

## Primer 46

### Product Description

**Hernon**<sup>®</sup> **Primer 46** is a single component, solvent-free, reactive monomer-based product designed to promote the cure speed of **Hernon**<sup>®</sup> anaerobic adhesives and sealants.

### Typical Applications

**Primer 46** is used where increased cure speed of **Hernon**<sup>®</sup> anaerobic adhesives and sealants is required. It is especially recommended for applications with passive metals or inert surfaces and with large bond gaps. It is particularly recommended for cure conditions below 15°C.

### Typical Properties

Property	Value
Appearance	Blue-green liquid
Chemical Type	Methacrylate Monomer
Specific Gravity @ 25°C	1.02
Viscosity @ 25°C, cP	Low
Solvent	None
On Part Life, hours	≤ 1
Flash Point	See SDS

### Typical Performance

The fixture time for **Hernon**<sup>®</sup> adhesives and sealants with **Primer 46** is between 16 and 60 seconds with full cure obtained within 24 hours.

These times are based on specific bond line gaps and adhesive viscosity. All applications should be evaluated for actual fixture time before repeated use or establishing automated assembly procedures.

An increased bond line thickness may decrease strength and will increase the fixture time.

### 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).**

**Under no circumstances should activator and adhesive be mixed directly as liquids. Use only in a well-ventilated area.**

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 cue and performance of the adhesive.

### 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. The activator will not dry and will remain active for up to 1 hour after application.
3. Apply **Hernon**<sup>®</sup> 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.

### Storage

**Primer 46** 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**<sup>®</sup> offers a complete line of semi and fully automated dispensing equipment. Contact **Hernon**<sup>®</sup> **Sales** for additional information.

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