Chemosil® 512 Adhesive

Technical Data Sheet

Chemosil® 512 one-coat adhesive is used to bond fluoroelastomers to metal and a variety of other substrates during the vulcanization process. It is composed of a mixture of dissolved silicone compounds in a solvent system.

Features and Benefits:

Versatile – bonds a wide variety of fluoroelastomers, including conventional and peroxide cross-linking types.

Easy to Apply – applies easily by brush, spray or dip methods.

Environmentally Resistant – provides high resistance to temperature and media.

Elastomers:

- Fluoroelastomers (FKM)

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.

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

Mixing – Transfer amount of adhesive required to a clean container. Thoroughly stir material before use. If dilution is needed, use MEK, MIBK or isopropanol at a ratio of 0.5:1 or 1:1, solvent to adhesive.

Applying – Apply adhesive by brush, dip or spray methods. Unused or diluted material should not be returned to original container.

Drying/Curing – Allow applied adhesive to air-dry for approximately 15 minutes at ambient temperature. Porous substrates may require a longer time for the solvent to completely evaporate.

Coated metal parts should be processed within one week. Avoid contamination of coated parts by storing in dry, grease-free environment.

Bonding occurs during vulcanization process of the rubber under recommended cure temperatures of 170-180°C (338-356°F). Coated metal parts can be pre-heated for approximately 10 minutes at 150°C (302°F).

Shelf Life/Storage:

Shelf life is nine months from date of manufacture when stored by the recipient below 25°C (77°F) in original, unopened container.

Typical Properties*	
Appearance	Clear Brown Liquid
Density @ 20°C (68°F) g/m^3 (lb/gal)	 0.84 - 0.86 (7.01 - 7.17)
Solids Content by Weight, % Dry residue, 30 minutes @ 130°C (266°F)	13 - 17
Flash Point (Seta), °C (°F)	-6 (23)
Solvents	MEK

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

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 DS3915E 12/22 Rev.4

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