Chemlok® 205LH Primer

Technical Data Sheet

Chemlok® 205LH primer is a low Hazardous Air Pollutant (HAP) primer designed for use under Chemlok covercoat adhesives to bond a wide variety of vulcanized and unvulcanized rubber compounds to metals and other rigid substrates. It is composed of a mixture of polymers, organic compounds and mineral fillers dissolved or dispersed in a low HAP organic solvent system.

Features and Benefits:

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

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

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

Identifiable Appearance – provides a brilliant blue color for easy identification when used over phosphatized substrates.

Environmentally Recommended – contains low HAP content (3.6 lb HAP/gal solid or 6.45% HAP content).

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 205LH primer to stainless steel, aluminum, brass or other nonferrous substrates within one 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 non-HAP, ketone-type solvents such as MPK. Give careful attention to agitation since dilution will accelerate settling. Note proper dilution for the various application methods is best achieved by experience.

Typical Properties*	
Appearance	Blue Liquid
Viscosity cps Brookfield LVT Spindle 2, 30 rpm seconds Zahn Cup #2	 10 - 550 10 - 100
Density kg/m^3 (lb/gal)	 886.7 - 958.6 (7.4 - 8.0)
Solids Content by Weight, %	21.5 - 26.5
Flash Point (Seta), °C (°F)	13 (56)
Solvents	MPK, N-butyl Propionate

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

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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 205LH primer should be 5.1-10.2 micron (0.2-0.4 mil). When using Chemlok 205LH primer over grit blasted substrates or when using it in conjunction with Chemlok 6125 series covercoats, apply a dry film thickness at the high end of the range. For all other applications (i.e., swaging or smooth substrates), apply Chemlok 205LH primer at the low end of the film thickness range.

Drying/Curing – Thoroughly dry coated parts before applying the covercoat adhesive. It is best to use temperatures of 65-93°C (150- 200°F) and abundant dry 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 – Clean areas with a rag as soon as possible using MPK or MEK.

Shelf Life/Storage:

Shelf life is six months 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.

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