

Activator 63C

Product Description

Hernon® Activator 63 Concentrate (63C) is diluted with Heptane/ Isopropyl Alcohol to make **Activator 63**. Mixing instructions are as follows:

| Total Amount | 63C | Heptane | IPA |
|---------------|----------|-----------|---------|
| 1 fluid ounce | 5.3 gm | 16.5 gm | 0.5 gm |
| 1 gallon | 670.0 gm | 2107.0 gm | 68.3 gm |
| 5 gallons | 3339 | 10510 gm | 341 gm |

- Use a clean, dry container for mixing.
- Purge container with nitrogen gas before filling to remove any moisture.
- Weight out amounts listed and mix ingredients for a minimum of 30 minutes or until all concentrate is dissolve.

Activator 63 when mixed is a single component product designed to improve adhesion to low surface energy plastics such as polyethylene, polypropylene and Santoprene to similar substrates using **Quantum®** and **Instantbond™** adhesives.

Typical Properties*

| Property | Value |
|-------------------------|---------------------------|
| Chemical Type | Amine |
| Solvent | Heptane/Isopropyl Alcohol |
| Appearance | Light Yellow Liquid |
| Specific Gravity @ 25°C | 0.96 |
| Viscosity @ 25°C, cP | Low |
| On part life | < 2 hours |
| Flash Point | See SDS |

*After mixing with Heptane/Isopropyl Alcohol Solution.

Typical Performance

Fixture time and cure speed achieved as a result of using **Activator 63** depend on the adhesive used, the substrate bonded, surface cleanliness and whether one or two surface activation is used.

Fixture time is defined as the time to develop a shear strength of 0.1 N/mm².

Tested on grit-blasted steel lap-shear specimens, one side primed with **Activator 63**

| Hernon Adhesive | Fixture Time (minutes) |
|-----------------|------------------------|
| ReAct™ 761 | 2-5 |

Typical Cured Performance

Shear Strength

Tested on lap-shear specimens with 1 side primed with **Activator 63** and tested according to ASTM D1002.

| Adhesive | Substrate | Cure Time (hours) | Shear Strength (psi) |
|------------|-----------|-------------------|----------------------|
| ReAct™ 761 | G/B Steel | 24 | >1000 |

General Information

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

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

Directions for Use

Cleanliness of the parts to be assembled has a direct effect on the speed and final curing performance of the adhesive. Be sure that the parts are clean and dry. **Cleaner 62** is a reliable way of cleaning parts.

1. Apply the activator on one or both mating surfaces to be bonded.
2. After solvent evaporation, parts appear oily and will remain active for up to two hours after application.
3. Apply **Hernon® Adhesive** to one surface and assemble parts immediately. Hold firmly for one to three minutes. Poorly fitted parts may require longer holding time.
 4. When activator is applied to only one surface, apply the adhesive to the non-activated surface.
 5. Secure the assembly and wait for adhesive to fixture before any handling.
 6. Full cure occurs in 3 to 24 hours depending upon the gap between the surfaces.
 7. When possible, move surfaces in relation to each other for a few seconds to distribute the adhesive evenly and to achieve maximum adhesion.

Hernon® Technical Data Sheet

Activator 63C

Handling Precautions

Once Activator 63 Concentrate is mixed with Heptane/IPA the material is flammable. When dispensing this material from a pressurized system, only nitrogen or argon should be used. Please check local, state and federal regulations regarding the use of flammable liquids in the workplace. For example, special care must be taken to avoid contact of the activator or its vapor with open flame or any electrical equipment that is not flame proofed.

Storage

Activator 63 Concentrate when mixed with Heptane/IPA 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 ISO9001 Quality Standard.