

# Technical Data Sheet

## Blank Ammunition Sealant 48641

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### Product Description

**Hernon<sup>®</sup> Blank Ammunition Sealant 48641** is a medium viscosity, UV and LED curable compound formulated to provide high performance, fast curing, coating and sealing of ammunition blank tips. This product is also used for shallow potting applications.

### Product Benefits

- UV fluorescence for in-process inspection
- LED curable
- NO Solvents 100% solid system
- Excellent adhesion to a variety of surfaces
- Excellent environmental resistance
- Good gap filling properties
- No shrinkage due to solvent evaporation
- Rapid room temperature cure

### Typical Properties (Uncured)

| Property                | Value                      |
|-------------------------|----------------------------|
| Chemical Type           | Modified Acrylic Ester     |
| Appearance              | Purple, fluorescent liquid |
| Viscosity @ 25°C, cP    | 600 to 800                 |
| Specific Gravity @ 25°C | 1.01                       |
| Flash Point             | See MSDS                   |

### Factors Affecting UV Curing

- All UV sources degrade with use. Check output with a radiometer.
- Thicker films require longer cures.
- Light intensity decreases as distance from UV source increases.
- Some clear plastics may contain UV inhibitors.

### Precautions When Using UV Lamps

- Never look directly at UV source.
- Wear protective UV goggles
- Use in a well-ventilated area. Some UV sources generate ozone. Provide shielding around high intensity UV sources.
- High intensity UV sources generate heat. Take appropriate precautions.

### Typical Curing Performance

**Blank Ammunition Sealant 48641** will cure rapidly at room temperature when exposed to high intensity ultraviolet light (365 nm). UV light intensities above 100 mW/cm<sup>2</sup> will insure optimum surface cure.

#### **Fixture Time**

100mW/cm<sup>2</sup> at 365 nm  
Glass microscope slides

| Property              | Value    |
|-----------------------|----------|
| Fixture time, seconds | ≤ 3 secs |

#### **Tack Free Time**

| Property                | Value    |
|-------------------------|----------|
| Tack free time, seconds | ≤ 3 secs |

### Typical Properties (Cured)

Cured for 24 hours @ 22°C tested to ISO 4587

| Substrate                     | Value           |
|-------------------------------|-----------------|
| Durometer Hardness            | 70 – 80 Shore D |
| Shear Strength Glass to Steel | ≥ 300 psi       |

### 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).**

#### **Storage**

**Blank Ammunition Sealant 48641** 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<sup>®</sup>** offers a complete line of semi and fully automated dispensing equipment. Contact **Hernon<sup>®</sup> Sales** for additional information.

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