Chemlok® 205A Primer

Technical Data Sheet

Chemlok® 205A primer is designed for use under Chemlok covercoat adhesives to bond a wide variety of vulcanized and unvulcanized rubber compounds to metals and other rigid substrates. Chemlok 205A, a modification of Chemlok 205 adhesive primer, is composed of a mixture of polymers, organic compounds and mineral fillers dissolved or dispersed in a predominately ketone solvent system.

Chemlok 205A primer is also an excellent one-coat adhesive for bonding some nitrile rubber compounds.

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 6100 series adhesives.

Environmentally Recommended – dilutable with aromatic solvents, reducing the number of solvents in plant inventory.

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

Durable – provides rubber tearing bonds and outstanding environmental resistance when used in combination with Chemlok covercoat adhesives.

Convenient – requires only a single coat application to bond some nitrile rubber compounds to rigid substrates during vulcanization.

Application:

Surface Preparation – Thoroughly clean metal surfaces prior to adhesive 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 205A primer 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 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 or aromatic solvents such as toluene or xylene. Give careful attention to agitation since dilution will accelerate settling. Note proper dilution for the various application methods is best achieved by experience.

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

Regardless of application method, the dry film thickness of Chemlok 205A primer should be 5.1-10.2 micron (0.2-0.4 mil).

Typical Properties*	
Appearance	Gray Liquid
Viscosity cps @ 25°C (77°F) Brookfield LVT Spindle 2, 30 rpm seconds Zahn Cup #2	 85 - 165 20 - 40
Density kg/m^3 (lb/gal)	 910.7 - 970.6 (7.6 - 8.1)
Solids Content by Weight, %	22 - 26
Flash Point (Seta), °C (°F)	16 (61)
Solvents	MIBK, MEK, Propylene Glycol Monomethyl Ether

*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 30-60 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.

Cleanup – Use MEK to clean primer before heat is applied. Remove cured primer by mechanical abrasion methods.

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.

Values stated in this document represent typical values as not all tests are run on each lot of material produced. For formalized product specifications for specific product end uses, contact the Customer Support Center.

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