

L-312

Adhesive Primer, Epoxy Phenolic



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Product Data Sheet

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Description

L-312 is an adhesive primer designed to promote surface wetting of adhesive films. In addition, L-312 provides protection for aluminum detail parts after surface preparation for bonding. L-312 may be applied by brushing, spraying, or dipping detail aluminum parts.

Advantages of L-312

- ❖ L-312 adhesive primer allows aluminum detail parts to be stored after cleaning and etching procedures have been completed without degrading the subsequent adhesive bond.
- ❖ L-312 requires only a 30 minute air dry after priming.
- ❖ Room Temperature stability eliminates the need for cold storage.

Physical Properties

- *Color :* Light Blue
- *Solids Content:* 5% Nominal
- *Form:* Sprayable Liquid
- *Caution:* Flammable, perform all mixing in well ventilated area away from heat

Availability

- 1 Gallon (3.8 L)
- 5 Gallon (18.9 L)
- 55 Gallon (208 L) Drum



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Shelf Life

- *6 months at Room Temperature (75°F or 24°C)*

Curing

- *L-312 cures concurrently with standard epoxy film adhesives over a broad range of time and temperatures – from 200°F (93°C) to 365°F (185°C) from 20 minutes to 120 minutes.*

Application

- *Prior to priming, aluminum detail parts should be cleaned and etched to a water break free condition. The details should be rinsed and dried.*
- *Apply L-312 immediately after drying is completed and within a time limit which prevents the reformation of aluminum oxides on the detail surface.*
 - 1) *Allow L-312 to reach room temperature before opening the container.*
 - 2) *Spray details with a uniform cross coat to a dry film thickness of 0.0001” to 0.0003” (0.0025 mm to 0.008 mm) thick.*
 - 3) *Air dry detail parts for 30 minutes minimum after priming.*
 - 4) *The details should be stored in a clean, dry environment prior to lay up and bonding.*

NOTICE:

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