

MetaLink

Technical Data Sheet (TDS)

Product Description

MetaLink is an environmentally friendly, chromate free, pre-bond adhesion promoter for aluminum prior to application of primer.

Product features:

- Waterborne
- No corrosion acid
- Spray on, no rinse, ambient dry
- Little or no waste

Recommended Uses

MetaLink is intended for industrial applications, either new build or maintenance.

MetaLink is a suitable pre-treatment of Aluminum and its alloys such as: Aluminum (#2024, #5052, #6061, #7071 and #7075); prior to application of the following Endura primers.

- EP-2C CF
- EP-2C FC CF
- EP-PA LOW VOC CF
- Epoxy Primer Sealer

Mix Ratio

1 MetaLink A- Orange	[FAD0012]
1 MetaLink B	[FAD0011]
1 MetaLink C	[FAD0009]

Mixing Procedure:

Step 1	Pour MetaLink B and MetaLink C into the MetaLink A Bottle
Step 2	Hand shake the mixture of A&B&C for 1 minute.
Step 3	Allow a 30 minute Induction time prior to application.
MetaLink must be mixed as full kits.	

Product Characteristics

Pot Life: (77°F (25°C) and 50% RH)	10 Hours
Shelf Life:	
MetaLink Component A	2 years
MetaLink Component B	2 years
MetaLink Component C	2 years
For unopened product (77°F (25°C))	

Surface Preparation

Procedure:

1. Degrease the surface thoroughly with soap and water and/or Endura Degreaser 10 to remove any surface contaminants, oil, or paint stripper residue.
2. Sand the surface thoroughly with 180-220 grit sandpaper or a Maroon Nylon scuff pad to remove any surface oxidation.
3. Blow sanding dust from the surface with clean compressed air.

IMPORTANT NOTE: Sanding aluminum before the application of MetaLink removes oxidation and exposes the active aluminum surface. MetaLink adheres tenaciously to the active aluminum surface.

The prepared surface must not be wiped, washed, or wetted in any way after sanding and before application of MetaLink. The active sites in the aluminum after sanding will be neutralized if they encounter ANY liquid (solvent or water-based products). This will eliminate the opportunity for MetaLink to bond to the aluminum causing ADHESION FAILURE.

Time between completion of sanding and application of the Endura MetaLink should not exceed 3 hours.

Application Method

After the induction time, apply the mixture in a thin wet film by spray or by manual application with a pure nylon polyester brush.

Do not allow the product to puddle.

Any excess accumulation at seams, crevices or rivet areas must be removed with clean compressed air.

Spray Gun Setup

Feed Type	Fluid Tip	Application Pressures (heel of gun)	Fluid Delivery
Siphon Feed	1.6-1.8 mm	40 - 50 psi	
Gravity Feed	1.3-1.8 mm	30 - 40 psi	
Pressure Feed	0.8-1.2 mm	30 - 40 psi	7 - 8 oz/min
Air Assist Airless	Not Recommended		
Airless			

Spray Viscosity

Once mixed, MetaLink is at spraying viscosity.

Do Not Thin.

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Film Build

MetaLink has a recommended film build thickness.

Wet: WFT Unreduced	< 1.0 mils	< 25 microns
Dry: DFT	0.3 – 0.5 mils	7.5 – 12.5 microns

Theoretical coverage: 200 – 300 ft² per gallon

Dry Time

	68°F (20°C)
Dry to Prime	1-2 Hours
Max time to Prime	8 Hours

Do not apply EX-2C topcoat directly over MetaLink. MetaLink must be coated with the recommended primers before topcoat application.

Ordering Information (sizing)

MetaLink Kit – Complete	
Pint Kit (473 ml)	FKT0001-010
Quart Kit (946 ml)	FKT0001-020
Gallon Kit (3.78l)	FKT0001-030
Other custom sizes may be available.	

Individual Part Codes for Kits	
1 pint kit (473 ml)	
Comp A - Orange	FAD0012-010
Comp B	FAD0011-01B
Comp C	FAD0009-01C

1 quart kit (946 ml)	
Comp A - Orange	FAD0012-020
Comp B	FAD0011-02B
Comp C	FAD0009-02C

1 gallon kit (3.78l)	
Comp A - Orange	FAD0012-030
Comp B	FAD0011-03B
Comp C	FAD0009-03C

Storage

MetaLink must be stored at room temperature.
Do not allow to freeze.