

Technical Data Sheet Accelerator 48

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Product Description

Hernon® Accelerator 48 is a solvent-based accelerator for instant adhesives. The accelerator is designed to speed the cure of **Hernon®** cyanoacrylate adhesives.

Typical Applications

Accelerator 48 is used where increased cure speed of **Hernon®** cyanoacrylate adhesives is required. Especially recommended for applications involving printed circuit board wire tacking and tamper proofing of adjustable components.

Typical Properties

Property	Value
Chemical Type	Amine
Solvent	Isopropanol
Appearance	Clear liquid
Specific Gravity @ 25°C	0.80
Viscosity @ 25°C, cP	Low
Drying Time, seconds	≤ 30
On Part Life, minutes	≤ 1
Flash Point	See SDS

Typical Performance

Fixture time and cure speed achieved as a result of using **Accelerator 48** depend on the adhesive used and the substrate bonded.

Fixture time is defined as the time to develop a shear strength of 0.1 N/mm².

Tested on grit-blasted steel lap-shear specimens, one side primed with **Accelerator 48**.

Adhesive	Value
Instantbond™ 117	≤ 30

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.

The solvent can affect certain plastics or coatings. It is recommended to check all surfaces for compatibility before use.

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).

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

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 cure and performance of the adhesive.

Directions for Use

Post Activation

1. Apply **Hernon®** cyanoacrylate to the parts to be bonded or fixed.
2. Apply **Accelerator 48** over all exposed cyanoacrylate adhesive by spray or drop. (Typically use one drop of activator per drop of exposed adhesive).

Surface Activation

1. Apply one coating of **Accelerator 48** to the area to be bonded by spray, brush or dipping. Contaminated surfaces may need special cleaning or degreasing prior to activation to remove any soluble contamination.
2. Allow the solvent time to evaporate until the surfaces are completely dry (approx. 30 seconds).
3. Apply the **Hernon®** cyanoacrylate product immediately after drying or not more than 45 seconds thereafter.
4. **Accelerator 48** can be re-applied if necessary if there is a delay of more than 45 seconds between original activator and adhesive application.

Storage

Accelerator 48 is classified as **HIGHLY FLAMMABLE** and must be stored in an appropriate manner in compliance with relevant regulations. Do not store near oxidizing agents or combustible materials. Store product 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.

Dispensing Equipment

Hernon® offers a complete line of semi and fully automated dispensing equipment. Contact **Hernon® 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®, 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 ISO9001 Quality Standard.