

Technical Data Sheet (TDS)

Product Description

Endura 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 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

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.

1 MetaLink A-Clear [FAD0008]

OR

1 MetaLink A- Orange [FAD0012]

1 MetaLink B [FAD0011]

1 MetaLink C [FAD0009]

Note: Metalink must be mixed as full Kits

Product Characteristics

Pot Life of Mixed Product:

10 Hours at 70°F (25°C) and 50% RH

Shelf Life Component A, B or C: 6 Months

Note: For unopened product

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 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 Endura MetaLink removes oxidation and exposes the active aluminum surface.

Endura 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 the come into contact with 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.

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Application Method

Apply the mixture after the induction time, 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 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 Airless	Not Recommended		

Spray Viscosity

MetaLink is at spraying viscosity.

Do Not Thin.

Film Build

Endura MetaLink has a recommended film build thickness.

Wet: (unreduced): < 1.0 mil (25 microns)

Dry: 0.3 – 0.5 mils DFT (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 hrs

Note:

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

Ordering Information (sizing)

Available in Quart and Gallon Kits.
Other custom sizes may be available.

1 Quart Kit		
Comp A – Clear OR	FAD0008-020	Qt Kit
Comp A - Orange	FAD0012 -020	Qt Kit
Comp B	FAD0011-020	Qt Kit
Comp C	FAD0009-020	Qt Kit

1 Gallon Kit		
Comp A – Clear OR	FAD0008-030	Gal Kit
Comp A - Orange	FAD0012 -030	Gal Kit
Comp B	FAD0011-030	Gal Kit
Comp C	FAD0009-030	Gal Kit

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Storage

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

Safety Precautions

Please refer to all Safety Data Sheets (SDS) before using this product. SDS sheets can be found on our website at www.endura.ca.