

PR-0100

Aerospace primer for polyamide prior to adhesive bonding
Qualified to AIMS 10-15-006

Product Description

PR-0100 is an epoxy-based two-component, heat-curing primer designed to prepare polyamide (PA66, PA6, PA12, etc.) for bonding. Available in several packaging formats.

Key Product Attributes

- High adhesion on polyamide
- Primed polyamide parts have indefinite shelf life if stored properly
- Reach compliant, no CMR
- Easy application

Technical Data



TYPICAL PROPERTIES

	Part A	Part B
Appearance	Black liquid	Low viscosity yellow liquid
Mix Ratio (by weight)	48	100
Mix Ratio (by volume)	33	100
Density (ISO 2811)	1.15 kg/L, [9.60 lb/gal]	0.85 kg/L, [6.76 lb/gal]
Mixing Time	5 min approx.	
Pot-Life (ISO 10364)	Approx. 2h in a closed container	
Service Temperature	-55 to 85°C, [-67 to 185°F]	
Curing Conditions*	12±2min @ 100±5°C, [212±9°F]	
	125±5min @ 65±5°C, [150±9°F]	

* Other curing conditions should be tested before use

PROPERTIES IN MIXED CONDITION

Properties	Test Methods	Units	Results
Color	Visual	N/A	Black
Work life (pot life)	ISO10364	Min	≤ 90

MECHANICAL PROPERTIES

	L&L Seal PA Primer	Test Method
Lap Shear Strength on Al/PA+primer/Al @ -55°C, [67°F]	6 MPa, [870 psi]	ISO 4587
Lap Shear Strength on Al/PA+primer/Al @ 23°C, [75°F]	7 MPa, [1,015 psi]	ISO 4587
Lap Shear Strength on Al/PA+primer/Al @ 85°C, [185°F]	3.6 MPa, [522 psi]	ISO 4587
Lap Shear Strength on Al/PA+primer/Al @ 23°C, [75°F] after heat ageing (dry-heat) @ 85°C, [185°F]	7 MPa, [1,015 psi]	ISO 4587
Lap Shear Strength on Al/PA+primer/Al @ 55°C, [67°F] after ageing cycles 3 x 24h @ 70°C, [158°F] / 95% R.H.	6 MPa, [870 psi]	ISO 4587

*The data should be considered typical, and not for specification purposes

Tested Substrates Etched Aluminum 2024T3 - thickness 1.6mm
 Primed Polyamide (PA6) - thickness 2mm
 L-9107 2-Component Epoxy Adhesive - thickness 125µm

Shelf Life & Storage Conditions

Shelf Life 12 month from production date stored between 15 to 25°C, [59 to 77°F], at less than 70% R.H. in original packaging. Primed parts have an indefinite open-time when stored according to these conditions. Keep parts free from dust, and out of direct sunlight.

Special Handling This material should be stored in non-flammable storage. Keep away from direct sunlight and all sources of heat and ignition. Keep properly sealed when not in use. If Part A crystallizes during storage, it can be restored by warming the material to 50°C, [122°F] for 3h while stirring.

Application

General The following recommendations are for informational purposes only. Before attempting any bonding application users should test adhesion to the surface using their specific material and application. Any applications involving critical or serial production should consult L&L Products Technical Service & Support Staff.

Surfaces must be clean, dry; and free of dust, debris, and any loose oxides or coatings. Heavy oils and grease must be removed. Clean surfaces thoroughly using a general purpose industrial organic solvent. Consult L&L Products Technical Service & Support staff.

Mix the material manually and apply with a paint brush or roller, but do not use absorbant foam brushes or rollers.

The primer shall be applied to both surfaces as an uniform thin layer.

Make sure to close the lid immediately after use, the product may gel if the packaging is left open for extended periods.

Shake well before using.

Health & Safety

Safety Precautions Avoid contact with skin and eyes. Consult product-specific Safety Data Sheet for all safety and environmental information concerning use and disposal of this product.

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