



Metal Prep 90™

Description: Metal Prep 90 is a chemical primer and conditioner that will improve the long term durability of methacrylate adhesives when used to bond aluminum and stainless steel surfaces.

Intended Use: Improves long term durability of aluminum and stainless steel bonds with Flex Welder, Flex Welder FC, Plastic Welder and Plastic Welder II.

Product features: **Excellent corrosion resistant bond lines**
Cleans metal prior to bonding
Fast drying carrier

Limitations:

Typical Physical Properties: *Technical data should be considered representative or typical only and should not be used for specification purposes.*

Cured 7 days @ 75° F

Cured Density	0.977 gms/cm(3)
Shelf life	6 mos. @ 60-90°F
Solids by Volume	5

Uncured

Carrier Solvent	Isopropyl Alcohol
Color	Transparent red dye
Coverage/lb	200 sq.ft./pt.
Flashpoint	55°F
Weight	8.15 lb./gal.

Surface Preparation: Clean surface by solvent-wiping any deposits of heavy grease, oil, dirt, or other contaminants. Surface can also be cleaned with industrial cleaning equipment such as vapor phase degreasers or hot aqueous baths. If working with metal, abrade or roughen the surface to significantly increase the microscopic bond area and optimize the bond strength.

Mixing Instructions: Mixing is not applicable to this product. This is a primer system used to increase adhesion to your substrate. Follow instructions on the package for maximum results.

Application Instructions: Metal Prep 90 is an easy-to-use primer designed for priming aluminum and stainless steel parts prior to bonding with Flex Welder, Flex Welder FC, Plastic Welder and Plastic Welder II adhesives. Excess oils or contaminants should be wiped from the metal surface 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 Abrade and rePrime the parts. 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 @ 95°F.

Storage: Store in a cool, dry place.

Compliances: None

Chemical Resistance: *Rating chemical resistance is not necessary for this product.*

Precautions: Please refer to the appropriate material safety data sheet (MSDS) prior to using this product.
For technical assistance, please call 1-800-933-8266
FOR INDUSTRIAL USE ONLY

Warranty: Devcon will replace any material found to be defective. Because the storage, handling and application of this material is beyond our control, we can accept no liability for the results obtained.

Disclaimer: 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.

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