

PR-420 Primer

Description

PR-420 is a primer to enhance coupling characteristics of PR-1500 series polyurethane potting compounds to metal surfaces. The material cures to a durable coating with excellent resistance to weathering and water.

PR-420 is a two-part compound suitable for application by brush or spray.

The following tests are in accordance with PRC-DeSoto International specification test methods.

Application properties (typical)

Color	
Part A	Brown-Black
Part B	Orange
Mixed	Orange
Mixing ratio	Part A:Part B
By weight	13.7:100
Base viscosity	
(Ford #2 Cup), seconds	30
Dry time to potting/molding	
@ 77°F (25°C), 50% RH, hours	1
Tack free time @ 77°F (25°C),	
50% RH, hours	1
Application life, hours	
35°F (2°C) to 75°F (24°C)	8
76°F (25°C) to 100°F (38°C)	6
101°F (39°C) to 120°F (49°C)	4

Performance properties (typical)

Specific gravity	1.34
Nonvolatile content, %	33
Recommended thickness, dry mils	1-2
Adhesion to metal	Excellent

Note: The application and performance property values above are typical for the material, but not intended for use in specifications or for acceptance inspection criteria because of variations in testing methods, conditions and configurations.

Surface preparation

Immediately before applying PR-420 primer to metallic substrates, the surfaces should be cleaned with solvents. For stainless steel, blasting to a white metal appearance using #50 angular steel grit between 80 and 90 psi is recommended for optimum performance. Contaminants such as dirt, grease, and/or processing lubricants must be removed prior to sealant application.

A progressive cleaning procedure should be employed using appropriate solvents, and a new lint free cloth conforming to AMS 3819. (reclaimed solvents or tissue paper should not be used). Always pour solvent on the cloth to avoid contaminating the solvent supply. Wash one small area at a time. Wire insulation and inserts should not be exposed to cleaning solvent beyond the time necessary for adequate cleaning.

It is important that the surface is dried with a second clean cloth prior to the solvent evaporating to prevent the redeposition of contaminants on the substrate.

Apply a thin coat of PR-420 to the surface by brush and allow to dry for approximately 1 hour at standard temperature. If primed surface becomes contaminated or potting is not accomplished within the application life, repeat priming procedure.

Substrate composition can vary greatly. This can affect primer adhesion. It is recommended that adhesion characteristics to a specific substrate be determined prior to application on production parts or assemblies.

For a more thorough discussion of proper surface preparation, please consult the SAE Aerospace Information Report AIR 4069. This document is available through SAE, 400 Commonwealth Avenue, Warrendale, PA 15096-0001.

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Storage life

The storage life of PR-420 is at least 12 months when stored at temperatures below 80°F (27°C) in original unopened containers.

Health precautions

This product is safe to use and apply when recommended precautions are followed. Before using this product, read and understand the Material Safety Data Sheet (MSDS), which provides information on health, physical and environmental hazards, handling precautions and first aid recommendations. An MSDS is available on request. Avoid overexposure. Obtain medical care in case of extreme overexposure.

For industrial use only. Keep away from children.

**For emergency medical information call
1-800-228-5635.**

**Additional information can be found at:
www.bergdahl.com**

**For sales and ordering information call
775-323-7542.**

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