PRETHANE
PC-450

URETHANE PRIMER
TECHNICAL DATA BULLETIN

DESCRIPTION

PC-450 is a two-component primer used to increase the adhesion of urethane elastomers to other elastomeric compounds or as a tie coat to some metal surfaces. PC-450 cures at room temperature and provides a strong bond that in many cases exceeds the strength of the elastomer. This primer can be applied by spraying, brushing or dipping. In service at ambient temperatures it is resistant to fresh and salt water, many chemicals and other environmental conditions.

MIXING INSTRUCTIONS

Old urethane elastomeric surfaces must be ground or sanded to a "suede-like" texture and free of oil and dirt. An electric drill and wire brush will work for this application.

Mix one part Component A (clear) to one part Component B (amber) by volume and brush on to prepared surface with a stiff brush.

DRYING TIME

PC-450 dries to a slightly tacky film in approximately 30 minutes at room temperature, at which time urethane elastomers may be applied. If PC-450 is to be cast and heat cured, the primer should be allowed to dry for one hour to allow all solvents to evaporate.

COVERAGE

Coverage obtained with PC-450 will depend on the porosity or roughness of the substrate being primed. Typical coverage will range from 100 to 400 square feet per gallon. The dry film thickness when priming smooth substrates should be approximately one mil per coat. Over spray and waste must be taken into account when estimating the quantity or material required for a particular job.

WORKING PROPERTIES

Uncured	Test Methods (ASTM)	Value
Viscosity Part A at 72 F, cps	D-2392-71	1,600
Viscosity Part B at 72 F, cps	D-2392-71	250
Viscosity Mixed at 72 F, cps	D-2392-71	500
Mixed Ratio by Volume		100-A/100-B
Weight per gallon, lbs		7.67
Cubic inches per pound		24.57

Cure Schedule	Test Methods (ASTM)	Value
Pot Life	D-2471-71	15 min
Full Cure		24 hrs