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# TECHNICAL DATA

## PR-184 Adhesion Promoter

### Description

PR-184 is an advanced one-part sealant adhesion promoter and surface cleaner for use on metal and solvent resistant coatings.

PR-184 contains non-toxic ester-based solvent blend, compounded with a surface activator agent and an indicator dye.

This product is qualified to manufacturers' specifications. Please contact PRC-DeSoto Europe for further details.

### Application Properties (Typical)

Colour	Red
Appearance	Free of particles
Drying Time (50% RH)	25°C (77°F) 30 minutes 5°C (41°F) 60 minutes

### Performance Properties (Typical)

Specific Gravity	0.92
Flash Point (ISO 2592) °C	30°C (86°F)
Effect on Finish	Does not soften finishes.
Solvency	Excellent soil remover and degreaser. Does not leave surface residues.

### Peel Strength \* (N/25mm (pli), % Cohesion Dry

	Without Adhesion Promoter	PR-184 ** Adhesion Promoter
Aluminium (Clad 2024)	175 (39), 100	175 (39), 100
Titanium (AMS 4911)	169 (38), 100	182 (41), 100
Stainless Steel (AMS 5513)	182 (41), 100	182 (41), 100
Water Based Primer (P60)	191 (43), 100	187 (42), 100
P/U Primer (PAC 33 NV)	182 (41), 100	182 (41), 100
HS P/U Primer (PR205)	169 (38), 100	182 (41), 100
Water Based Topcoat (F70)	191 (43), 100	142 (32), 100
HS Epoxy Topcoat (EC99)	160 (36), 100	196 (44), 100

\* Tested with PR1782B sealant.

\*\* PR-184 is not recommended for use on substrates where solvent crazing would be of concern (e.g. acrylic). Please examine use of our PR-142 adhesion promoter instead.

### Fuel Immersion \* (ISO 1817) 168 hours @ 60°C (140°F)

	Without Adhesion Promoter	PR-184 Adhesion Promoter
Water Based Primer (P60)	147 (33), 100	133 (30), 100
P/U Primer (PAC 33 NV)	133 (30), 100	133 (30), 100
HS P/U Primer (PR205)	138 (31), 100	133 (30), 100
Water Based Topcoat (F70)	138 (31), 100	124 (28), 100
HS Epoxy Topcoat (EC99)	133 (30), 100	129 (29), 100

### De-icing Fluid Immersion \* (ISO 11075 Type I) 168 hours @ 23°C (73.4°F)

	Without Adhesion Promoter	PR-184 Adhesion Promoter
Water Based Primer (P60)	120 (27), 100	138 (31), 100
HS P/U Primer (PR205)	116 (26), 100	138 (31), 100
Water Based Topcoat (F70)	125 (28), 100	133 (30), 100
HS Epoxy Topcoat (EC99)	133 (30), 100	142 (32), 100

### Fuel Immersion \* (DERD 2494) @ 100°C (212°F)

	Without Adhesion Promoter	PR-184 Adhesion Promoter
Water Based Primer (P60)	120 (27), 100	124 (28), 100
P/U Primer (PAC 33NV)	22 (98), 100	98 (22), 100
HS P/U Primer (EC99)	33 (147), 100	147 (33), 100

### Surface Preparation

Immediately before applying adhesion promoter to primed substrates, the surface should be cleaned with solvents. Contaminants such as dirt, grease, and/or processing lubricants must be removed prior to sealant application.

A progressive cleaning procedure should be employed using appropriate solvents and a new lint-free cloth conforming to AMS 3819. (Reclaimed solvents or tissues paper should not be used). Always pour solvent on the cloth to avoid contaminating the solvent supply. Wash one small area at a time.

It is important that the surface is dried with a second clean cloth prior to the solvent evaporating to prevent the redistribution of contaminants on the substrate.

# PR-184 Adhesion Promoter

## Application Instructions

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Apply a thin coat of PR-184 to the solvent-cleaned surface by brush or clean gauze pad and allow to dry for the required dry time. After dry time wipe off excess PR-184 with a clean gauze pad and start the sealing procedure. If primed surface becomes contaminated or sealing is not accomplished within 4 hours after application of the adhesion promoter, repeat priming procedure. For a more thorough discussion of proper surface preparation, please consult the SAE Aerospace Information Report AIR 4069. This document is available through SAE, 400 Commonwealth Avenue, Warrendale, PA 15096-0001.

## Packing Options

PR-184 Adhesion promoter is supplied in one-part containers.

## Storage Life

The storage life of PR-184 is at least 6 months when stored at temperatures below 80°F (27°C) in original, unopened containers.

PR-184 is hygroscopic and must be kept free from moisture - always replace cap immediately after use. Discard product if it becomes cloudy or a precipitate is formed.

## Health Precautions

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This product is safe to use and apply when recommended precautions are followed. Before using this product, read and understand the Material Safety Data Sheet (MSDS), which provides information on health, physical and environmental hazards, handling precautions and first aid recommendations. An MSDS is available on request. Avoid overexposure. Obtain medical care in case of extreme overexposure.

**For industrial use only. Keep away from children.**

**Additional information can be found at:**

**[www.ppgaerospace.com](http://www.ppgaerospace.com)**

**For sales and ordering information call 1-800-AEROMIX (237-6649).**

All recommendations, statements, and technical data contained herein are based on tests we believe to be reliable and correct, but accuracy and completeness of said tests are not guaranteed and are not to be construed as a warranty, either expressed or implied. User shall rely on his own information and tests to determine suitability of the product for the intended use and assumes all risks and liability resulting from his use of the product. Seller's and manufacturer's sole responsibility shall be to replace that portion of the product of this manufacturer which proves to be defective. Neither seller nor manufacturer shall be liable to the buyer or any third person for any injury, loss, or damage directly or indirectly resulting from use of, or inability to use, the product. Recommendations or statements other than those contained in a written agreement signed by an officer of the manufacturer shall not be binding upon the manufacturer or seller. Printed in U.S.A.

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