

Technical Data Sheet DINITROL® 538 Plus

DINITROL® 538 Plus

General Description

538 Plus is a 1-Step, solvent based, multi-function primer.

Characteristics

538 Plus multi-function 1-Step primer has the following features:

- 1-Step glass/frit primer
- Pinchwelt primer
- RIM/Encapsulation primer
- PAAS Re-activator primer
- Blocks 100% of harmful UV rays
- Inhibits rust/corrosion
- Compatible with all EFTEC adhesive systems

Shelf Life

12 months in an unopened bottle.

Storage Requirements

Recommended storage temperature is between 0°C (32°F) and 35°C (95°F). Keep product in cool and dry locations for best results.

Packaging

100ml bottle

Part

538 Plus

Application/Dry Time

10 minutes

Post Application Working Time

Approximately 3 months if surface is kept clean and uncontaminated.

Re-application: One time maximum

Open Shelf Life

1 week after bottle has been opened. (if properly sealed)

The 538 Plus should not be used if the product has remained opened for an extended amount of time. Replace inner seal and cap tightly and immediately after each use to ensure maximum shelf life.

Health and Safety Caution

Wear OSHA and ANSI Z87.1-1989 approved safety goggles and nitrile gloves with any OEM/aftermarket primer.

Working conditions with good ventilation is required. If this is not possible consult the 538 plus Material Safety Data Sheet for recommended options of use during poorly ventilated conditions.

Glass Application

1. Apply a generous film of glass cleaner to the glass bonding surface. If the glass cleaner "fish-eyes/separates" or "beads" up (like water on oil) on the bonding surface after a few seconds of application, this area needs special cleaning/preparation to remove the contaminate prior to applying 538 Plus. (see Contamination Removal Instructions)
2. If bonding area is adjacent to encapsulation, use a clean scour pad to wet-scrub the surface of the bonding area being careful not to remove any frit or scratch any part of the glass in the viewing area. (Always use a clean/contaminate free scour pad)
3. Apply a second application of glass cleaner to the bonding area to ensure contaminates have been removed.

**A foaming glass cleaner can provide the technician with a visual of any oils or release agents present on the bonding surface which may cause primer failure if not removed.

Note: DINITROL 520 activator/cleaner can also be used to ensure a clean bonding area prior to applying 538 Plus if needed. (follow application instructions found on the Dinitrol 520 TDS sheet)

4. Wipe the glass clean with lint free towel. Repeat the cleaning, wiping and drying process as necessary.
5. After proper surface cleaning, ensure the glass bonding surface is **completely dry**.

6. **Shake 538 Plus for 1 minute**
7. Apply primer in a smooth continuous lane on glass bonding area using an applicator like a dauber. (be sure not to "double dip". A used or contaminated dauber or other applicator can cause the remaining primer in the can to become contaminated)
8. Allow 10 minutes for the primer to dry prior to applying DINITROL adhesive.

Encapsulation / PVC / PAAS

Special attention must be given to encapsulated glass. These glass types have hard to remove films and may require extra cleaning.

1. Clean bonding area
2. Scuff the encapsulation surface with an abrasive pad or fine grade sand paper.
3. Wipe area clean
4. Apply 538 Plus to the RIM, PAAS, or PVC bonding surfaces.
5. Allow 20 minutes to dry/activate the bonding surface prior to applying DINITROL adhesive.

Pinchwelt Application

Never compromise the pinchwelt by damaging the paint system on the vehicle. In the event that the pinchwelt becomes scratched and/or bare metal is exposed, use a cotton swab, acid brush or other approved applicator to apply 538 Plus to the scratches and bare metal to prevent corrosion in the pinchwelt.

**Avoid priming existing fresh cut/trimmed urethane bead.

In the event that the pinchwelt has been stripped to the metal and no urethane is left in the pinchwelt, 538 Plus should be applied to the metal bonding surface and allow 10 minutes for primer to dry.

Bare metal areas larger than 1/2" x 1/2" will require a second coat of 538 Plus.

Replace inner seal and cap tightly and immediately after each use to ensure maximum shelf life.

***Application below 0°F is not recommended**

WARRANTY AND LIMITATION OF LIABILITY

EFTEC AFTERMARKET WARRANTS THE QUALITY OF THE PRODUCT FOR A REASONABLE PERIOD CORRESPONDING TO NORMAL PRACTICE FOR SUCH PRODUCT, PROVIDED ALWAYS, HOWEVER, THAT THE PRODUCT IS USED AS DIRECTED IN EFTEC AFTERMARKET'S WRITTEN INSTRUCTIONS AND MATERIAL SAFETY DATA SHEETS, WITHIN SHELF LIFE OF PRODUCT AND IN ALL RESPECTS WITH REASONABLE CARE. EXCEPT AS SET FORTH ABOVE, EFTEC AFTERMARKET EXPRESSLY EXCLUDES ANY IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE AND ALL OTHER EXPRESS OR IMPLIED REPRESENTATIONS AND WARRANTIES PROVIDED BY STATUTE OR COMMON LAW. USER DETERMINES SUITABILITY OF PRODUCT FOR INTENDED USE AND ASSUMES ALL RISK AND LIABILITY IN CONNECTION THEREWITH. IN NO EVENT SHALL EFTEC AFTERMARKET BE LIABLE FOR CONSEQUENTIAL, PUNITIVE, SPECIAL, EXEMPLARY OR INCIDENTAL DAMAGES. THE EXCLUSIVE REMEDY AVAILABLE FOR CLAIMS (INCLUDING BREACH OF WARRANTY, NEGLIGENCE AND STRICT LIABILITY) IS LIMITED TO HAVING THE OPTION OF REPLACEMENT OR REPAYMENT OF THE PURCHASE PRICE FOR THE PRODUCTS WHICH ARE THE SUBJECT OF THE CLAIM.



bonding
coating
sealing

The Specialist
In the Automotive Aftermarket

All information current as of October 2006