

# TECHNICAL DATA

## PR-148 Adhesion Promoter

### Description

PR-148 is an adhesion promoter to enhance the coupling characteristics of polysulfide compounds to a wide variety of substrates. PR-148 is a one-part compound suitable for application by brush or clean gauze.

This product is fully qualified to the AMS 3100 Class 1 specification and PRC-DeSoto International specification test methods.

### Application Properties (Typical)

Color	Blue
Appearance	Free of particles
Dry time, 30%-70% RH	
77°F (25°C)	15 minutes
60°F (16°C)	45 minutes
40°F (4°C)	45 minutes

### Performance Properties (Typical)

Specific gravity	0.81
Flash point, PMCC	23°F (-5°C)
Effects on finishes	Does not soften finishes
Peel strength*, pli (N/25 mm), 100% cohesion	
JRF/3% NaCl immersion, 7 days @ 140°F (60°C)	
MIL-C-27725 (IFT coating)	56 (250)
Aged MIL-C-27725 (IFT coating)	55 (245)
AMS 4911 (Titanium)	57 (254)
NaCl-H <sub>2</sub> O immersion, 7 days @ 140°F (60°C)	
MIL-P-23377 (Epoxy Primer)	73 (325)
MIL-P-85582 (Water Based Primer)	75 (334)
MIL-S-5059 (Stainless steel)	27 (120)
MIL-T-9046 (Titanium comp. C)	28 (125)
Dry	
MIL-P-5425 (Acrylic)**	67 (298)

\* Tested with PR-1440 B-2 (AMS-S-8802) sealant

\*\*PR-148 is not recommended for use on substrates where solvent crazing would be of concern. Please examine using our PR-142 adhesion promoter instead.

**Note:** The application and performance property values above are typical for the material, but not intended for use in specifications or for acceptance inspection criteria because of variations in testing methods, conditions and configurations.

### Surface Preparation

Immediately before applying adhesion promoter to primed substrates, the surfaces 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 tissue 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 redeposition of contaminants on the substrate.

### Application Instructions

Apply a thin coat of PR-148 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-148 with a clean gauze pad and start the sealing procedure. If primed surface becomes contaminated or sealing is not accomplished within 8 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-148 Adhesion promoter is supplied in one-part containers.

### Storage Life

The storage life of PR-148 is at least 6 months when stored at temperatures below 80°F(27°C) in original, unopened containers. The material is hygroscopic and must be kept free of moisture. It should be discarded if it becomes cloudy or a precipitate is formed.

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## Health Precautions

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.

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