

CHEMLOK® 219

Technical Data Sheet

Chemlok® 219 can be used as either a one-coat surface treatment or a primer in combination with Chemlok 213 for applications that require increased environmental resistance. It is composed of a mixture of organic resins and polymers in an organic solvent system.

Chemlok 219 is used for affixing a wide variety of both polyether and polyester castable urethanes to metal, as well as affixing certain thermoplastic polyurethanes (TPU).

Features and Benefits

Versatile: affixes a wide variety of polyether and polyester castable urethanes of varying hardness, based on both TDI and MDI; can be used as a primer.

Economical: eliminates the need to inventory several surface treatments due to its versatility.

Convenient: requires only a single coat for most applications, minimizing application costs.

Time Saving: requires no agitation in preparation for use or during application, saving application time and reducing the potential for application errors. Non-settling Chemlok 219 is ready to dip or brush when opened.

Fast Drying: dries fast to allow rapid turnaround times, reducing the number of coated parts kept in inventory.

Elastomers

- Millable Urethane
- Castable Urethane
- Thermoplastic Urethane (TPU)

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 application guide.

Mixing: No agitation is required before or during use. Chemlok 219 is clear to amber in color with no suspended materials; Chemlok 219 can be used as received.

If dilution is needed, use MIBK or denatured ethanol. 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 Chemlok 219 in a uniformly thin coat by brush, spray or dip methods. Thicker adhesive films caused by repeated brushing or improper dipping drainage can compromise performance.

Regardless of application method, the dry film thickness of Chemlok 219 should be 12.7 micron (0.5 mil).

Chemlok 219 doubles as an excellent primer for Chemlok 213. For castable urethane, the properties of Chemlok 219 and Chemlok 213 are complimentary - Chemlok 219 provides excellent protection as a primer for the metal; Chemlok 213 works well on RIM, TPU and castable polyurethanes. Chemlok 213 is also tolerant of processing conditions such as long prebakes. Together, they increase resistance to a variety of environmental elements.

Typical Properties*	
Appearance	Clear to Amber Liquid
Viscosity, cps @ 25°C (77°F) Brookfield LVT Spindle 2, 30 rpm	50 - 110
Density kg/m ³ (lb/gal)	880 - 910 (7.3 - 7.6)
Solids Content by Weight, %	23.5 - 27.0
Flash Point (Seta), °C (°F)	14 (58)
Solvents	Denatured Ethanol, MIBK

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

If prebake lasts longer than one hour at 100°C (212°F), use Chemlok 219 as a primer with Chemlok 213 as a covercoat. Chemlok 219 is a heat-reactive system, therefore, do not allow excessive time and temperature during the prebake stage. When used with Chemlok 213, both systems will tolerate prebakes as long as 16 hours at 121°C (250°F) or as high as 163°C (325°F) for 2 hours.

Drying: Allow coated parts to air-dry for 30-45 minutes at room temperature.

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. Do not store or use near heat, sparks or open flame.

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.

Verify Volatile Organic Compounds (VOC) requirements with the applicable local, regional and state air quality authorities before importing, selling or using this product. VOC rules, thresholds and reporting obligations vary by jurisdiction; compliance is the responsibility of the importer/seller/owner.

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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CHEMLOK® 219

技术说明书

Chemlok® 219可以作为单涂表面处理剂也可作为Chemlok 213的底涂用于需要增加耐环境性能的应用中。本品是有机树脂和聚合物在有机溶剂体系内溶解形成的混合物。

Chemlok 219可用于帮助和促进各种聚醚浇注型聚氨酯和聚酯浇注型聚氨酯附着至金属。也可用于帮助和促进某些热塑性聚氨酯 (TPU)的附着。

特征和优点

用途广泛: 本品可应用于基于TDI和MDI, 不同硬度的聚醚浇注型和聚酯浇注型聚氨酯; 也可作为底涂使用。

经济: 使用范围广泛, 无需库存不同种类的表面处理剂。

使用方便: 大多数情况下仅需涂敷一层, 可降低涂敷成本。

节省时间: 使用前或涂敷过程中无需搅拌, 可节省涂敷时间, 降低涂敷操作失误的可能性。Chemlok 219不会发生沉降, 开封后可立即进行浸涂或刷涂。

快速干燥: 干燥迅速, 可缩短处理时间, 减少涂敷件的库存量。

弹性体

- 混炼型聚氨酯
- 浇注型聚氨酯
- 热塑性聚氨酯 (TPU)

使用方法

表面处理: 在涂敷前, 应彻底清洗金属表面。使用溶剂型除油剂或碱性清洗剂去除金属表面的保护油、切削油和油脂。选择适当的化学或机械清洗方法, 除去金属表面的锈、腐蚀层或氧化层。

对于特定基材的表面处理的详细信息请参阅Chemlok/Chemosil应用指南。

混合: 使用前或使用过程中无需搅拌。Chemlok 219是透明至琥珀色的, 不含悬浮物; Chemlok 219使用前无需准备。

如果需要稀释, 可使用甲基异丁基酮 (MIBK) 或乙醇。注意: 针对不同涂敷方式的稀释最好通过经验获得。稀释会加速沉降, 搅拌时须特别注意。

涂敷: 涂敷Chemlok 219涂敷时应通过刷涂、喷涂或浸涂形成均一的薄膜。如果反复刷涂或在浸涂时沥干操作不当, 导致膜厚增加, 可能会降低性能。

不论采用何种涂敷方式, Chemlok 219的干膜厚度应为12.7微米 (0.5密尔)。

Chemlok 219还是一款出色的底涂, 可与 Chemlok 213配合使用。对浇注型聚氨酯, Chemlok 219与Chemlok 213的特性是互补的。Chemlok 219作为金属底涂, 具有出色的保护能力。Chemlok 213应用于注模型聚氨酯、注塑型聚氨酯和浇注型聚氨酯的性能极佳。Chemlok 213还能承受长时间预烘等工艺条件。这两种产品配合使用, 可提高对多种环境因素的耐受性。

如果在100°C (212°F) 进行预烘干的时间超过一小时, 可使用Chemlok 219作为底涂, 与Chemlok 213 覆涂配合使用。Chemlok 219具有热敏感性, 因此预烘的时间不要过长, 温度不要过高。与Chemlok 213配合使用时, 两者在121°C (250°F) 进行预烘的时间可长达16小时, 或者2个小时的烘烤时间内, 温度最高不超过163°C (325°F)。

干燥: 让涂敷件在室温下自然风干30至45分钟。

典型特性*

外观	透明至琥珀色液体
粘度, cps @ 25°C (77°F) Brookfield粘度计 2号转子, 转速30 rpm	50 - 110
密度 kg/m³ (lb/gal)	880 - 910 (7.3 - 7.6)
固体含量, %	23.5 - 27.0
闪点 (Seta), °C (°F)	14 (58)
溶剂	乙醇, 甲基异丁基甲酮 (MIBK)

*典型数据不可作为产品标准之用。

保质期/储藏要求

自发货之日起,保质期为一年,但是收货人必须使用出厂未开封的原装容器,在 **21-27°C (70-80°F)** 的温度下保存于通风良好区域。储藏或使用时不得靠近热源、火花或明火。

警示信息

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