

## 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]

MetaLink must be mixed as full kits.

#### Mixing Procedure:

<b>Step 1</b>	Pour MetaLink B and MetaLink C into the MetaLink A Bottle
<b>Step 2</b>	Hand shake the mixture of A&B&C for 1 minute.
<b>Step 3</b>	Allow a 30 minute Induction time prior to application.

#### Product Characteristics

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

#### 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 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

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	Not Recommended		
Airless			
Airless			

#### Spray Viscosity

Once mixed, MetaLink is at spraying viscosity.

**Do Not Thin.**

#### Film Build

MetaLink has a recommended film build thickness.

<b>Wet: WFT Unreduced</b>	<b>&lt; 1.0 mils</b>	<b>&lt; 25 microns</b>
<b>Dry: DFT</b>	<b>0.3 – 0.5 mils</b>	<b>7.5 – 12.5 microns</b>

Theoretical coverage: 200 – 300 ft<sup>2</sup> per gallon

#### Dry Time

	<b>68°F (20°C)</b>
<b>Dry to Prime</b>	1-2 Hours
<b>Max time to Prime</b>	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)

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

MetaLink Kit	
Pint Kit	FKT0001-010
Quart Kit	FKT0001-020
Gallon Kit	FKT0001-030

#### Individual Part Codes for Kits

1 Pint Kit	
Comp A - Orange	FAD0012-010
Comp B	FAD0011-01B
Comp C	FAD0009-01C

1 Quart Kit	
Comp A - Orange	FAD0012-020
Comp B	FAD0011-02B
Comp C	FAD0009-02C

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1 Gallon Kit	
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.**

#### Safety Precautions

Please refer to all Safety Data Sheets (SDS) before using this product. SDS sheets can be found on our website at [www.endurapaint.com](http://www.endurapaint.com).