

Primer/Conditioner PC120

Technical Data Sheet



Benefits

- Improves Long Term Bond Durability of Aluminum or Stainless Steel Bonds
- Fast Drying
- Cleans Metal Surfaces Prior to Bonding

Recommended for use with all Plexus adhesives including, but not limited to the following, when bonding metals:

- | | |
|-------|-------|
| MA300 | MA425 |
| MA310 | MA550 |
| AO420 | MA555 |
| MA422 | |

Plexus Primer/Conditioner PC120 is a chemical primer and conditioner designed to improve the long-term bond durability of Plexus adhesives when used for adhering aluminum and stainless steel assemblies¹. Fast drying at ambient temperature, parts can be bonded 1 to 3 minutes after the primer is applied.

Typically, water and salt can attack bonded metal structures at the adhesive interface, potentially reducing the overall strength. The active ingredients in this primer allow the adhesive to produce a bond, which can resist long-term exposure to salt water.

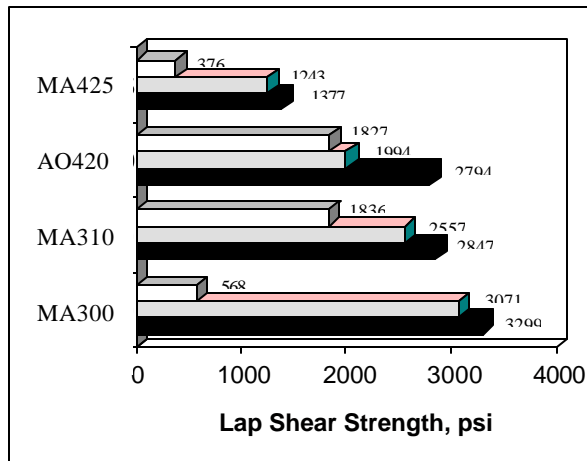
Plexus PC120 also acts as a cleaner to remove contaminants on the metal surface. In many circumstances the use of the PC120 can replace routine solvent cleaning.

Application can be performed by brushing or wiping. Only a thin film of PC120 is needed. The primer contains a red dye. As long as a red tint is visible on the primed surfaces, sufficient primer has been applied. Once the primer is dry, the parts are ready to bond.

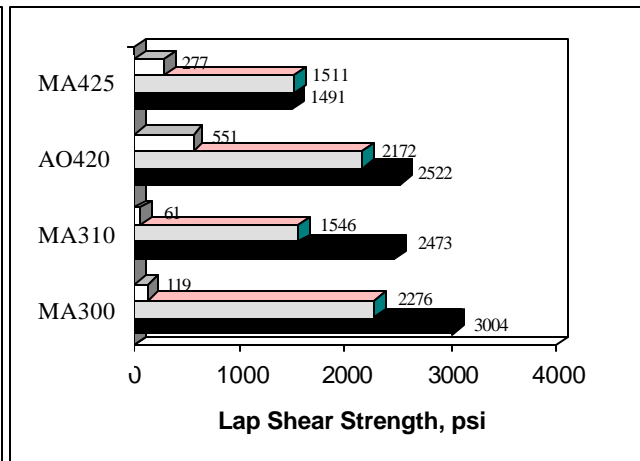
Plexus Primer/Conditioner PC120 is available in 1-quart containers. Coverage is about 250 square feet per pint.

Typical Lap Shear Test Results of Samples with Plexus Primer Tested Before and After Salt Spray Exposure (100° F, 98% RH, 5% Salt)

Control - With Primer
 2 Weeks in Salt Spray - With Primer
 2 Weeks in Salt Spray - Without Primer



Stainless Steel (304)



Aluminum (6061-T6)

DIRECTIONS FOR APPLICATION

Plexus™ Primer/Conditioner PC120 is a low viscosity liquid designed to be applied to aluminum and stainless steel parts prior to bonding with Plexus adhesives. Excess oils or contaminants should be wiped from the surface with a clean cloth. **The primer should be applied in a thin layer.** The usual application techniques are wiping, brushing, or spraying followed by a light wipe to leave a thin layer behind. PC120 contains a red dye to assist with proper application. When a red tint is seen on the assembly enough primer has been applied. An even amount of primer across the area to be bonded is recommended. Allow primer to dry before applying adhesive.

HANDLING AND SAFETY

Plexus™ Primer/Conditioner PC120 is flammable. Keep containers closed after use. Avoid skin and eye contact. Wash with soap and water after skin contact. In case of eye contact, flush with water for 15 minutes and get medical attention. Harmful if swallowed. Keep out of reach of children. Keep away from heat, sparks, and open flames.

SHELF LIFE AND STORAGE

Plexus Primer/Conditioner PC120 has a shelf life of 1 year in unopened containers when stored at temperatures of 60-80° F (15-26°C).

FOR MORE INFORMATION

For more information, contact ITW Plexus at (800) 851-6692. To assure maximum bond strength, surfaces must be mated within the specified working time of the adhesive.

¹ ITW Plexus strongly recommends all substrates be tested with the selected adhesive in the anticipated service conditions to determine suitability.

All information on this data sheet is based on laboratory testing and is not intended for design purposes. ITW Plexus makes no representations or warranties of any kind concerning this data. Due to variance of storage, handling and application of these materials, ITW Plexus cannot accept liability for results obtained

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