

## Technical Data Sheet

### ReAct™ 784

February 2006

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#### Product Description

**Hernon**<sup>®</sup> has taken the excellent bond strength of Fusionbond structural adhesive and merged it with the simplicity of **ReAct**<sup>™</sup> two-component, no-mix curing system to create **ReAct**<sup>™</sup> 784. **ReAct**<sup>™</sup> 784 is a 100% solids, room temperature cure, versatile structural adhesive. This formulation will offer rapid, high strength and high impact resistant bonds to a variety of substrates within minutes. Designed for a wide variety of substrates, React 784 offers excellent temperature and chemical resistance. The two-component, no-mix system allows controlled assembly timing ideal for production and repair applications. Simply apply adhesive to one part and activator to other part and join the assembly. A structural bond will develop within minutes.

#### Product Benefits

- Bonds to an exceptionally large variety of substrates including metals, plastics, composites, ceramics, glass, wood, leather, rubber and marble.
- Convenient two-component, no-mix system for rapid production applications
- Minimal or no surface preparation.
- 100% solid system
- Excellent chemical resistance
- Excellent environmental resistance.
- Excellent temperature resistance.
- No pot life
- Simple and inexpensive dispensing equipment.
- No shrinkage due to solvent evaporation.
- Rapid room temperature cure.

#### Typical Properties (Uncured)

Property	Value
Resin	Methacrylate ester
Appearance	White liquid
Viscosity @ 25°C, cP	40,000 to 64,000
Specific gravity	1.04
Flash point	See MSDS

#### Typical Curing Performance

##### **Cure Speed vs. Substrate**

The rate of cure will depend on the substrate used. The table below shows the fixture time achieved on different materials at 22°C. Fixture time is defined as the time to develop a shear strength of 0.1 N/mm<sup>2</sup>.

Tested on steel and aluminum lap-shear specimens, plastic and glass block-shear specimens. One side primed with **EF**<sup>®</sup> **Activator 15**.

Substrate	Fixture Time, minutes
As Received Steel	8
As Received Aluminum	12
Abraded Aluminum	10
Epoxyglass	10
Phenolic	5
PVC	4
ABS	4
Acrylic	10
Polycarbonate	5
Glass	22

##### Typical Cured Performance

Tested on steel and aluminum lap-shear specimens in accordance with ISO 4587, and plastic and glass block-shear specimens in accordance with ISO 13445. Cured for 24 hours at room temperature . One side primed with **EF**<sup>®</sup> **Activator 15**.

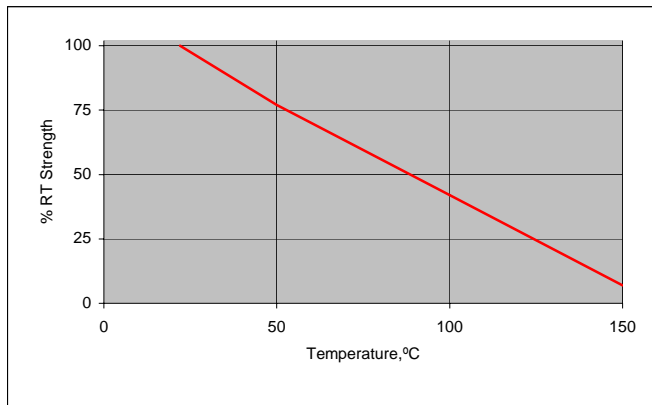
Substrate	Shear Strength, N/mm <sup>2</sup> (psi)
As Received Steel	33.4 (4850)
As Received Aluminum	7.2 (1050)
Abraded Aluminum	12.5 (1810)
Epoxyglass	11.9 (1720)
Phenolic	6.9 (995)
PVC	4.9 (710)
ABS	3.0 (430)
Acrylic	7.2 (1040)
Polycarbonate	5.4 (790)
Glass	9.9 (1440)

## Typical Environmental Resistance

Cured for 1 week @ 22 °C, One side primed with **EF® Activator 15**. Shear Strength, ISO 4587, Steel

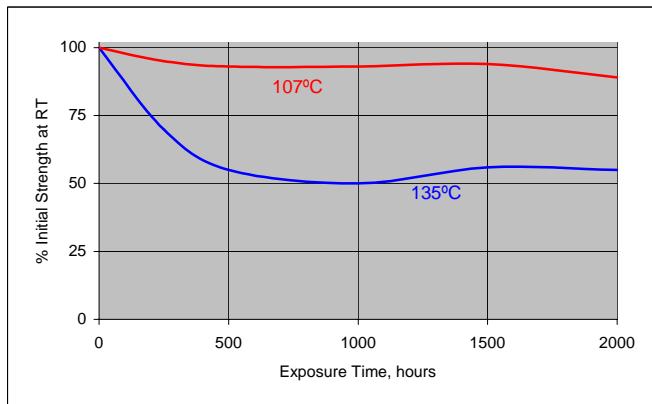
### Hot Strength

Tested at temperature



### Heat Aging

Aged at temperature indicated - Tested at 72°F (22°C).



### Chemical/Solvent Resistance

Aged under condition indicated - Tested at 72°F (22°C).

Chemical/Solvent	Temp (°C)	% of Initial Strength	
		1000 h	2000 h
Motor Oil	66	75	90
Gasoline	66	95	90
Water/Glycol	66	75	50
Isopropanol	22	75	90
Salt Fog	35	75	60
Humidity, 100% RH	49	55	35

## General Information

**This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials.**

**For safe handling information on this product, consult the Material Safety Data Sheet (MSDS).**

### Directions For Use

- ReAct™ 784** is useable on a wide variety of surfaces. 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.
- Apply **EF® Activator 15** to one surface. Apply adhesive to the unprimed surface.
- 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.
- Maintain pressure until handling strength is achieved. Handling strength varies with part geometry, substrate, surface area, tolerances, etc.
- Release pressure and allow 24 hours for adhesive to fully cure.

### Storage

**ReAct™ 784** should be stored in a cool, dry location in unopened containers at a temperature between 46°F to 82°F (8°C to 28°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 ISO9001:2000 Quality Standard.