

# TECHNICAL DATA

## PR-1861 Adhesion Promoter

### Description

PR-1861 Adhesion Promoter is specially designed to promote adhesion of windshield sealants PR-1425CF and PR-1829 to windshield surfaces where crazing is a concern. Windshield surfaces include acrylic, polycarbonate, and glass.

PR-1861 is a one-part solution suitable for application by brush or clean gauze.

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

### Application Properties (Typical)

Color	Colorless
Appearance	Free of particles
Dry time, 30%-70% RH	
77°F (25°C)	30 minutes
60°F (16°C)	45 minutes
40°F (4°C)	45 minutes

### Performance Properties (Typical)

Specific gravity	0.80
Flash point, PMCC	54°F (12°C)
Effects on finishes	Does not craze acrylic or polycarbonate
Peel strength*, pli (N/25 mm), 100% CF	
Dry, 14 days at 77°F (25°C)	
MIL-G-25667 (Glass)	47 (206)
MIL-P-8184 (Acrylic)	65 (285)
MIL-P-83310 (Polycarbonate)	59 (258)

\*Tested with PR-1425CF B-1/2 windshield and canopy sealant.

**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 adhesion promoter to primed substrates, the surfaces should be cleaned with solvents. 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.

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.

### Application Instructions

Apply a thin coat of PR-1861 to the cleaned surface by brush or clean gauze pad and allow to dry for the required dry time. If primed surface becomes contaminated or sealing is not accomplished within 8 hours after application of the adhesion promoter, repeat priming procedure.

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.

### Packing Options

PR-1861 is supplied in one component bottles.

### Storage Life

The storage life of PR-1861 is at least 6 months when stored at temperatures below 80°F (27°C) in original, unopened containers. The material is hygroscopic and must be kept free of moisture. It should be discarded if it becomes cloudy or particles are visible.

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## 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.**

**Additional information can be found at:**

[www.bergdahl.com](http://www.bergdahl.com)

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