



## Product Description

Vibra-Tite 638 Excel Surface Prep is a flammable but ozone friendly surface treatment for activating acrylate based No-Mix structural adhesives. Vibra-Tite 638 is particularly suited for initiating the cure of Vibra-Tite toughened acrylic adhesives. 638 can also be used to speed the cure of anaerobic fluids and assists in speeding fixture times and reducing ultimate cure times.

## Typical Applications

Vibra-Tite 638 Excel Surface Prep is used with all Vibra-Tite No-Mix structural adhesive products. It can also be used to speed the cure of some anaerobic fluids but is not recommended for our Gasket Makers. Vibra-Tite 638 has an on-part life of up to 6 hours.

## Procedure for Application

Product is normally hand applied from the bottle by brushing, wiping or spraying onto parts. Allow solvent to evaporate until the surfaces are completely dry. Apply structural adhesive to the opposing surface and join. For large gaps or faster cure times, Vibra-Tite 638 may be applied to both substrates. However, when applying adhesive over a treated surface, assembly must occur within 15 seconds.

## Properties

Vibra-Tite 638 Excel Surface Prep contains a blend of flammable solvents. Care must be taken to avoid flames.

## Technical Features

Chemical Base .....Heptane / Isopropanol  
Color: ..... Amber  
Viscosity ..... 3cps  
Shelf Life .....12 months @ 68°F unopened  
Flammability ..... Yes, high

## Cured Performance

Performance is dependent on the structural adhesive viscosity, gap fill and type of materials being bonded. However, in typical applications fixture times are achieved in approximately 2 minutes.

## Presentation

Bottles.....2 oz, 8 oz (with pump sprayer)  
Cans.....Gallon

## General Information

### Storage

Store in cool area out of direct sunlight

### Note

Vibra-Tite 638 Excel Surface Prep can be used by spraying, wiping, or brushing on the primer to one or both bonding surfaces. Vibra-Tite 638 can be used for batch dipping of large quantities of parts. It also degreases and cleans your parts.

## Health & Safety in use

Use in well ventilated area and read MSDS.