

Technical Data Sheet

DINITROL 1-Step Primer

DINITROL® D-528

General Description

D-528 1-Step primer is to be used in the final bonding surface preparation for bonding urethane to glass or painted metals.

Characteristics

D-528 1-Step Glass/Paint Primer has the following features:

- 1-Step primer
- Used both as glass and pinchweld primer
- Low conductive
- Blocks 100% of harmful UV rays for all glass types

Shelf Life

12 months in an unopened bottle.

Storage Requirements

Recommended storage temperature is between 5°C (40°F) and 27°C (80°F). Keep product in cool and dry locations for best results.

Packaging

Green capped bottles
1.0 oz can
4.2 oz can
0.33 oz tubes

Part

D-528S
D-528M
D-528A

Application/Dry Time

10 minutes

Post Application Working Time

Approximately 7 days if surface is kept clean and uncontaminated.

Open Shelf Life

1 week after bottle has been opened.

Be sure to replace the lid tightly immediately after opening to maintain maximum shelf life. See detailed instructions for use of this product enclosed with each box of Dinitrol urethane product.

The 528 1-Step should not be used if the product has remained opened for an extended amount of time. The lid must be replaced promptly after each use.

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 D-528 Safety Material Data Sheet for recommended options of use during poorly ventilated conditions.

Glass Application

1. Apply a generous film of industry approved glass cleaner to the glass bonding surface. If the glass cleaner "fish-eyes" or beads up like water on oil on the bonding surface after a few seconds of application, this is a sure indication, but not limited to the fact, that this glass needs special cleaning/preparation attention. (If D-520 Activator/Cleaner is to be used and the D-520 also "fish-eyes" or beads up then these steps should also be followed even with the pre-treatment of D-520)
2. Use a scour pad such as a Scotch-Brite pad (Trademark of 3M) to scrub the surface of the bonding area. Apply firm pressure to your scrubbing action. Continue with a back-and-forth type action a few times until the entire bonding surface has been treated with the abrasive scrub. In most cases, you will have scuffed the surface well enough to visibly see where you have and have not scrubbed. Make sure not to scrub in the inside area of the glass adjacent to the bonding area which would be in view after installation. Do not over scrub or scrub so hard that the ceramic comes off or is jeopardized.

3. Wipe the glass clean with lint free paper towel or a clean, lint free cloth. More glass cleaner may be required to ensure all of the contamination has been removed. Repeat the cleaning, wiping and drying process as necessary.
 - Use a new scour pad after: every 5 - 10 windshields
 - the scour pad becomes obviously contaminated
 - the pad loses appreciable scrubbing or scuffing action or which ever comes first

After proper surface cleaning ensure the glass surface is **completely** dry before applying a smooth continuous lane of D-528 1-Step to the bonding area of the glass. Use an acid brush, woolen dauber, or equivalent when applying D-528S or D-528M. Let dry 10 minutes at temperatures above 30°F, 20 minutes at temperatures from 0°F to 30°F.

Encapsulated Glass

Special attention must be given to encapsulated glass. (for example, DW1217) These glass types have hard to remove films and may require extra cleaning. **MEK, heptane or D-520 are suggested agents for this purpose.**

Pinchweld Application

Never compromise the pinchweld by damaging the paint system in the pinchweld. In the event that the pinchweld becomes scratched and/or metal is exposed, use a cotton swab or other approved applicator to apply D-528 on scratches or exposed metal to prevent future corrosion in the pinchweld. Let dry 10 minutes. Avoid getting D-528 on the freshly cut urethane.

In the event that the pinchweld has new paint and no urethane is left in the pinchweld, D-528 1-Step should be applied to the bonding surface. The paint system must be dry and scuffed with fine steel wool or scotch brite pad before application of D-528 1-Step. Use approved applicator to apply.

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

WARRANTY AND LIMITATION OF LIABILITY

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Please see Eftec
Aftermarket's web site at
www.eftecnica.com for updated
precautions and proper
preparation of glass surface before
performing an
installation.

