

## Ultrabond Primer Sealant 34194

### Product Description

**Heron® Ammunition Primer Sealant 34194** is a single component 100% solid system offering a tough, dry coating with superior chemical and environmental resistance after cure. **Ammunition Primer Sealant 34194** will cure rapidly when exposed to high intensity U.V. light. This coating is formulated to migrate rapidly resulting in complete coverage of the gap. The fluorescent sealant will offer an easy inspection using standard vision system.

### Product Benefits

- UV fluorescence for in-process inspection
- 100% solid system (no solvents).
- Excellent environmental resistance
- Excellent waterproof resistance providing Leak free seals
- 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	Clear- Yellow Fluorescent Liquid
Specific Gravity	1.00
Viscosity @ 25°C, cP	100-120
Flash Point	See SDS
Refractive Index	1.479
Surface Tension	30.49

### Curing Characteristics

The following factors can affect cure rates:

- Lamp intensity and wavelength
- Distance from light source
- Light transmittance of bonded part
- Temperature

### Typical Curing Performance

Fixture time is defined as the time to develop a shear strength of 0.1 N/mm<sup>2</sup>.

Specimen	Cure Conditions	Fixture Time
Glass/Glass	US 1000, at ½ inch distance	≤ 10 seconds

### Typical Properties (Cured)

Property	Value
Durometer Hardness, Shore D	30-40
Temperature Range, °F	-65 to 250

### Typical Cured Performance

Block- Shear Strength on different specimens  
Cured with US 1000, at ½ inch distance  
Tested at RT, according to ASTM D4501

Specimen	Cure Conditions	Value, psi
Glass to Steel	UV-cured for 30 sec, post-cured for 24 hours at 22 °C	≥ 100

### 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.

### Ultraviolet Light

Precautions should be taken to avoid exposure of operator to direct or reflected radiation. Exposure to short wave ultraviolet light can cause a burning of the skin and eyes. Eyes and skin should be protected when mercury vapor lamps are in operation. Most long wave ultraviolet sources do not require shielding.

# Hernon® Technical Data Sheet

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### Recommended Lamps

For information about safe low intensity or high intensity rapid cure lamps, contact the **Hernon® Technical Department**.

### Storage

**Hernon Ammunition Sealant 34194** 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.

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 Quality Standard.