
Applying Plexus PC-120

A guide to proper use and application

What is Plexus PC-120?

- Plexus PC-120 is a dual function primer/conditioner designed to clean surface contamination and leave a thin coating of primer on specific metal surfaces.
 - Although designed specifically for cleaning and priming of Aluminum and Stainless Steel, PC-120 can be used to clean other surfaces in special situations, contact Plexus Technical Service for recommendations on any surface other than Aluminum or Stainless Steel.
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How does Plexus PC-120 Work?

Plexus PC-120 works by:

- ❑ Cleaning the surface of contamination using Isopropyl Alcohol to “lift” machine oils and other contamination
 - ❑ Depositing a thin Phosphate based coating to retard corrosion
 - ❑ Leaving a light “pink” color to assist in determining what areas have, and have not, been treated with PC-120
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How should PC-120 be used?

- PC-120 can be brushed, wiped or sprayed onto the surface being primed.
 - The PC-120 applied should then be wiped with a clean dry rag to remove any surface contamination cleaned by the PC-120 and leave only a thin, quick drying film.
 - Dirty or oily rags should be replaced to avoid improper cleaning.
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Common mistakes with PC-120

- Although very simple to use, there are some common mistakes made during the application of PC-120. They include:
 - ❑ Using too much PC-120
 - ❑ Not removing the oils lifted off the metal surface before the PC-120 dries
 - ❑ Not abrading corrosion that is already on the surface of the metal
 - ❑ Using PC-120 past its shelf life
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Using too much PC-120

- Only a very thin coat should be left of the metal, you should be able to see a slight “pink” cast as illustrated below.

Too Much PC-120



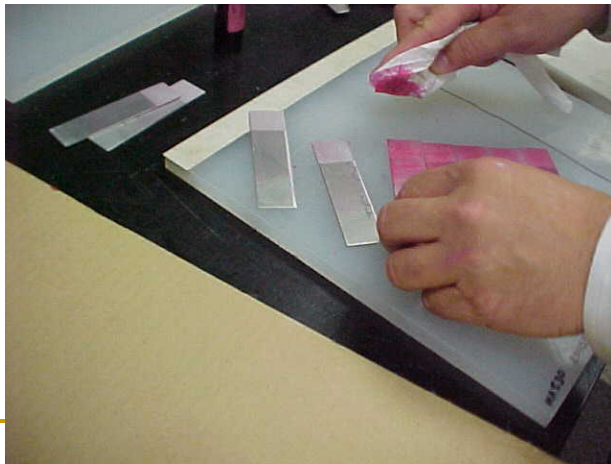
Correct Amount



Not removing oils once primed

- The solvents in PC-120 will clean and “lift” most machining oils, but if the metal isn’t wiped clean of these oils then they will be deposited right back onto the metal surface when the solvent in PC-120 evaporates!
- While still wet, wipe the PC-120 applied to the surface with a clean dry rag, changing the rag as needed.

Wipe the surface with a dry rag



Replace the rag when dirty

(Notice how much aluminum oxide was cleaned off “clean” looking Aluminum)



Not abrading corroded surfaces

- As good as PC-120 is, it can't help bonding performance if applied to a surface that is already corroded!
 - Any surface that shows signs of corrosion should be cleaned by sanding or wire brushing to remove any scale or corrosion.
 - After removal of corrosion then treat the surface with PC-120 as you normally would.
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Using PC-120 past it's shelf life

- When stored under normal conditions PC-120 has a shelf life of 12 months in an unopened, original container.
- PC-120 bottles are marked with a lot number that is a simple 8 digit code that gives you the date of manufacture. “807241” for example is 2008, 07 month (July), 24th day (the “1” refers to the first batch of PC-120 made that day). Use the lot number to make sure the material is still within shelf life.
- Since it contains isopropyl alcohol, PC-120 should be tightly capped when not in use to stop evaporation



Remember these points!

- To avoid problems with Plexus PC-120:
 - Don't use too much PC-120, only a thin layer is needed
 - Use a clean rag to wipe PC-120 off before it completely dries to remove surface contaminants it has cleaned
 - Any sign of corrosion already on the surface should be removed by abrading BEFORE priming
 - Check the lot number for the date to make sure the PC-120 is less than a year old
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Questions

- Please contact Plexus Technical Service at 1-800-851-6692 or info@itwplexus.com