HERNON®
High Performance Adhesives and Sealants
ISO 9001 Registered

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Technical Data Sheet
Activator 56

Product Description

Hernon® Activator 56 is a single component, non-CFC solvent-based product, designed to promote the cure speed of **Hernon® Structural Adhesive/Sealants.**

Typical Applications

Activator 56 is used where increased cure speed of **Hernon®** anaerobic adhesives and sealants is required. Especially recommended for applications with passive metals, inert surfaces or where large gaps are present.

Typical Properties

Property	Value
Chemical Type	Aldehyde-amine condensate
Solvent	Acetone
Appearance	Light yellow liquid
Specific Gravity @ 25ºC	0.81
Viscosity @ 25ºC, cP	Low
Drying Time, minutes	≤ 3
On Part Life, hours	2
Flash Point	See SDS

Typical Performance

Fixture time and cure speed achieved as a result of using **Activator 56** 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 **Activator 56.**

Adhesive	Value
ReAct 727	≤ 25 seconds
ReAct 767	≤ 25 seconds

Typical Cured Performance

Shear Strength
Tested on lap-shear specimens with 1 side primed with **Activator 56** and tested according to ASTM D1002.

Adhesive	Substrate	Cure Time (hours)	Shear Strength (psi)
ReAct 727	G/B Steel	24	2500-3500
ReAct 767	G/B Steel	24	1500-2500

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.

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 activator 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 cue and performance of the adhesive.

Directions for Use

1. Spray or brush the primer on one or both mating surfaces. For small gaps, treatment of only one surface may be adequate. Contaminated surfaces may need repeated treatment or special degreasing prior to activation to remove any dissolvable contamination. If bonding surfaces are porous, or if gaps are large, apply the primer to both surfaces.

   Note: Because the solvent base can affect certain plastics or coatings, checking all surfaces for compatibility is recommended.

2. Allow the solvent sufficient time to evaporate under good ventilation.
3. After priming, parts should be bonded within 2 hours. Try to prevent any surface contamination before the bonding process.
4. Apply the adhesive/sealant to one or both surfaces and assemble parts immediately.

Note: If **Activator 56** is to be applied to only one surface, apply the adhesive to the opposite surface.

5. When possible, for a few seconds move surfaces in relation to each other to properly distribute the adhesive and to achieve maximum activation. Secure the assembly and wait for surfaces to fixture before any further handling.

Storage

Activator 56 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 45ºF to 85ºF (7ºC to 29ºC) 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.