Chemlok® 205 Primer and/or Adhesive

Technical Data Sheet

Chemlok® 205 primer/adhesive is a heat-activated material designed for use as either a substrate primer or as a one-coat adhesive for bonding unvulcanized nitrile elastomer compounds. It is composed of a mixture of polymers, organic compounds and mineral fillers dissolved or dispersed in an organic solvent system.

Features and Benefits:

Versatile – can be used as a primer under a wide variety of Chemlok covercoat adhesives such as the Chemlok 230 series and Chemlok 6000 series adhesives.

Convenient – can be used as a one-coat adhesive to bond some nitrile rubber compounds to rigid substrates during vulcanization.

Easy to Apply – applies easily by brush, dip, spray or roll coat methods; suitable for existing production lines.

Durable – provides high tear and cohesive strength, as well as excellent environmental resistance when used in combination with Chemlok covercoat adhesives.

Elastomers:

- Nitrile (NBR)
- Polyacrylate (ACM)

Application:

Surface Preparation – Thoroughly clean metal surfaces prior to application. Remove protective oils, cutting oils and greases by solvent degreasing or alkaline cleaning. Remove rust, scale or oxide coatings by suitable chemical or mechanical cleaning methods.

Apply Chemlok 205 primer/adhesive to stainless steel, aluminum, brass or other nonferrous substrates within one-half hour after cleaning. For ferrous substrates such as steel, a longer layover can be tolerated if no rust is formed.

For further detailed information on surface preparation of specific substrates, refer to Chemlok Adhesives application guide.

Mixing – Thoroughly stir primer/adhesive before use, and agitate sufficiently during use to keep dispersed solids uniformly suspended. If dilution is needed, use ketone-type solvents such as MEK and MIBK. Note proper dilution for the various application methods is best achieved by experience. Give careful attention to agitation since dilution will accelerate settling.

Applying – Apply primer/adhesive by brush, dip, roll coat, spray or any method that gives a uniform coating and avoids excessive runs or tears.

Normally the dry film thickness of Chemlok 205 primer/adhesive should be 5.1-10.2 micron (0.2-0.4 mil). When using Chemlok 205 primer/adhesive over grit blasted substrates or when using Chemlok 205 primer/adhesive as a nitrile adhesive, apply a dry film thickness at the high end of the range. For all other applications (i.e., swaging or smooth substrates), apply Chemlok 205 primer/adhesive at the low end of the film thickness range.

Typical Properties*

Appearance	Gray Liquid
Viscosity, cps @ 25°C (77°F) Brookfield LVT Spindle 2, 30 rpm	85 - 165
Density kg/m^3 (lb/gal)	 920.0 - 970.0 (7.7 - 8.1)
Solids Content by Weight, %	22 - 26
Flash Point (Seta), °C (°F)	14 (58)
Solvents	MIBK, MEK, Xylene

*Data is typical and not to be used for specification purposes.

Drying/Curing – Thoroughly dry coated parts before applying the covercoat adhesive. This will take approximately 30-45 minutes at room temperature. It is best to use temperatures of 65-93°C (150-200°F) and abundant circulating air; however, forced air drying is possible at temperatures up to 121°C (250°F) for short periods of time. Maximum air flow at minimum temperatures will give the best results. After parts have dried, apply Chemlok covercoats using similar application methods.

Cleanup – Clean areas with a rag as soon as possible using MEK.

Shelf Life/Storage:

Shelf life is one year from date of shipment when stored by the recipient at 21-27°C (70-80°F) in original, unopened container.

Cautionary Information:

Before using this or any Parker Lord product, refer to the Safety Data Sheet (SDS) and label for safe use and handling instructions.

For industrial/commercial use only. Must be applied by trained personnel only. Not to be used in household applications. Not for consumer use.

OD DS3172E 04/24 Rev.7

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