A brand of ITW Polymers Adhesives North America

TECHNICAL DATA SHEET

PLEXUS PC-120

Description

Plexus® Cleaner Conditioner PC-120 is a chemical cleaner and conditioner designed to improve the long-term bond durability of Plexus adhesives when used for adhering aluminum and stainless steel assemblies[1].
Fast drying at ambient temperatures, parts can be bonded 1 to 3 minutes after the conditioner is applied.

Typically, water and salt can attack bonded metal structures at the adhesive interface, potentially reducing the overall strength. The active ingredients in this cleaner allow the adhesive to produce a bond which can resist long term exposure to salt water.

Plexus PC-120 acts as a cleaner to remove contaminants on the metal surface. In many circumstances, the use of PC-120 can replace routine solvent cleaning.

Application can be performed by brushing or wiping. Allow the PC-120 to dry slightly before wiping away. Only a thin film of PC-120 is needed. The primer contains a red dye. As long as a red tint is slightly visible on the metal surfaces, sufficient conditioner has been applied. Once the conditioner is dry, the parts are ready to bond.

Plexus PC-120 is available in 944-mL containers. Coverage is about 250 square feet per 500 mL.

Benefits

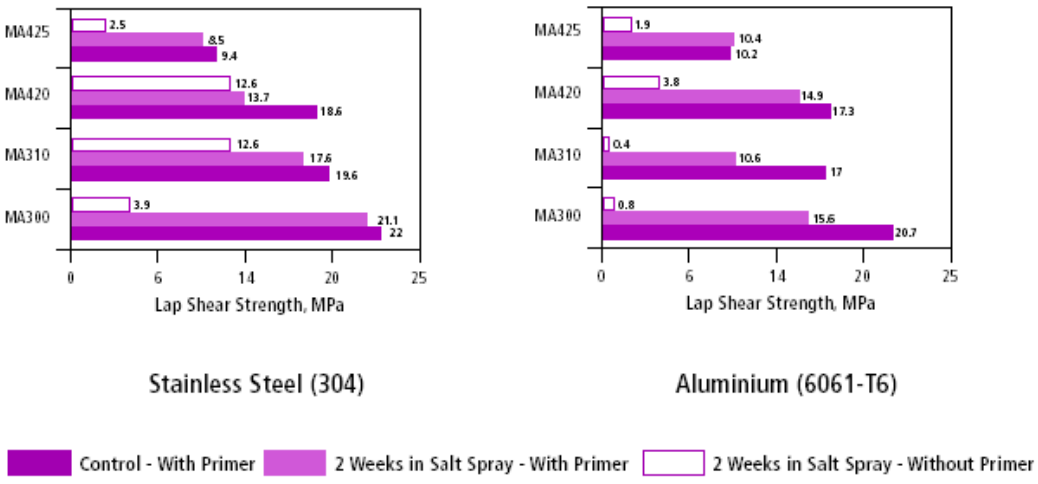
- Improves long term bond
- Durability of Aluminum or Stainless Steel bonds
- Fast Drying
- Cleans metal surfaces prior to bonding

Recommended for use with the following Plexus adhesives when bonding metals:

MA300	MA550	MA920	MA530
MA420	MA320	MA830	MA560-1
MA310	MA425	MA832	MA590

Typical Lap Shear test results of samples with Plexus cleaner conditioner primer tested before and after salt spray exposure

(37°C, 98% RH, 5% Salt)



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DIRECTIONS FOR APPLICATION

Plexus PC-120 is a low-viscosity liquid designed to be applied to aluminum and stainless steel parts prior to bonding with Plexus adhesives. Excess oils or contaminants should be wiped from the surface with a clean cloth. The conditioner should be applied in a thin layer. The usual application techniques are wiping, brushing, or spraying. PC-120 contains a red dye to assist with proper application. When a red tint is seen on the assembly enough primer has been applied. An even amount of cleaner/conditioner across the area to be bonded is recommended. Allow the PC-120 to dry before applying adhesive.

Although Plexus PC-120 is often called a primer, it is not one in the sense that a large coating should be applied to the metal surface. Using PC-120 as a cleaner conditioner will leave sufficient active ingredient on the metal surface to provide for enhanced protection. Excess amounts appearing in a deep red and heavy coating may produce opposite effects and weaken bonds.

HANDLING AND SAFETY

Plexus PC-120 is flammable. Keep containers closed after use. Avoid skin and eye contact. Wash with soap and water after skin contact. In case of eye contact, flush with water for 15 minutes and seek medical attention. Harmful if swallowed. Keep out of reach of children. Keep away from heat, sparks and open flames.

SHELF LIFE AND STORAGE

Plexus PC-120 has a shelf life of twelve months in unopened containers when stored at temperatures of 59°F – 86°F (15°C – 30˚C).

FOR MORE INFORMATION

For more information, contact ITW PANA at 800-851-6692. To assure maximum bond strength, surfaces must be mated within the specified working time of the adhesive.

Notes

1. **ITW PANA strongly recommends that all substrates be tested with the selected adhesive under anticipated service conditions to determine suitability.**

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