

## Application & Usage Information of HERNON Adhesives and Sealants

### I. Area coverage for Various Package Sizes

Package Size	Area Covered (in <sup>2</sup> )*
.5mL Capsule	10
1mL Tube	20
3mL Tube	60
6mL Tube	120
10mL Bottle	200
20mL Bottle/Tube	400
1/3 oz Bottle	200
1 oz Bottle	600
25mL Syringe	490
50mL Dual Syringe	490
50mL Bottle	985
100mL Tube	1,970
250mL Bottle/Tube	4,930
300mL Cartridge	5,920
400mL Dual Cartridge	3,940
428mL (1 lb. Bottle)	8,560
850mL Cartridge	16,700
1,000mL (Liter)	19,700

❖ Coverage figures based on a .003" bondline thickness

### II. Area Coverage for HERNON Primers, Activators, Accelerators and Support Products

Package Size	Area Covered (in <sup>2</sup> )*
1 oz Bottle	900
1.75 oz Bottle	1,575
2 oz Bottle	1,800
3 oz Bottle	2,700
40g Spray Can	1,200
4 oz Bottle	3,600
6 oz Spray Can	5,185
16 oz Container (Pint)	16,400
18 oz Spray Can	9,000
32 oz Can (Quart)	28,800
1 Gallon	115,200

❖ Coverage figures based on a .002" bondline thickness

### III. Treating Screws by Tumbling Method with Hernon Nuts n' Bolts

Number of milliliters required to treat 1,000 pieces of round head screws by tumbling.

Diameter*	2	3	4	5	6	8	10	12	1/4	5/16	3/8	1/2
Length*												
1/8	2	2	3	3	3	4	-	-	-	-	-	-
1/4	3	3	4	5	6	7	8	10	13	-	-	-
3/8	4	4	5	6	7	9	10	13	16	22	-	-
1/2	5	6	6	7	9	10	13	15	18	25	32	-
3/4	7	8	9	10	12	14	17	20	24	32	41	55
1	9	10	10	13	15	18	21	25	30	38	49	66
1½	-	-	16	19	21	25	30	34	41	53	66	87
2	-	-	-	24	28	33	38	44	52	65	83	110
3	-	-	-	-	-	47	55	63	75	94	120	140

❖ Measured in inches

### IV. Treating Nuts and Bolts with Hernon Nuts n' Bolts

Number of milliliters required to treat nuts and bolts per 1,000 pieces

Bolt Size*	Manual Application from Bottle	Automated Application Equipment
1/4	27	17
5/16	45	30
3/8	75	50
7/16	105	70
1/2	135	90
9/16	180	120
5/8	225	150
3/4	340	130

❖ Measured in inches

### V. Treating Pipe Fittings with Hernon Dripstop

Number of milliliters required to treat 1,000 pipe fittings

Fitting Size*	Tumble Applied	Manual Application
1/8	25	40
1/4	45	60
3/8	60	90
1/2	90	130
3/4	190	250
1	360	440

❖ Measured in inches

## VI. Approximate number of Free-Fall drops per milliliter from standard packaging

Viscosity (cP)	Drops/mL	Drops/lb.
1-100	100	42,800
100-1,000	70	29,960
1,000-5,000	50	21,400
5,000-10,000	30	12,840

## VII. Weld Seals

- ❖ 3mL of low viscosity Threadlocker will cover 100 linear inches of weld when applied with a ½ inch brush.

## VIII. Resin Usage for Hernon Self-Lockers

Fastener Size*	Usage
#2	14
#4	22
#6	29
#8	37
#10	56
1/4	77
5/16	120
3/8	175
7/16	250
1/2	335
9/16	450
5/8	590
3/4	900
7/8	1,300
1	1,750
1 1/8	2,350
1 1/4	3,100
1 3/8	4,100
1 1/2	5,400

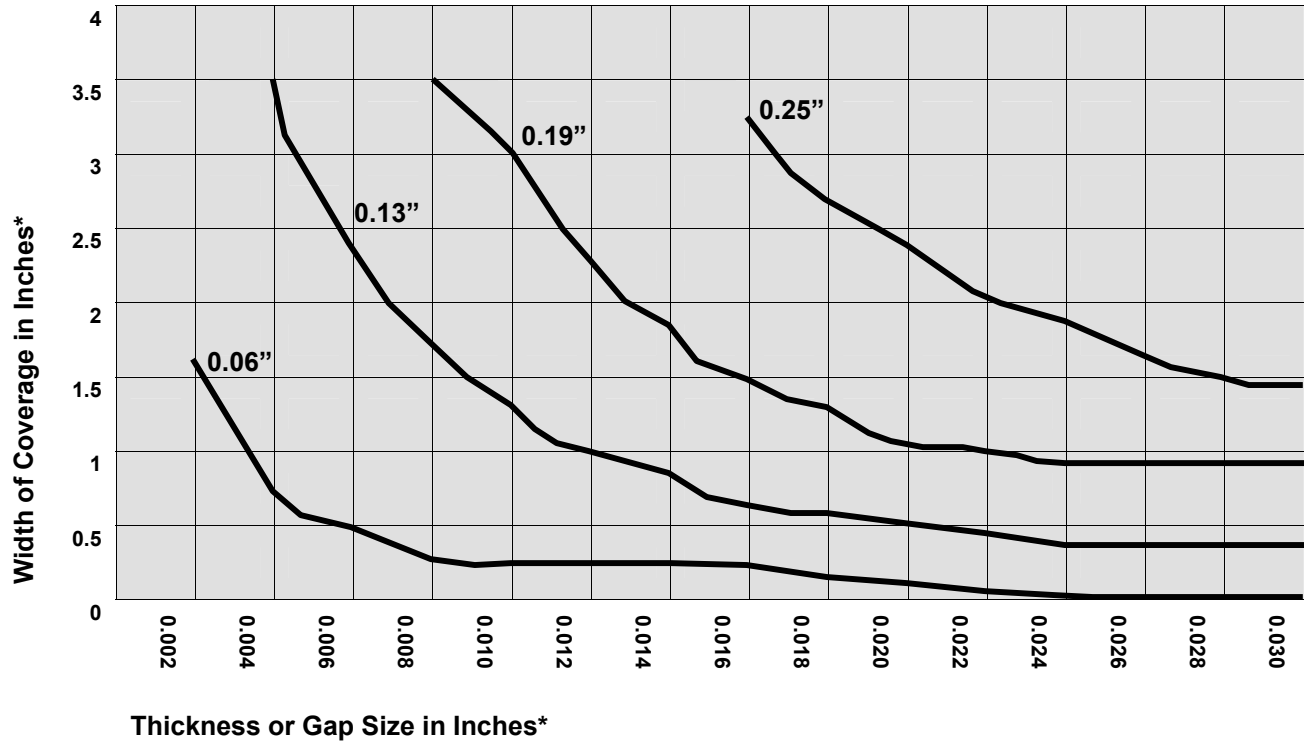
- ❖ Values are based on machine treating fasteners with Hernon Self-Locker with a bond width of 1.5" X Diameter
- ❖ Usage is based on grams per 1,000 fasteners
- ❖ Hernon Self-Locker is sold by the pound (454 g)

## IX. Usage Chart for Hernon Self-Seeler

Pipe Size*	Coating Width*	mL/1,000 Parts
1/16	5/16	30
1/8	3/8	50
1/4	7/16	112
3/8	1/2	155
1/2	9/16	285
3/4	5/8	400
1	3/4	725
1 1/4	13/16	980
1 1/2	7/8	1,150
2	1 1/16	1,525
2 1/2	1 1/8	3,225
3	1/8	4,000

- ❖ Coverage figures based on a .002" bondline thickness

## X. Area Coverage of Hernon Gasket Replacers



❖ Example: Material will cover a 1" width when a 0.06" bead is applied at a 0.003" gap

## XI. Bead Size and Length for Hernon gasket Replacer Package Sizes

Container Size	Bead Diameter*	Bead Length*
50mL Tube	.250	62
	.130	250
	.060	1,000
100mL Tube	.250	125
	.130	500
	.060	2,000
250mL Tube	.250	310
	.130	1,250
	.060	10,000
300mL Cartridge	.250	375
	.130	1,500
	.060	6,000
850mL Cartridge	.250	21,250
	.130	4,250
	.060	17,100
10 Liter Pail	.250	12,400
	.130	50,000
	.060	400,000

❖ Measured in inches