

## Technical Data Sheet Dragonbond 194

September 2019

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### Product Description

**Hernon® Dragonbond 194** is a single component, clear cyanoacrylate adhesive, toughened for impact and peel resistance.

### Typical Applications

**Dragonbond 194** is a flexible cyanoacrylate excellent for parts subjected to shock and vibration on most metals, plastics, and rubber substrates.

**Dragonbond 194** is used primarily in the silk screen printing industry with **EF® Accelerator 72** to bond the silk screen to the wood frame, but can be used in many other applications where a flexible bond is needed

### Typical Properties (Uncured)

| Property             | Value               |
|----------------------|---------------------|
| Resin                | Ethyl cyanoacrylate |
| Appearance           | Clear liquid        |
| Viscosity @ 25°C, cP | 650-750             |
| Specific gravity     | 1.05                |
| Flash point          | See SDS             |

### Typical Cured Performance

#### Shear Strength

Cured 24 Hours @ 22°C - tested according to ASTM D1002.

| Substrate           | Shear Strength N/mm² (psi) |
|---------------------|----------------------------|
| Steel, grit-blasted | ≥10.3 (≥1500)              |

### 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).

#### Directions for Use

To ensure a good bond, surfaces must be clean and free from rust inhibitors, mold release agents, oil, and other components. Bond strength on painted parts is dependent on the paint to substrate strength.

#### Bond Durability

Surface area, surface temperature, environment, and stress all affect the durability of the bond.

#### Blooming

Adhesive vapors can settle on surfaces during cure and leave a white residue on parts. This condition is called blooming. This effect can be reduced by one or more of the following methods:

- Increase airflow
- Reduce amount of adhesive used on part
- Use **EF® Accelerator 72** to speed fixture
- Residue can be removed by **Hernon® Cyanoacrylate Remover 14**

#### Storage

Cyanoacrylate adhesives must be stored under refrigeration at a temperature of 40°F ± 5°F for extended shelf life. Before opening, the containers must be warmed to room temperature, otherwise, water may condense into the bottle and cause hardening of the adhesive. To prevent contamination of unused adhesive, do not return product 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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