

Technical Data Sheet Activator 63

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Product Description

Activator 63 is a solvent based product, specially formulated to promote the cure of **Hernon[®] Adhesives**.

Typical Properties

Property	Value
Chemical Type	Amine
Solvent	Heptane/Isopropanol
Appearance	Light Yellow Liquid
Specific Gravity @ 25°C	0.75
Viscosity @ 25°C, cP	Low
Drying Time, minutes	≤ 2
On Part Life, hours	2
Flash Point	See SDS

Typical Performance

Fixture time and cure speed achieved as a result of using **Activator 63** depend on the adhesive used, the substrate bonded, surface cleanliness and whether one or two surface activation is used.

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 63**

Hernon Adhesive	Fixture Time (minutes)
ReAct™ 761	2-5

Typical Cured Performance

Shear Strength

Tested on lap-shear specimens with 1 side primed with **Activator 63** and tested according to ASTM D1002.

Adhesive	Substrate	Cure Time (hours)	Shear Strength (psi)
ReAct™ 761	G/B Steel	24	>1000

Handling Precautions

Activator must be handled in a manner applicable to highly flammable materials and in compliance with relevant local regulations.

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 activator and adhesive be mixed directly as liquids. Use only in a well-ventilated area.

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

Cleanliness of the parts to be assembled has a direct effect on the speed and final curing performance of the adhesive. Be sure that the parts are clean and dry. **Cleaner 62** is a reliable way of cleaning parts.

1. Apply the activator on one or both mating surfaces to be bonded.
2. After solvent evaporation, parts appear oily and will remain active for up to two hours after application.
3. Apply **Hernon[®] Adhesive** to one surface and assemble parts immediately. Hold firmly for one to three minutes. Poorly fitted parts may require longer holding time.
4. When activator is applied to only one surface, apply the adhesive to the non-activated surface.
5. Secure the assembly and wait for adhesive to fixture before any handling.
6. Full cure occurs in 3 to 24 hours depending upon the gap between the surfaces.
7. When possible, move surfaces in relation to each other for a few seconds to distribute the adhesive evenly and to achieve maximum adhesion.

Storage

Activator 63 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.