

Activator 52

Product Description

Hernon[®] Accelerator 52 is a single component, non-CFC solvent based adhesive accelerator formulated to promote the cure speed of **Hernon[®]** cyanoacrylate adhesives.

Typical Applications

- Securing wire or coil tapes
- Tamper-proofing
- Board stiffener
- Edge guide

Product Benefits

- Environmentally Friendly.
- Used where increased cure speed of **Hernon's** cyanoacrylate products is required.
- Can be post or pre-applied to the bond. Best results are achieved when used for post applications.

Accelerator 52 meets the requirements of CID-A-A-3097 Type I and II.

Typical Properties

Property	Value
Chemical Type	Amine
Solvent	Acetone
Appearance	Clear liquid
Specific Gravity @ 25°C	0.79
Viscosity @ 25°C, cP	Low
Drying Time, seconds	≤ 30
On Part Life, minutes	≤ 1
Flash Point	See SDS

Typical Performance

Fixture time and cure speed achieved as a result of using **Accelerator 52** depend on the adhesive used and the substrate bonded.

Fixture Time,
Using grit-blasted steel,

Two-side activation with **Accelerator 52**

Adhesive	Value
Instantbond™ 117	≤ 15 seconds

Handling Precautions

This is a highly flammable material. 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 naked flame or any electrical equipment that is not flame proofed.

The solvent can affect certain plastics or coatings. It is recommended to check all surfaces for compatibility before use.

Directions for Use

Activation / Acceleration

1. Apply **Hernon[®]** Cyanoacrylate Adhesive to the parts to be bonded or fixed.
2. Spray or add a drop of **Accelerator 52** over all of the exposed Cyanoacrylate Adhesive (Typically use one drop of activator per drop of adhesive).
3. Can be used to check for signs of hazing or crazing.

Surface Activation

1. Apply one coating of **Accelerator 52** to the area to be bonded by spray, brush or dipping. Contaminated surfaces may need special cleaning or degreasing prior to activation to remove any soluble contamination.
2. Allow the solvent time to evaporate until the surfaces are completely dry (approximately 30 seconds).
3. Apply the **Hernon[®]** cyanoacrylate product immediately after drying or not more than 45 seconds thereafter.
4. **Accelerator 52** can be re-applied if necessary if there is a delay of more than 45 seconds between original activator and adhesive application.

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.

Hernon® Technical Data Sheet

Activator 52

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

Under no circumstances should accelerator and adhesive be mixed directly as liquids.

Storage

Accelerator 52 is classified as **HIGHLY FLAMMABLE** and must be stored in an appropriate manner in compliance with relevant regulations. Do not store near oxidizing agents or combustible materials. Store product in the unopened container in a dry location. Store 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.