

HPS Initiator 93

Product Description

Hernon[®] HPS Initiator 93 is used to activate Hernon[®] Hernon[®] Porosity Sealant (HPS) resins. Hernon[®] HPS Initiator 93 activates HPS 991R enabling the system to cure at elevated temperatures.

Typical Properties

| Property | Value |
|-------------------------|---------|
| Appearance | White |
| Specific Gravity @ 25°C | 1.04 |
| Flash Point | See SDS |

Gel Time

Gel time** at 90°C with Initiator 93: 4 to 10 minutes
99.8 grams of HPS 991R mixed with 0.2 grams of Initiator 93*
99.2 grams of HPS 994R mixed with 0.8 grams of Initiator 93*

Activation Instructions

HPS 991R can be activated using the following mixing proportions:

| <u>HPS 991R</u> | <u>HPS Initiator 93</u> |
|-----------------|-------------------------|
| 1 Gallon | 63 grams |
| 5 Gallons | 315 grams |

Mix thoroughly until the initiator is completely dissolved before use.

Please see technical data sheets for HPS resins for Activation instructions and Directions for Use.

Cure Mechanism and Rate

HPS resins cures to form a thermoset polymer when exposed to elevated temperature. Thermal content and coefficient of thermal transfer in the workpieces influence the cure rate of the HPS system.

Higher temperatures produce quicker cure rates. HPS resins generally cures within the range of 177°F (80°C) to 205°F (96°C).

Proper cure requires the workpiece to uniformly attain full cure temperature. Parts that do not transfer heat well will required longer processing times. Efficient thermal conductivity yields shorter processing cycles. Parts with heavier cross sections require longer exposure at heat to attain sufficient temperature internally. Carefully consider part geometry.

Consult Hernon[®] Technical Service for specific process requirements.

Handling Precautions

This is a highly flammable material. When dispensing this material from a pressurized system, only nitrogen or argon should be used. Please check local, state and federal regulations regarding the use of flammable liquids in the workplace. For example, special care must be taken to avoid contact of the activator or its vapor with naked flame or any electrical equipment that is not flame proofed.

Storage

Store in the unopened container in a dry location such as a refrigerator or freezer below approximately 50 °F (10°C). Higher temperatures may cause decomposition. Preferably product should be stored in refrigerator to ensure shelf life. Product also can be stored at freezer for longer shelf life. Above approximately 95°F decomposition may become volatile. Do not store with strong oxidizing agents and from ignition sources. Do not smoke. To prevent contamination of unused material, keeping container tightly closed and do not return any material to its original container.

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).

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.

Dispensing Equipment

Hernon[®] offers a complete line of semi and fully automated dispensing equipment. Contact Hernon[®] Sales for additional information.

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