ACRALOCK®
Engineered Bonding Solutions

Technical Data Sheet
Cleaner AP series
AP1, AP2, AP3

DESCRIPTION:

The Acralock AP cleaner series is a set of different, easy to use cleaners based on Isopropylalcohol to be used for special applications. The application recommodation for each cleaner on various substrates is described at the Acralock Adhesive Selector Guide, in its actual version, page 2.

PRODUCTS:

AP1-CLR: **Metal Cleaner** which is designed to clean, chemically convert and prepare metal surfaces for better cleaning and permanent bonding with Acralock methacrylate structural adhesives. It significantly improves the long-term durability of adhesive bonds that are subjected to humid or corrosive environments such as salt water or salt spray. Without AP1, certain Acralock Structural Series adhesives can lose bond strength over time when exposed to such conditions.

AP2-CLR: **Plastic Cleaner** which is designed to clean, chemically convert and prepare Polyamid surfaces for better cleaning and permanent bonding with Acralock methacrylate structural adhesives. It significantly improves the long-term durability of adhesive bonds to Polyamid and other difficult to bond plastics.

AP3-CLR: **Glas Cleaner** which is designed to clean, chemically convert and prepare glas surfaces for better cleaning and permanent bonding with Acralock methacrylate structural adhesives. It significantly improves the long-term durability of adhesive bonds to ESG glass and ceramic coated surfaces.

PERFORMANCE HIGHLIGHTS

- Simple wipe application, rapid dry
- Mild solvent action combined with etching
- Clear, unpigmented material

BENEFITS

Minimal added time and labor input

Cleans surfaces better and faster than standard solvents & cleaners

Nothing influence long term properties

APPLICATION:

Good surface preparation is the precondition for durable bonding applications. Therefore we recommend to use *the Acralock AP* Cleaners according the following 2-cloth cleaning method:

1. Thoroughly clean all surfaces by brushing away any loose materials
2. Pour a small quantity of cleaning solvent into a buffer cloth or similar cleaning material
3. Wipe the joint surfaces with sufficient force to remove dirt and contaminants
4. Visually inspect the cloth to determine if contaminant were effectively removed. If the cloth remains dirty, repeat step 3 with a new cloth until this cloth remains white and/or clean
5. Allow the cleaner to dry until all the solvent evaporates. This typically takes < 30 minutes depending on cleaner, room temperature and humidity

   Typical Evaporation time @ 22°C: AP1: < 1 min
   AP2: < 15 min
   AP3: < 30 min
6. Apply structural MMA adhesive latest 4 hours after the cleaning operation, taking care that no new polution of the surface can happen.

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SAFETY AND HANDLING

Read Material Safety Data Sheet before handling or using this product. AP series is flammable. Always use in a well-ventilated area. Floor-level extraction and large quantities of moving air greatly facilitate ventilation. AP series cleaners should be stored in a cool place away from sources of heat and open flames or sparks. Keep container closed when not in use. Prevent contact with skin and eyes. In case of skin contact, wash with soap and water. In case of eye contact, flush with water for 15 minutes and seek immediate medical attention. Harmful if swallowed. Keep out of reach of children.

STORAGE & SHELFLIFE:

The shelf life of AP series cleaners in unopened containers is approximately six months from the date the product is shipped from EBS facilities. Shelf life is based on steady state storage below 25°C. Exposure, intermittent or prolonged, above 25°C will result in a reduction of the stated shelf life.

IMPORTANT NOTES:

1. **SUBSTRATE AND APPLICATION COMPATIBILITY:**

   The user must determine the suitability of a selected adhesive and the need for one of the special cleaners for a given substrate and application. EBS strongly recommends laboratory, shop and end-use testing that simulates the actual manufacturing and end-use environment.

2. **SURFACE PREPARATION:**

   The need for surface preparation must be determined by comparative testing of prepared and unprepared substrates to assure that unprepared bonding is equivalent to or acceptable for the application relative to prepared bonding.

   Initial bonding tests must be followed up with simulated or actual durability tests to assure that surface conditions do not lead to degradation of the bond over time under service conditions. Subsequent changes in substrates or bonding conditions will require re-testing.

3. **TECHNICAL ASSISTANCE:**

   Contact your local EBS distributor or EBS under office@acralock.eu for questions or assistance with the selection of adhesives and methods for evaluating adhesives and the need for special cleaners for your intended application.

4. **WARRANTY:**

   This product is intended for use by skilled individuals at their own risk. Recommendations contained herein are based on information we believe to be reliable. The properties presented above are typical values obtained under controlled conditions at the EBS Europe laboratory. They are intended to be used only as a guide for selection for end-use evaluation. The ultimate suitability for any intended application must be verified by the end user under anticipated test conditions. Since specific use, materials and product handling are not controlled by EBS laboratory, our warranty is limited to the replacement of defective EBS products.

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