



User Guide: Surface Preparation for structural bonding

Metal bonding

Thoroughly clean the surface with a suitable solvent to remove all grease, oil and dirt. Grit blast surface area with 8-40 mesh grit, or grind with a coarse wheel or abrasive disc pad to create increased surface area for better adhesion (CAUTION: An abrasive disc pad can only be used provided white mesh is revealed). The desired profile is 3-5mil, including defined edges (Do not 'feather-edge' epoxy). Note: For metals exposed to seawater or other salt solution, grit blast and high pressure water blast the area, then leave overnight to allow any salts in the metal to 'sweat' to the surface. Repeat blasting to 'sweat out' all soluble salts. Perform chloride contamination test to determine soluble salt content (should be less than 40ppm). Clean the surface again with a suitable solvent to remove all traces of grease, oil, dust, or other foreign substances from the grit blasting.

Repair surface as soon as possible to eliminate any changes or surface contaminates

In summary:

1. Degrease
2. Abrade (for best results)
3. Degrease
4. Apply primer
5. Allow primer to dry to just tacky (approximately 40 - 90 minutes @ RT)
6. Cast PU and allow material to cure

Primers

A properly prepared substrate is essential to achieve consistent bond performance.

A suitable solvent or cleaning agent prior to the application of the primer should remove all oil, grease and other soluble material from the substrates.

Rust or scale or other loose debris should also be removed by mechanical or chemical methods.

Grit blasting, mechanical abrasion or chemical etching will aid the adhesion of the primer to the substrate, and will significantly increase bond strength.

Primers can be applied by; dipping, brushing or spraying.

Spraying may involve the dilution of the material with a suitable solvent

Contact: **Technical Support on 01793 823741** or support@robnor.co.uk for details.

Robnor primers have been formulated to provide optimum bond strength with one coat. Thick primer layers generally result in lower bond strength.

Resins Online Call us on 01793 823741

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