

CHEMLOK® 208A PRIMER

Technical Data Sheet

Chemlok® 208A primer is specifically developed for use with Autoseal® 3370 adhesive and other select Chemlok covercoat adhesives in coil coating applications.

Features and Benefits

Durable: provides minimum loss of adhesive layer to roll-formed coated metal.

Excellent Adhesion: adheres well to properly prepared metals, such as aluminum, electrogalvanized steel and stainless steel.

Environmentally Resistant: provides excellent environmental resistance when used in combination with Chemlok covercoat adhesives.

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. Chemical cleaning is the preferred method as chemical treatments are readily adapted to automated metal treatment and adhesive application lines. Chemical cleaning is ideal when tight tolerances must be maintained or when blast cleaning would cause distortion.

Mixing: Thoroughly stir primer before use, and agitate sufficiently during use to keep solids uniformly dispersed. If dilution is needed, use xylene.

Applying: Apply primer by reverse roll coat method.

Parker Lord
Engineered Materials Group
111 LORD Drive
Cary, NC 27511-7923
USA
phone +1 877 275-5673
www.parker.com/EPM

DS3177 OD 11/24 Rev.5

Information and specifications subject to change without notice and without liability therefor. Trademarks used herein are the property of their respective owners.

© 2024 Parker Hannifin Corporation



Listed below are conditions which provide optimum adhesion to metal in coil coating, and subsequent adhesion to rubber, when used with the appropriate Chemlok adhesive covercoats:

Dry Film Thickness	2.5-5.1 micron (0.1-0.2 mil)
Wet Film Thickness	10.2-25.4 micron (0.4-1.0 mil)
Peak Metal Temperature	218-232°C (425-450°F)
T-bends	0-3
MEK Double Rubs	1-10

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.

Typical Properties*

Appearance	Gray Liquid
Viscosity, cps @ 25°C (77°F) Brookfield LVT Spindle 2, 30 rpm	75 - 200
Density kg/m ³ (lb/gal)	934.6 - 970.6 (7.8 - 8.1)
Solids Content by Weight, %	31.5 - 34.5
Flash Point (Seta), °C (°F)	21 (70)
Solvents	Xylene, MIBK, Toluene, MEK
Autoignition Temperature, °C (°F) ASTM E659-78	537 (999)

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

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.

Information provided herein is based upon tests believed to be reliable. In as much as Parker Lord has no control over the manner in which others may use this information, it does not guarantee the results to be obtained. In addition, Parker Lord does not guarantee the performance of the product or the results obtained from the use of the product or this information where the product has been repackaged by any third party, including but not limited to any product end-user. Nor does the company make any express or implied warranty of merchantability or fitness for a particular purpose concerning the effects or results of such use.

WARNING — USER RESPONSIBILITY. FAILURE OR IMPROPER SELECTION OR IMPROPER USE OF THE PRODUCTS DESCRIBED HEREIN OR RELATED ITEMS CAN CAUSE DEATH, PERSONAL INJURY AND PROPERTY DAMAGE.

This document and other information from Parker-Hannifin Corporation, its subsidiaries and authorized distributors provide product or system options for further investigation by users having technical expertise.

The user, through its own analysis and testing, is solely responsible for making the final selection of the system and components and assuring that all performance, endurance, maintenance, safety and warning requirements of the application are met. The user must analyze all aspects of the application, follow applicable industry standards, and follow the information concerning the product in the current product catalog and in any other materials provided from Parker or its subsidiaries or authorized distributors.

To the extent that Parker or its subsidiaries or authorized distributors provide component or system options based upon data or specifications provided by the user, the user is responsible for determining that such data and specifications are suitable and sufficient for all applications and reasonably foreseeable uses of the components or systems.