

Adhesive—Primer**1. SCOPE**

1.1 This specification describes a single component, non-CFC solvent based surface activator. The activator is designed to promote the speed of cure of anaerobic adhesives and sealants. This primer shall be used with the standard 86557106 (FNHA-2-E-069.00).

1.2 This specification may involve hazardous materials, procedures and apparatus. This specification does not address the health and safety problems associated with its application or use. It is the specification user's responsibility to follow appropriate health or safety practices and determine the application or regulatory limitation before use.

2. APPLICATION

This specification was originally released to provide a primed surface for sealant according to standard 86557106 (FNHA-2-E-069.00). The Primer is used to accelerate cure, provide cure on inactive surfaces, provide cure at low temperatures, reduce inconsistencies of adhesive performance, and eliminate heat cure. Examples of inactive surfaces are: zinc, cadmium, anoxidated aluminum, stainless steel, passivated surfaces, ceramics and thermosets.

3. DESIGNATION

The Engineering drawing shall contain the following notation for the specification of the subject primer. The quantity shall be noted and the unit of measure shall be in gallons (GA). As described in standard 86511126 (FNHA-3-B-100.00), the Applicable Standards blocks will each

include a space for one standard. The part number shall be the number of this specification and the name shall be the name of this specification. This material is used in conjunction with standard Sealant Gasket Eliminator 86557106 (FNHA-2-E-069.00).

4. RELATED STANDARDS

86557106 (FNHA-2-E-069.00)—Sealant-Gasket Eliminator
86527126 (FNHA-4-C-002.00)—Application for Std 86557106

5. REQUIREMENTS**5.1 PHYSICAL PROPERTIES**

The typical properties are listed in Table 1.

5.2 CHEMICAL PROPERTIES

The chemical type is a basic copper salt in an acetone solvent.

5.3 SHELF LIFE

The compound shall have a shelf life of 18 months for a 500 ml container based upon the date of manufacture. Storage in unopened containers at or below 8 to 21°C (46 to 70°F) in a cool, dry condition for best stability.

THIS ITEM IS HIGHLY FLAMMABLE AND SHOULD BE STORED IN APPROPRIATE MANNER AND COMPLIANT WITH RELEVANT REGULATIONS.

					NAME	STD PRIMER 7649		
					 NEW HOLLAND		ENGINEERING SPECIFICATION	
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5.4 PACKAGING

The container shall contain 1 gallon.

5.5 MANUFACTURING PROCESSES

For manufacturing application see standard 86527126 (FNHA-4-C-002.00).

6. APPROVAL OF MATERIALS

Materials defined by this specification must have prior approval by the responsible Materials Engineering Activity. Suppliers desiring approval of their materials shall first obtain an expression of interest from the effected Purchasing, Design or Supplier shall submit to the affected Materials Engineering Activity its own Laboratory report to the specification (test results, not nominal values), the material designation and code number, and

test specimens for New Holland Inc. evaluation. Upon approval, the material will be added to the Materials Engineering Approved Source List.

7. SUPPLIER'S RESPONSIBILITY

All materials supplied to this specification shall be equivalent in all characteristics to the material upon which approval was originally granted. Prior to the making of any changes in the properties, composition, construction, color, dimensions, processing or labeling of the material originally approved under this specification, the supplier shall notify Purchasing and the affected Materials Engineering activity of the proposed changes and obtain the written acknowledgement of the Material Engineering activity. Test data, test samples and a new identification code are to be submitted with the request.

Table 1: Typical Properties

Description		Requirements	Units
Color		Clear Green	
Specific Gravity @ 25° C		0.792	
Viscosity @ 20° C		2	MPa, Sec.
Flashpoint		-18	°C
Drying Time @ 20° F	Minimum	30	Sec.
	Maximum	70	Sec.
On-Part Life	Loctite	30	Min.
	Hernon	1	Mo.

Part Number	Unit of Measure	Container Size	Description
86527120	Gallon	Bulk	PRIMER STD 86557987
87020487	Liter	Bulk	PRIMER 86557987

Engineering Approved Source List		
Supplier	Supplier Code	MSDS Code
Loctite Corporation	7649	N000192
Hernon Corporation	50	N000193

 NEW HOLLAND	NAME				PART NUMBER	
	STD PRIMER 7649				Documents	
	ENGINEERING SPECIFICATION				REV. D	FRAME 2
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