



TECHNICAL DATA SHEET – PLEXUS PC-120

Date: 06/2017

PRODUCT DESCRIPTION

Plexus Primer Conditioner PC-120 is a chemical primer and conditioner designed to improve the long term bond durability of Plexus adhesives when used for adhering aluminium and stainless steel assemblies¹. Fast drying at ambient temperatures 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 PC-120 also acts as an additional cleaner to remove contaminants on the metal surface. In many circumstances the use of PC-120 can replace routine solvent cleaning.

Application can be performed by brushing, spraying or wiping. Only a thin film of PC-120 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 PC-120 is available in 944ml containers. Coverage is circa 50sqm/L

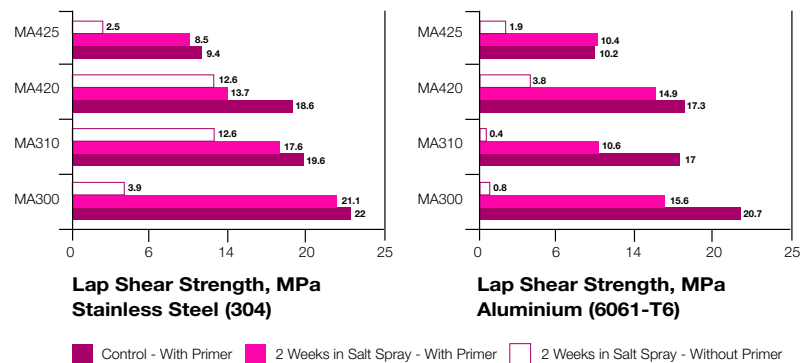
BENEFITS

- Improves long term bond
- Etch priming provides increased durability for Aluminium and Stainless Steel bonds
- Fast Drying

RECOMMENDED FOR USE WITH THE FOLLOWING PLEXUS ADHESIVES WHEN BONDING METALS:

MA300	MA550	MA425	MA530
MA420	MA2045	MA920	MA515
MA310	MA832	MA2090	MA830

TYPICAL LAP SHEAR TEST RESULTS OF SAMPLES WITH PLEXUS PRIMER TESTED BEFORE AND AFTER SALT SPRAY EXPOSURE (37°C, 98% RH, 5% SALT)



PLEXUS PC-120

DIRECTIONS FOR APPLICATION

Plexus PC-120 is a low viscosity liquid designed to be applied to aluminium and stainless steel parts prior to bonding with Plexus adhesives. Excess oils or contaminants should be wiped from the surface with a clean cloth using a suitable solvent.

The PC-120 should be applied in a thin layer. The usual application techniques are wiping, brushing or spraying. PC-120 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 the primer to dry before applying adhesive.

Using PC-120 as a cleaner conditioner will leave sufficient active ingredient on the metal surface to provide for enhanced protection. Excess amounts appearing in a deep red and heavy coating may produce opposite effects and weaken bonds.

HANDLING AND SAFETY

Plexus PC-120 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 seek medical attention. Harmful if swallowed. Keep out of reach of children. Keep away from heat, sparks and open flames.

SHELF LIFE AND STORAGE

Plexus PC-120 has a shelf life of twelve months in unopened containers when stored at temperatures of 15-30°C

FOR MORE INFORMATION

For more information, contact ITW Engineered Polymers at +353 61 771 500. To assure maximum bond strength, surface must be mated within the specified working time of the adhesive.

NOTES

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

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