

## Tuffbond<sup>®</sup> 397

### Product Description

Hernon<sup>®</sup> 397 is a single component, high temperature resistant, heat activated epoxy. It cures to a high-performance thermoset system with excellent adhesion properties to a wide variety of substrates. Tuffbond<sup>®</sup> 397 will change from amber-yellow to a reddish brown upon cure.

### Product Benefits

- High temperature resistance.
- Single component (no mixing, no pot life).
- Contains 150micron spacer beads for bond line control
- Solventless.
- Cures on demand (heat cure).
- Will not slip during cure.
- Changes color upon cure (yellow to brown).
- Excellent adhesion to various substrates.
- Gives high shear.
- Low water absorption.

### Typical Properties (Uncured)

Property	Value
Resin	Epoxy
Appearance	Amber-yellow liquid
Viscosity @ 25°C, cP	44,000 to 56,000
Specific gravity	1.19

### Curing Characteristics

Tuffbond<sup>®</sup> 397 can be cured by infrared or convection oven. Cure time will depend on the bond-line temperature.

Temperature, °C (°F)	Set Time, minutes
150 (300)	≤1.5
150 (300)	10 minutes (full strength)

### Typical Cured Performance

Shear Strength, ASTM D1002  
Cured at temperature listed

Substrate	Cure Time	Temperature	Shear Strength, psi
Steel	10 minutes	150 °C	2000 - 3500

### 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).**

### Storage

Tuffbond<sup>®</sup> 397 must be stored under refrigeration at a temperature of approximately 40° F for extended shelf life. Keep container tightly closed when not in use. 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.

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<sup>®</sup>, 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.