F (260°C). Once disassembled, cured adhesive can be removed with **Hernon® Gasket Remover 30**.

Storage

Metal Cement 850 should be stored in a cool, dry location in unopened containers at a temperature between 45°F to 85°F (7°C to 29°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 complete line of semi and fully automated dispensing equipment. Contact **Hernon® Sales** for additional information.

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