

## Activator 21

### Product Description

**Hernon® Activator 21** is an encapsulated catalyst that activates the resin; **Self Locker 523**.

### Typical Properties (Uncured)

Property	Value
Appearance	White Solid
Chemistry	Encapsulated Benzoyl peroxide
Specific gravity	1.34

### Typical Performance

Fixture time and cure speed of the adhesive on treated surfaces depends on the adhesive used and the substrate bonded. Check the technical data sheet for **Self Locker 523** for more information.

### General Information

#### Mixing Procedure

**Self Locker 523** must be mixed with **Hernon® Activator 21** to obtain strengths.

For small amounts: Add **Activator 21** to stock solution (Self Locker) and stir until well blended.

Use the following mixing proportions:

Total Amount, g	Stock Solution, g	Activator 21, g
25 gm	25.0	1.5
50 gm (2 oz)	50.0	3.0
100	100	6.0

#### Application

1. Make sure parts are clean.
2. Mix Self Locker with Activator as described above.
3. Application by Hand: Roll threads across a flat surface in material making sure to leave the lead threads clean and fill the rest of the thread roots completely.
4. Application by Machine: Adjust machine to keep lead threads clean and coat with a band width minimum of 1 in diameter.
5. Dry Bolt as soon as possible after coating.
6. Dry for 15-30 minutes at 65°C. Do not allow coated parts to air dry. Do not over-dry parts.

7. Once cooled to room temperature coated parts may be stored or packaged but do not assemble until 24 hours after drying.

8. Material will be activated when nut is applied.

#### Storage

**Hernon® Activator 21** should be stored in a cool, dry location in unopened containers at a temperature below 45°F to 85°F (7°C to 29°C) unless otherwise labeled. To prevent contamination of unused material, do not return any material to its original container.

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