

**HASA 39781**

**Product Description**

Hernon® HASA 39781 is a single-component, anaerobic, structural adhesive designed for bonding rigid assemblies. HASA 39781 cure is accomplished when mating surfaces including metal, glass and ceramics are joined together.

Accelerated cures are possible with the application of primers or by a short, low temperature heat cycle. Upon cure, HASA 39781 is a highly crosslinked thermoset plastic with excellent properties over a wide range of conditions.

**Product Benefits**

- Single component, ready to use adhesive.
- Room temperature cure.
- 100% active material, no solvents.
- Easy clean-up. Wipe uncured adhesive from outer surfaces.

**Typical Applications**

- Bonding ferrite to plated metals in electric motors and loudspeakers.
- Bonding of glass and ceramics.
- Where fast setting of adhesives with high structural properties is required.

**Typical Properties (Uncured)**

Property	Value
Chemical Type	Urethane
Appearance	Clear yellow liquid
Specific gravity @ 25°C	1.10
Viscosity @ 25°C, cP	3,000 – 6,000
Density, lb/gal	8.7
Material VOC, g/L	265

**Typical Properties (Cured)**

**Physical Properties**

Property	Value
Coefficient of thermal expansion, ASTM D696 (K <sup>-1</sup> )	200 x 10 <sup>-6</sup>
Coefficient of thermal conductivity, ASTM C 177, W/(m·K)	0.400

**Electrical Properties**

Property	Value
Dielectric Constant @ 100 Hz ASTM D150	1.25 1.28 1.29
Dissipation Factor @ 100 Hz ASTM D150	0.019 0.001 0.003

**Typical Curing Performance**

**Cure Speed vs. Substrate**

The rate of cure will depend on the substrate used. The table below shows the fixture time achieved on different materials at 22°C / 50% relative humidity. Fixture time is defined as the time to develop a shear strength of 0.1 N/mm<sup>2</sup>.

(Activator 37824 was applied to one surface)

Substrate	Value
Rec'd Steel	< 2 mins

**Typical Cured Performance**

Shear Strength, ASTM D1002  
Grit-blasted steel specimens

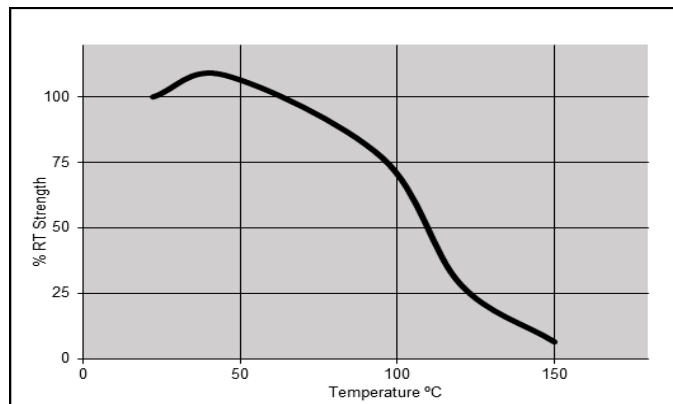
Cure at 22°C	Activation	Shear Strength, psi
24 Hours	Activator 37824 on 1 side	1000-2000

### Typical Environmental Resistance

Cured for 2 days @ 22 °C, Shear Strength, ASTM D1002,  
**Activator 37824** on 1 side.  
Steel (grit blasted)

#### Hot Strength

Tested at temperature



#### Cold Strength

Test condition	Shear Strength
At -20°C	≥ 13.8 N/mm <sup>2</sup> (≥ 2,000 psi)

#### Heat Aging

Aged at temperature indicated - Tested at 72°F (22°C).

Time	Temp	% of Initial Strength
Hours	(°C)	
72	100	100.0
	120	80.1
169	100	100.0
	120	61.7

#### Chemical/Solvent Resistance

Aged under condition indicated - Tested at 72°F (22°C).

Chemical/Solvent	Temp	% of Initial Strength
	(°C)	500h
Water Glycol 50/50	87	85.1
Auto. Trans. Fluid	87	100.0
Phosphate Ester	87	2.6
Gasoline	22	7.3
Motor Oil	87	100.0
Humidity, 95 %RH	40	65.7

### 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.

This product is not normally recommended for use on plastics (particularly thermoplastic materials where stress cracking of the plastic could result). It is recommended to confirm compatibility of the product with such substrates.

### Directions for Use

- For best performance, bond surfaces should be clean and free of grease. Resin needs to be MIXED before using.
- To ensure a fast and reliable cure, **Activator 37824** should be applied to one of the bond surfaces and the adhesive to the other surface. Parts should be assembled within 15 minutes.
- The recommended bond-line gap is 0.1 mm. Where bond gaps are large, (up to a maximum of 0.5mm), or faster cure speed is required, activator should be applied to both surfaces. Parts should be assembled immediately, (within 1 minute).
- Excess adhesive can be wiped away with organic solvent.
- Bond should be held clamped until adhesive has fixture.
- Joint should be allowed to develop full strength before subjecting to any service loads, (typically 24 to 72 hours after assembly depending on bond gap and materials).

#### Storage

**HASA 39781** 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® Technical Data Sheet

## HASA 39781

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**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.