MERCOLA

Adhesives & Sealants

BONDFLEX 551 BLACK PRIMER

Technical Data Sheet

Reviewed: 06.06.2025

DESCRIPTION

BONDFLEX 551 BLACK PRIMER is a one-component fast curing, professional grade primer specially developed to improve the adhesion and maximize the bonding of sealants/adhesives on low surface energy substrates used in the transportation market and more specifically the glass bonding.
This all-in-one primer is also compatible with all **BONDFLEX** polyurethane and hybrid sealants.

ADVANTAGES

- Fast curing
- Superior adhesion
- Excellent covering properties
- UV stable formula
- Easy to use

APPLICATIONS

- **BONDFLEX 551 BLACK PRIMER** is used on glass and silk-screened ceramic frit glass for the bonding of windshield or glass (on cars, trains, buses, trucks and specialty vehicles) as well as on vehicle body frames. It acts as a corrosion inhibitor on metal and can be applied on pinch-weld scratches and nicks.
- It is also recommended in the marine industry (for windshield or porthole bonding) to prime acrylic (PMMA) or polycarbonate windows, fiberglass and polyester.
- **BONDFLEX 551 BLACK PRIMER** can also be used as a multipurpose primer on many non-porous substrates, like aluminium, metals, stainless steel, painted surfaces, ABS, wood and PVC.
- For applications other than glass bonding, it is recommended to do preliminary adhesion and compatibility tests.

INSTRUCTIONS FOR USE

Surface preparation:
The substrates to be treated must be clean, dry, free of dust or grease. Contaminated surfaces must be cleaned beforehand with a solvent-based solution with or without the help of an abrasive like 3M SCOTCH BRITE® RED. Let evaporate for 5 minutes before next step.
Treat the glass with the adhesion promoter **BONDFLEX 552 ACTIVATOR** (see the technical data sheet of the product) before applying **BONDFLEX 551 BLACK PRIMER**.
Note: when using solvents, extinguish all sources of ignition and carefully follow the safety and handling instructions given by the manufacturer.

Primer application:
To perfectly homogenize the product, shake thoroughly the bottle until agitator ball is moving, then shake additional 30 seconds. Dip a clean felt tip applicator into the bottle, roll it around the edges of the bottle to squeeze out the excess of product.
Primer can also be applied using a 10ml single-use tube with its dedicated applicator (white foam). Shake the tube vigorously for 10 to 15 seconds to re-homogenize the product, then screw the applicator tip onto the tube. Apply light and uniform pressure to soak the foam. Then press evenly on the tube to obtain a homogenous and opaque film.
Hermetically seal the container immediately after use as this product is very sensitive to moisture. Any contact with humidity will make the primer cure.
Depending on the type of glass, follow the recommendations: (see also the technical data sheet of the windshield adhesive used)

Raw Glass: **BONDFLEX 552 ACTIVATOR** / **BONDFLEX 551 BLACK PRIMER** / Windshield sealant: **BONDFLEX 550FC** or **BONDFLEX 560FC+.**

Windshield with black ceramic frit: Anti-silicone treatment / **BONDFLEX 552 ACTIVATOR** / (**BONDFLEX 551 BLACK PRIMER)** / Windshield sealant: **BONDFLEX 550FC** or **BONDFLEX 560FC+.**
Bonding can be performed with or without the use of primer. Bonding without **BONDFLEX 551 BLACK PRIMER** must be performed on a windshield with a ceramic frit ensuring optimal and uniform opacity to UV and not presenting silicone residues.

PMMA or Polycarbonate Windows: **BONDFLEX 552 ACTIVATOR** / **BONDFLEX 551 BLACK PRIMER** / Windshield sealant: **BONDFLEX 550FC** or **BONDFLEX 560FC+.**
After drying (15 minutes, depending on temperature and moisture conditions) apply the sealant within a one-hour deadline, proceeding according to instructions of its technical data sheet.
If the deadline is not respected or if the film of primer is contaminated (dust, etc.) lightly sand the primed surface, remove the dust and re-prime with **BONDFLEX 551 BLACK PRIMER**.

On the vehicle: a surface treatment with **BONDFLEX 551 BLACK PRIMER** is recommended on pinch-weld parts scratched during disassembling of the windscreen as well as on areas where traces of rust are visible. After abrasion followed by cleaning (solvent), apply **BONDFLEX 551 BLACK PRIMER** with a clean felt tip applicator (or the 10 ml single-use tube) to stop corrosion. Respect a drying time of 15 minutes. If the temperature is below 20°C, a longer drying time is recommended.

CLEANING

Clean all equipment with acetone immediately after use. After curing, abrasion is necessary.

LIMITATIONS

1. Do not use if an increase in viscosity or a cured film on surface of the bottle are observed.
2. Do not apply primer on frozen surfaces.
3. Do not apply primer to the existing trimmed polyurethane bead (windshield replacement).
4. Do not reuse the felt tip applicator.
5. Do not re-dip the felt tip applicator in the bottle.

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AJA ISO 9001 : 2015
UKAS MANAGEMENT SYSTEMS 0273
REACH Compliant
CLP 2016
LOW VOC

CONSUMPTION
80-100ml/m^2 on glass.
Consumption may increase on absorbent or uneven surfaces.

TECHNICAL CHARACTERISTICS
Base: Aliphatic Polyurethane
Color: Black
Odor: Solvent
Solids: approx. 30%
Consistency: Liquid
Curing System: Moisture Cure
Drying Time (20°C/ 65% R.H.): 15-20 min
Specific gravity: 0,95 ± 0,5 gr/ml
Temperature Resistance: -40°C to +90°C
Application temperature: +5°C - +35°C

STORAGE
In a cool and dry place at temperatures between +5°C - +25^{0}C

SHELF LIFE
12 months in unopened packaging in the above mentioned storage conditions.

PACKAGING
Tube 10ml (single use – with white foam)
Tins 30ml, 250ml, 1.000ml
25Lt, 200Lt drums upon request

PACKAGING	CODE	BARCODE
10ml	4268	5204094042686
30ml	4269	5204094042693
250ml	4272	5204094042723

HEALTH AND SAFETY INFORMATION
Before use, consult the Product Safety Data Sheet.

The directives contained in this technical data sheet are the result of our long experience from real life applications and the research testing of our research and development laboratory and have been submitted in good faith. Because of the diversity of the materials and substrates and the great number of possible applications, which are beyond our control, we cannot accept any responsibility for the results obtained. In every case it is recommended to carry out preliminary experiments. We are liable only for our products for being free from faults and of consistent quality. Users are responsible for complying with local legislation and for obtaining any required approvals or authorizations. The present edition of this technical datasheet automatically cancels any previous ones concerning the same product.

TECHNICAL SUPPORT
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MONDAY TO FRIDAY 8:00 - 16:00

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