

# DINITROL 538 PLUS

## One-step primer for use with all DINITROL polyurethane adhesives

DINITROL 538 Plus is a one-step primer for windscreen bonding. DINITROL 538 Plus is a solvent containing, physically and chemically drying black primer which promotes the adhesion between the glass/paint surface and the direct glazing adhesive and acts as a UV protection.



- » One-step primer for glass and ceramic coating
- » Pretreatment of RIM and paints
- » Rust-proofing for smaller scratches in paint
- » Compatible with all DINITROL polyurethane adhesives



### Equipment

**INDUSTRIAL NITRILE GLOVES 10-P**  
 Art. No. 1734100 (XL)  
 Art. No. 1734300 (LG)

### DINITROL 538 PLUS

Art. No.	Size	Package	Color
12349	10 ml	Stick	Black
<b>Other packages</b>			
12404	30 ml	Bottle	Black
12341	100 ml	Bottle	Black

a brand of



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# DINITROL 538 PLUS

## Technical Details

### Characteristics

DINITROL 538 plus primer is a „one-step primer“ with additional functions for window bonding with polyurethanes. It is a solvent-based, physically and chemically drying black primer which and chemically drying black primer that ensures adhesion between glass/ceramic and the pane adhesive and increases the UV protection of the screen print.

### Features

- 1-Step Primer as adhesion promoter, activator, corrosion and UV protector
- Excellent adhesion on glass, ceramic screen printing, paint and various metals
- Controlled quick application by the foam applicator (tube)
- Supports the longterm safety of replaced windscreens by DINITROL adhesives

### Surface pre-treatment

The surface to be treated must be clean, dry and free of dust, oil and grease. Thoroughly clean glass bonding surface of the new windshield with DINITROL 582 to remove stubborn contamination on glass surfaces and the ceramic screen printing. It is recommended to carry out the pre-treatment according to the DINITROL work instructions for windshield replacement.

***Abrading the glass and/or ceramic frit bonding surface will enhance the adhesive and primer bond.***

### Application

Before use, acclimatize the bonding surface and primer. Shake the primer bottle until the balls can be heard, then another minute. Primer is applied by DAUBER (Wool Wiper) or Melamine Foam. Apply primer evenly in one direction (approx. 5 - 20 µm). This process may be repeated max. 2 times (reactivation or leveling of rough surfaces). Close the primer again immediately after removal.

### Method of use

Before use of the primer DINITROL 538 Plus, shake the bottle thoroughly until paint mixing balls rattle freely. Mix for an additional one minute. The application of the primer DINITROL 538 Plus can be done manually by felt and/or an adequate tool.

### Important Note

Due to its moisture reactivity, the primer must be used within 7 days after the first opening of the bottle. This product is suitable for experienced users only. For special applications, preliminary tests are required.

### Storage

Between 32 and 95°F, in well sealed packaging in a dry and well ventilated area. Store in a dry and well ventilated area.

### Further information

- Material safety data sheet
- Pre-treatment table
- For complete instructions, see DINITROL AGR Training Manual

## Technical Data

Chemical base	Reactive polyurethane adducts
Colour	black liquid
Density, 73°F	910 ± 20 kg/m <sup>3</sup>
Viscosity Brookfield	5 – 15 mPas
Solid content	28 ± 2%
Drying time	> 5 Min.
Flash point	< 70°F
Processing humidity	30 – 70%
Application temperature	20°F – 104°F
Coverage	approx. 150 g/m <sup>2</sup>
Application method	Wool mop / melamine foam
Flash-off time	min. 5 minutes
Shelf life	12 months
Adhesion with direct glazing Polyurethanes on glass-frit:	
• with activator	good
• without activator	good
Adhesion with PU adhesives on	
• with activator	good
• RIM, PAAS and pinchweld	good
Available in	10 ml aluminium tube, 30 ml bottle, 100 ml bottle

1) 73°F / 50% rh

**For all relevant safety advices please read the material safety data sheet or the packaging label.**