

Endura MetaLink is an environmentally friendly, chromate free, pre-bond adhesion promoter for bonding metal alloys such as: Aluminum (#2024, #5052, #6061, #7071 and #7075).

### Product Features

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

### Theoretical Solids

Content:  
Volume: N/A

### Shelf Life\*

Single Component: 6  
Months

\*For unopened product.

### Pot Life of Mixed

Product:  
10 Hours @ 77°F  
(25°C) and 50% RH



### Important Information

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 are exposed by sanding, these active sites will be neutralized if contacted by ANY liquid (solvent or water based products) and eliminates the opportunity of Endura MetaLink to bond to the aluminum. If aluminum surface is wetted after sanding and prior to MetaLink application ADHESION FAILURE will occur.***

Blowing sanding dust from the surface with clean compressed air is all that is allowed.

Washing aluminum surfaces with soapy water/degreasers/solvents **PRIOR** to sanding is desirable and effective for proper surface preparation.



### Surface Preparation

1. Degrease the surface thoroughly with soap and water and/or Endura Degreaser 10 and/or EX-2C Thinner and/or Lacquer thinner to remove any surface contaminants, oil or paint stripper residue.
2. Sand the surface thoroughly with 180-220 grit sandpaper to remove any surface oxidation. Thorough use of an appropriate Nylon scuff pad (3M Red) is also acceptable to remove the oxidation.

*Use of a lint free rag with thinner or a tack cloth **MUST NOT** be used for removal of the surface debris after deoxidizing the aluminum surface. Blowing sanding dust from the surface with clean compressed air is all that is allowed.*

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

### Mixing Procedure

- Step 1: Pour part B and C into the bottle of part A  
Step 2: Hand shake the A&B&C mixture for 1 minute  
Step 3: Allow 30 minutes as Induction time.

|        | Quart Kit      |             | Gallon Kit     |             |
|--------|----------------|-------------|----------------|-------------|
|        | Weight (grams) | Volume (ml) | Weight (grams) | Volume (ml) |
| Part A | 800            | 833         | 3,200          | 3,333       |
| Part B | 28.9           | 29          | 115.6          | 116         |
| Part C | 14.3           | 13          | 57.2           | 53          |
| Total  | 843.2          | 875         | 3,373          | 3,502       |

## MetaLink

Endura MetaLink is an environmentally friendly, chromate free, pre-bond adhesion promoter for bonding metal alloys such as: Aluminum (#2024, #5052, #6061, #7071 and #7075).

### Product Features

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

### Theoretical Solids Content:

Volume: N/A

### Shelf Life\*

Single Component: 6 Months

\*For unopened product.

### Pot Life of Mixed Product:

10 Hours @ 77°F (25°C) and 50% RH



### Spray Gun Setup

| Feed Type          | Fluid Tip              | Application Pressures (heel of gun) | Fluid Delivery |
|--------------------|------------------------|-------------------------------------|----------------|
| Siphon Feed        | 1.6-1.8 mm             | 80 psi                              |                |
| Gravity Feed       | 1.3-1.8 mm             | 40 psi                              |                |
| Pressure Feed      | 0.8-1.2 mm             | 40 psi                              | 7-8 oz/min     |
| Air Assist Airless | <b>Not Recommended</b> |                                     |                |
| Airless            |                        |                                     |                |

Not recommended for use with HVLP spray equipment.



### Application Method

Apply the mixture after induction time, in a thin, wet film by spray or by manual application with a pure bristle brush. The recommended wet film thickness is less than 1 mil.

#### Do not allow the product to puddle.

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



### Recommended Film Build Thickness and Cover Rate

Endura MetaLink has a recommended film build thickness of <1 mil.

Theoretical coverage of 200-300 ft<sup>2</sup> per gallon per 0.3 – 0.5 DFT



### Drying Time\*

Endura MetaLink **must be dried, before the application of epoxy primer.**

Allow the Endura MetaLink to dry for 1 - 2 hours at room temperature 21 °C (70 °F) or an elevated temperature, before the application of epoxy primer.

**Do not apply EX-2C topcoat directly over Endura MetaLink. Endura MetaLink must be coated with Endura epoxy primer before topcoat application.**

### Storage

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