

PR-0100

Primer for polyamide preparation prior bonding

Material Summary

PR-0100 is a primer for preparation prior bonding of polyamide (PA66, PA6, PA12, etc.).
PR-0100 is a two-component curing primer.

The two components of the primer

| | Base compound (Part A) | Curing system (Part B) |
|---------------------------|------------------------|------------------------|
| Shelf life, max. | 6 months | 6 months |
| Storage temperature, max. | < 40 °C | < 40 °C |
| Storage humidity, max. | < 70% | < 70% |
| Color | Black | Yellow |

Mixing and application conditions of the primer

- Mixing ratio: 1 part by volume of Part A is added to 1,5 parts by volume of Part B
- Mixing process: can be made with a spatula
- Mixing time before use: < 5 minutes
- Mixed product color: black
- Mixed product work life: 2 hours in closed containers
- Application process of the primer on the polyamide: can be made with a paint brush or a paint roller

Primed polyamide parts

- Storage temperature: from 15 °C to 25 °C
- Storage relative humidity: 70 % max.
- Storage time: when stored in the original package, the storage life is of months without decrease of bondability

Curing

- 10 minutes at 100 °C

Application conditions of the epoxy adhesive

- The epoxy adhesive can be applied directly after the curing of the primer

Properties of the final assembly (Polyamide + Primer + Epoxy adhesive + Second substrate)

- Tensile lap shear strength at room temperature: > 5 MPa

Health & Safety

- Consult product specific Material Safety Data Sheet.

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