

Technical Data Sheet Activator 15

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Product Description

Hernon® Activator 15 is a solvent free product which was designed to be used with **Hernon® ReAct™ 727, 784** and **Fusionbond 374**.

Product Benefits

- Activator can be applied up to 2 hours before bonding parts or used instantly.

Typical Properties (Uncured)

Property	Value
Chemical Type	Amine
Appearance	Amber- Yellow Liquid
Solvent	None
Viscosity @ 25°C, cP	80-200
Specific gravity	0.99
Flash point	See SDS
On Part Life, hours	2

Typical Curing Performance

Cure Speed vs. Substrate

The rate of cure will depend on the substrate used. Fixture time is defined as the time to develop a shear strength of 0.1 N/mm².

Fusionbond 374 was used to measure fixture time. (One side primed with a minimal thin layer of **Activator 15**.)

Substrate	Fixture Time (minutes)
G/B Steel	≤ 10
G/B Aluminum	2-3
ABS	≤ 6

Typical Cured Performance

Tested on lap-shear specimens in accordance with ASTM D1002.

Cured for 24 hours at room temperature. **Fusionbond 374** was used as an adhesive. One side primed with a minimal thin layer of **Activator 15**.

G/B Steel	≥ 20.7 (3000)
G/B Aluminum	≥ 17.2 (2500)
A/R Steel	≥ 17.2 (2500)
A/R Aluminum	≥ 13.8 (2000)

Block- Shear Strength

Cured 24 Hours @ 22°C - tested according to ASTM D4501. (One side primed with a minimal thin layer of **Activator 15**.)

Substrate	Shear Strength (psi)
ABS	≥ 500
Epoxy Glass	≥ 500
Acrylic	≥ 1000
Polycarbonate	≥ 500
PVC	≥ 500

Directions for Use

1. Substrates should be free of heavy grease and grinding residues. A chemical conversion coating may enhance adhesive properties and provide maximum corrosion protection on metallic assemblies.
2. Apply a thin layer of **Activator 15** to one surface. Apply **ReAct™ 784** or **Fusionbond 374** to the other surface to be bonded.
3. Join surfaces using sufficient force to spread adhesive thinly. Join parts within two hours of applying primer (primer on-part life is two hours maximum). Minimizing the on-part time of the primer maximizes consistency in performance.
4. Maintain pressure until handling strength is achieved. Handling strength varies with part geometry, substrate, surface area, tolerances, etc.
5. Release pressure and allow 24 hours for adhesive to fully cure.

Storage

Activator 15 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.

General Information

Substrate	Shear Strength, N/mm ² (psi)
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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).

Under no circumstances should activator and adhesive be mixed directly as liquids.

Dispensing Equipment

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

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