

Metal Prep 90

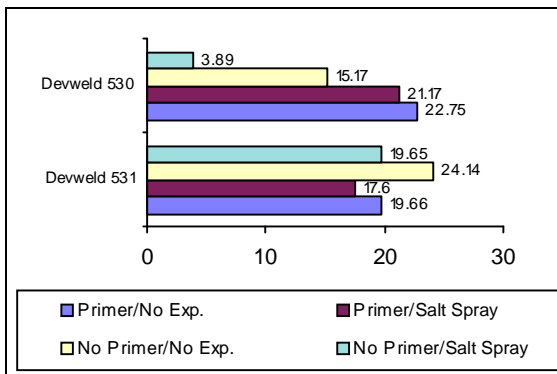
ORDERING INFORMATION

	<u>Stock No.</u> 19650	<u>Package Size</u> 473ml
Description	Metal Prep 90 is a chemical primer and conditioner that will improve the long-term durability of methacrylate adhesives when used to bond aluminium and stainless steel surfaces. It contains a red dye in an isopropyl alcohol carrier and also acts to clean contaminants on the metal surface when wiped on.	
Features	<ul style="list-style-type: none"> Improves long term durability of Devweld 530, Devweld 531, Plastic Welder and Composite Welder when used to bond aluminium and stainless steel. Can be used within minutes of applying Fast drying at ambient temperatures Cleans metal prior to bonding 	
Recommended applications	<ul style="list-style-type: none"> Bonding window and door assemblies Adhering aluminium panels Signage assembly 	

PRODUCT DATA

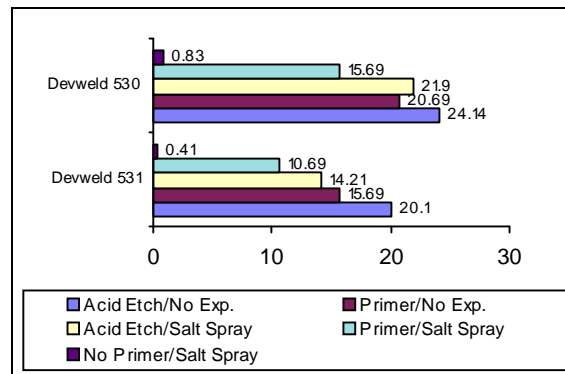
Typical Properties	Colour	Transparent red dye
	% Solids by volume	5
	Carrier solvent	Isopropyl Alcohol
	Density (grams/cm ³)	0.977
	Weight/litre	37
	Drying time, 24°C	1-3 minutes as wiped onto surface, red residue necessary
	Flash point	13°C
Shelf life	6 months @ room temperature (16-32°C)	
Coverage	18m ² /473ml	

**60 ga. Stainless Steel 304
Overlap Shear Strength (MPa)**



5% Salt spray 2 weeks @ 35°C

**60 ga. 6061-T6 Aluminium
Overlap Shear Strength (MPa)**



5% Salt spray 2 weeks @ 35°C

Test Procedure | Unprepared metal surfaces is wiped with Metal Prep 90 and allowed to dry 3 minutes before bonding. A bond thickness of 0.03" was used with a 25mm x 25mm over lap per ASTM D 1002 and allowed to cure 24 hours before salt spray exposure. An average of 5 samples was used and all were within one standard deviation.

Unit 3, Shipton Way, Express Business Park, Northampton Road, Rushden,
NN10 6GL, UK
ITW Devcon Industrial Products, Liebigstraße 21, 24145 KIEL,
Deutschland/Germany



Metal Prep 90

APPLICATION INFORMATION

Directions for application	Metal Prep 90 is an easy to use primer designed for priming aluminium and stainless steel parts prior to bonding with Devweld 530, Devweld 531, Plastic Welder and Composite Welder adhesives. Excess oils or contaminants should be wiped from the metal surface prior with a dry cloth. The primer should be applied in a thin coat. The recommended application technique is to wipe or brush on a thin, red layer and allow to dry. Cloth, sponge, brush, or roller may also be used. When a red tint is seen on the surface, enough primer has been applied. An even amount of primer across the bond area is recommended. Adhesive must be applied and parts assembled between 3 minutes and 7 days after priming; beyond 7 days the parts must be reprimed. Preprimed metal one week old has shown to maintain 95% of freshly primed metal bond strength after a two week exposure to 5% salt spray @ 35°C.
Handling and Safety	Close container after use to prevent alcohol evaporation. Avoid skin and eye contact. Wash it 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.
Storage and Shelf Life	Store in area above 16°C and not more than 32°C for a shelf life of 6 months as unopened. Opened containers should be reclosed tightly and stored away from sparks, heat, and open flames.
Precaution	For complete safety and handling information please refer to the appropriate Materials Safety Data Sheets prior to using this product.
Warranty	Devcon will replace any material found defective. Because the storage, handling, and application of this material is beyond our control, we can accept no liability for the results obtained and recommend the customer evaluate for their own end-use and exposure conditions.

WARNING: INDUSTRIAL USE ONLY

Disclaimer	<p>All information on this data sheet is based on laboratory testing and is not intended for design purposes. ITW Devcon makes no representations or warranties of any kind concerning this data.</p> <p>For product information visit www.devconeurope.com alternatively for technical assistance please call +44 (0) 870 458 7388 (UK) or +49 431 718830 (Germany)</p>
------------	--