

Initiator 91

Product Description

Hernon® HPS Initiator 91 is used to activate **Hernon® Hernon® Porosity Sealant (HPS) resins**. **Hernon® HPS Initiator 91** 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 91**: 4 to 10 minutes
99.8 grams of **HPS 991R mixed with 0.2 grams of **Initiator 91**

Activation Instructions

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

<u>HPS 991R</u>	<u>HPS Initiator 91</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. Store 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.

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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