

DINITROL®

PUR PRETREATMENT TABLE



Bonding + Sealing



	Materials	Pretreatment	Adhesion promoter Air dry* see # 6	Primer Air dry* see # 7	Product	Other comments
ALUMINIUM	Aluminium Coils Cut plates, smooth Tread plates, smooth Profiles	B roughen with grinding fleece M 600 Before and after roughening, clean with DINITROL 582	DINITROL 520	DINITROL 550	DINITROL 501 FC-HM DINITROL 501 FC-HM SQ DINITROL 512 2K HM DINITROL 516 A/B DINITROL 517 A/B DINITROL F 500 LP	Preclean heavily soiled surface with DINITROL 582 or isopropanol.
				DINITROL 538 Plus		
		S only clean with DINITROL 582	DINITROL 520		DINITROL 410 UV NF DINITROL 425 UV	
	Tread plates Textured side Aluminium cast parts	B roughen with grinding fleece M 600 Before and after roughening, clean with DINITROL 582	DINITROL 520	DINITROL 550	DINITROL 501 FC-HM DINITROL 501 FC-HM SQ DINITROL 512 2K HM DINITROL 516 A/B DINITROL F 500 LP	Pretests not necessary!
				DINITROL 538 Plus		
	S only clean with DINITROL 582	DINITROL 520		DINITROL 410 UV NF DINITROL 425 UV		
Aluminium Anodised Anodised Chromate conversion- coated	B roughen with grinding fleece M 600 Before and after roughening, clean with DINITROL 582	DINITROL 520	DINITROL 550	DINITROL 501 FC-HM DINITROL 501 FC-HM SQ DINITROL 512 2K HM DINITROL 516 A/B DINITROL 517 A/B DINITROL F 500 LP		
			DINITROL 538 Plus			
S only clean with DINITROL 582	DINITROL 520	-	DINITROL 410 UV NF DINITROL 425 UV			
OTHER METALS	Galvanised Sheets Galvanised Sheets, copper, brass and other non- ferrous metals	B roughen with grinding fleece M 600 Before and after roughening, clean with DINITROL 582	DINITROL 520	DINITROL 550	DINITROL 501 FC-HM DINITROL 501 FC-HM SQ DINITROL 512 2K HM DINITROL 516 A/B DINITROL 517 A/B DINITROL F 500 LP	Preclean heavily soiled surface with DINITROL 582 or isopropanol.
				DINITROL 538 Plus		
	S only clean with DINITROL 582	DINITROL 520	-	DINITROL 410 UV NF DINITROL 425 UV		
	Cast aluminium	B roughen with grinding fleece M 600 Before and after roughening, clean with DINITROL 582	DINITROL 520	DINITROL 550	DINITROL 501 FC-HM DINITROL 501 FC-HM SQ DINITROL 512 2K HM DINITROL 516 A/B DINITROL F 500 LP	Pretests not necessary!
				DINITROL 538 Plus		
	S only clean with DINITROL 582	DINITROL 520	-	DINITROL 410 UV NF DINITROL 425 UV		
	Nirosta Tinplate	B roughen with grinding fleece M 600 Before and after roughening, clean with DINITROL 582	DINITROL 520	DINITROL 550	DINITROL 501 FC-HM DINITROL 501 FC-HM SQ DINITROL 512 2K HM DINITROL 516 A/B DINITROL 517 A/B DINITROL F 500 LP	
				DINITROL 538 Plus		
	After roughening with grinding fleece M 600, clean with DINITROL 582	DINITROL 520	DINITROL 550	DINITROL 410 UV NF DINITROL 425 UV		
		-	DINITROL 538 Plus			



DINITROL 520

Glass activator & adhesion promoter

Processing: First, use a clean, soft cloth to apply a generous amount of DINITROL 520 bonding/cleaning agent to the surface to be bonded. Wait approx. 1-2 minutes and in the second step, wipe the dry film using a clean cloth to remove any excess product.

Item no.	Size	Container	Colour
12024	30 ml	Bottle	Transparent
12020	250 ml	Bottle	Transparent
12025	1 L	Can	Transparent



DINITROL 530

Glass and paint primer

Processing: Since the pigments in the primer may settle, the container must be shaken well before use. For this purpose, there are small balls in the container to ensure the right mixture when shaking. Apply the homogeneous primer with the appropriate tools, i.e., felt, a fine brush, melamine foam or a dauber.

Item no.	Size	Container	Colour
12023	30 ml	Bottle	Black
12030	100 ml	Bottle	Black
12026	250 ml	Bottle	Black
12133	1 L	Can	Black



DINITROL 538 PLUS

1-step multifunction primer

Processing: Since the pigments in the primer may settle, the container must be shaken well before use. For this purpose, there are small balls in the container to ensure the right mixture when shaking. Apply the homogeneous primer with the appropriate tools, i.e., felt, a fine brush, melamine foam or a dauber.

Item no.	Size	Container	Colour
12349	10 ml	Stick	Black
12404	30 ml	Bottle	Black
12341	100 ml	Bottle	Black
12694	250 ml	Bottle	Black



DINITROL 550

Multi-primer

Processing: Since the pigments in the primer may settle, the container must be shaken well before use. Apply the homogeneous primer with the appropriate tools, i.e., felt, a fine brush, melamine foam or a dauber, to the clean, pretreated surface. The bond depends on a variety of surface factors. For this reason, we recommend carrying out a bonding test first.

Item no.	Size	Container	Colour
12137	30 ml	Bottle	Black
12138	250 ml	Bottle	Black
12139	1 L	Can	Black

ATTENTION:

Compliance with the processing times specified in the bonding guidelines is of the utmost importance for perfect bonding and therefore, they must be strictly complied with. Strictly observe the bonding agent manufacturer's technical data sheets and notes. The information they contain are to be understood as non-binding instructions. Perfect bonding results always depend on the composition, quality, and processing of the on-site materials and must therefore be checked there in advance. Further special bonding agents are available upon request.

	Materials	Pretreatment	Adhesion promoter Air dry* see # 6	Primer Air dry* see # 7	Product	Other comments
ALUMINIUM	Aluminium Coils Cut plates, smooth Tread plates, smooth	B roughen with grinding fleece M 600 Before and after roughening, clean with DINITROL 582	DINITROL 520	DINITROL 550 DINITROL 538 Plus	DINITROL 501 FC-HM DINITROL 501 FC-HM SQ DINITROL 512 2K HM DINITROL 516 A/B DINITROL 517 A/B DINITROL F 500 LP	Preclean heavily soiled surface with DINITROL 582 or isopropanol.
	Profiles	S only clean with DINITROL 582	DINITROL 520		DINITROL 410 UV NF DINITROL 425 UV	
	Tread plates Textured side Aluminium cast parts	B roughen with grinding fleece M 600 Before and after roughening, clean with DINITROL 582	DINITROL 520	DINITROL 550 DINITROL 538 Plus	DINITROL 501 FC-HM DINITROL 501 FC-HM SQ DINITROL 512 2K HM DINITROL 516 A/B DINITROL F 500 LP	Pretests not necessary!
		S only clean with DINITROL 582	DINITROL 520		DINITROL 410 UV NF DINITROL 425 UV	
	Aluminium Anodised Anodised Chromate conversion- coated	B roughen with grinding fleece M 600 Before and after roughening, clean with DINITROL 582	DINITROL 520	DINITROL 550 DINITROL 538 Plus	DINITROL 501 FC-HM DINITROL 501 FC-HM SQ DINITROL 512 2K HM DINITROL 516 A/B DINITROL 517 A/B DINITROL F 500 LP	
		S only clean with DINITROL 582	DINITROL 520	-	DINITROL 410 UV NF DINITROL 425 UV	

	Materials	Pretreatment	Adhesion promoter Air dry* see # 6	Primer Air dry* see # 7	Product	Other comments
OTHER METALS	Galvanised Sheets Galvanised Sheets, copper, brass and other non- ferrous metals	B roughen with grinding fleece M 600 Before and after roughening, clean with DINITROL 582	DINITROL 520	DINITROL 550 DINITROL 538 Plus	DINITROL 501 FC-HM DINITROL 501 FC-HM SQ DINITROL 512 2K HM DINITROL 516 A/B DINITROL 517 A/B DINITROL F 500 LP	Preclean heavily soiled surface with DINITROL 582 or isopropanol.
		S only clean with DINITROL 582	DINITROL 520	-	DINITROL 410 UV NF DINITROL 425 UV	
	Cast aluminium Before and after roughening, clean with DINITROL 582	B roughen with grinding fleece M 600 Before and after roughening, clean with DINITROL 582	DINITROL 520	DINITROL 550 DINITROL 538 Plus	DINITROL 501 FC-HM DINITROL 501 FC-HM SQ DINITROL 512 2K HM DINITROL 516 A/B DINITROL F 500 LP	Pretests not necessary!
	S only clean with DINITROL 582	DINITROL 520	-	DINITROL 410 UV NF DINITROL 425 UV		
	Nirosta Tinplate	B roughen with grinding fleece M 600 Before and after roughening, clean with DINITROL 582	DINITROL 520	DINITROL 550 DINITROL 538 Plus	DINITROL 501 FC-HM DINITROL 501 FC-HM SQ DINITROL 512 2K HM DINITROL 516 A/B DINITROL 517 A/B DINITROL F 500 LP	
		After roughening with grinding fleece M 600, clean with DINITROL 582	DINITROL 520	DINITROL 550 DINITROL 538 Plus	DINITROL 410 UV NF DINITROL 425 UV	

	Materials	Pretreatment	Adhesion promoter Air dry* see # 6	Primer Air dry* see # 7	Product	Other comments
PLASTICS	GFRP Ferroplast ABS	B roughen with grinding fleece M 600 Remove dust Before and after roughening, clean with DINITROL 582	DINITROL 520	DINITROL 550 DINITROL 538 Plus	DINITROL 501 FC-HM DINITROL 501 FC-HM SQ DINITROL 512 2K HM DINITROL 516 A/B DINITROL 517 A/B DINITROL F 500 LP	After production, solvents may diffuse out of fresh or young plastic parts (not tempered). This can lead to decreased bonding. Pretests not necessary! After roughening with grinding fleece M 600. Clean with DINITROL 582.
		S If necessary, roughen with grinding fleece M 600	DINITROL 520		DINITROL 410 UV NF DINITROL 425 UV	
	RPVC Before and after roughening, clean with DINITROL 582	B roughen with grinding fleece M 600 Before and after roughening, clean with DINITROL 582	DINITROL 520	DINITROL 550 DINITROL 538 Plus	DINITROL 501 FC-HM DINITROL 501 FC-HM SQ DINITROL 512 2K HM DINITROL 516 A/B DINITROL F 500 LP DINITROL F 500 LP	Pretests not necessary!
		After roughening with grinding fleece M 600, clean with DINITROL 582	DINITROL 520	DINITROL 550 DINITROL 538 Plus	DINITROL 410 UV NF DINITROL 425 UV	
	Thermoplastic polymers Polycarbonate (PC) Makrolon (Bayer) Lexan (GEP) Orgalon (ATO)	B roughen with grinding fleece M 600 Before and after roughening, clean with DINITROL 582	DINITROL 520	DINITROL 550 DINITROL 538 Plus	DINITROL 501 FC-HM DINITROL 501 FC-HM SQ DINITROL 512 2K HM DINITROL 516 A/B DINITROL F 500 LP	Pretests not necessary!
		S Grind with grinding fleece M 600 Before and after grinding, clean with DINITROL 582	DINITROL 520	DINITROL 550 DINITROL 538 Plus	DINITROL 410 UV NF DINITROL 425 UV	

	Materials	Pretreatment	Adhesion promoter Air dry* see # 6	Primer Air dry* see # 7	Product	Other comments
PAINTS & PRIMERS	Painted surfaces (2K systems)	B If necessary, roughen with grinding fleece M 600 Before and after grinding, clean with DINITROL 582	DINITROL 520	DINITROL 530/ DINITROL 550	DINITROL 501 FC-HM DINITROL 501 FC-HM SQ DINITROL 512 2K HM DINITROL 516 A/B DINITROL F 500 LP	Paint must be completely cured. Observe the paint manufacturer's technical data sheets.
		S clean with DINITROL 582	DINITROL 520		DINITROL 410 UV NF DINITROL 425 UV	
	EP primer Epoxy	B roughen with grinding fleece M 600 Before and after grinding, clean with DINITROL 582	DINITROL 520	DINITROL 550 DINITROL 538 Plus	DINITROL 501 FC-HM DINITROL 501 FC-HM SQ DINITROL 512 2K HM DINITROL 516 A/B DINITROL F 500 LP	Pretests not necessary!
	S clean with DINITROL 582			DINITROL 410 UV NF DINITROL 425 UV		
	Powder coat Before and after grinding, clean with DINITROL 582	B roughen with grinding fleece M 600 Before and after grinding, clean with DINITROL 582	DINITROL 520	DINITROL 530/ DINITROL 550	DINITROL 501 FC-HM DINITROL 501 FC-HM SQ DINITROL 512 2K HM DINITROL 516 A/B DINITROL 517 A/B DINITROL F 500 LP	Pretests not necessary!
		S clean with DINITROL 582	DINITROL 520	DINITROL 530	DINITROL 410 UV NF DINITROL 425 UV	

	Materials	Pretreatment	Adhesion promoter Air dry* see # 6	Primer Air dry* see # 7	Product	Other comments
OTHER MATERIALS	Glass	B clean with DINITROL 582	DINITROL 520	DINITROL 530 DINITROL 538 Plus	DINITROL 501 FC-HM DINITROL 501 FC-HM SQ DINITROL 512 2K HM DINITROL 516 A/B DINITROL F 500 LP	DINITROL 530 black primer and DINITROL 538 Plus provide extra UV protection in conjunction with ceramic screen printing (precleaned).
		S clean with DINITROL 582	DINITROL 520		DINITROL 410 UV NF DINITROL 425 UV	
	Wood	B clean with DINITROL 582		DINITROL 530/ DINITROL 538 Plus/ DINITROL 550	DINITROL 501 FC-HM DINITROL 501 FC-HM SQ DINITROL 512 2K HM DINITROL 516 A/B DINITROL 517 A/B DINITROL F 500 LP	Pretests not necessary!
		S clean with DINITROL 582		DINITROL 550	DINITROL 410 UV NF DINITROL 425 UV	

ADHESION PROMOTER DRYING TIME

When the following adhesives are used:		
1K adhesive	min. 20 min.	max. 2 hours
When reactive 2K adhesives are used:		
DINITROL 516 A/B DINITROL 512 2K DINITROL 517 A/B	min. 20 min. min. 20 min. min. 20 min.	max. 2 hours max. 2 hours max. 2 hours

PRIMER DRYING TIME

When the following adhesives are used:		
1K adhesive	min. 10 min.	max. 24 hours
When reactive 2K adhesives are used:		
DINITROL 516 A/B DINITROL 512 2K DINITROL 517 A/B	min. 10 min. min. 10 min. min. 10 min.	max. 8 hours max. 8 hours max. 8 hours

* = Drying time 23 °C/50 % rel. humidity B = Bonding S = Sealing





THE QUALITY SOLUTION

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