

CHEMLOK® 485/CURATIVE 44

Technical Data Sheet

Chemlok® 485/Curative 44 is a two-component system used for insert mold applications to affix PVC and Alcryn® to substrates such as metal and rubber.

Features and Benefits

Versatile: works on a wide range of thermoplastic elastomers.

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

Convenient: requires only a single coat for most applications. For harsh environments, apply Chemlok 205GB as a primer prior to application.

Application

Surface Preparation: Remove grease, oil, fingerprints, dust, mold release agents, rust and other contaminants from the surfaces. Wear chemical resistant gloves. Wipe the surfaces with a clean cloth soaked in a solvent such as acetone, MEK or isopropyl alcohol. On metal surfaces, a suitable alkaline degreasing agent may be used. Rinse metals and allow the surfaces to thoroughly dry.

Mixing: Thoroughly stir Chemlok 485. While stirring, add 6-10 parts Chemlok Curative 44 curing agent, by weight, to 100 parts Chemlok 485.

Thoroughly mix the two components before using. A mixed working life of approximately one month can be expected when stored at room temperature and sealed from exposure to moisture.

If dilution is needed, use xylene in a ratio of 3 parts mixed system to 1 part solvent, by weight.

Applying: Apply Chemlok 485/Curative 44 by spray, brush or dip methods.

Regardless of application method, the dry film thicknesses of Chemlok 485/Curative 44 should be 17.8-25.4 micron (0.7-1.0 mil).

Drying/Curing: Before molding, allow coated parts to air-dry for 1-2 hours at 18-27°C (65-80°F) and at least 45% relative humidity. Drying time can be shortened by oven drying for 4 minutes at 93°C (200°F) or 2 minutes at 138°C (280°F). Larger parts may require more oven time as a result of the heat sink effect.

For best results, injection mold within 24 hours of adhesive application.

Although optimum performance is achieved when molding is done shortly after application and drying, coated parts can sit for one week before processing if care is taken to protect the coated parts from contamination. Prior to molding, preheat the coated parts to 107-121°C (225-250°F) and immediately place parts into the mold.

Cleanup: Use solvents such as xylene or MEK to remove Chemlok 485/Curative 44 before heat is applied. Remove cured Chemlok 485/Curative 44 by mechanical blasting methods.

Typical Properties*

	485 Resin	Curative 44
Appearance	Clear to Amber Liquid	Transparent Brown Liquid
Viscosity, cps @ 25°C (77°F) Brookfield LVT Spindle 2, 30 rpm	400 - 1000	<10 (typical)
Density kg/m ³ (lb/gal)	850.8 - 874.7 (7.1 - 7.3)	1010.0 - 1040.0 (8.4 - 8.7)
Solids Content by Weight, %	15 - 17	47 - 51.5
Flash Point (Seta), °C (°F)	-4 (+24)	29 (85)
Solvents	MEK, Xylene	Xylene

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

Shelf Life/Storage

Shelf life of each component 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.

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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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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CHEMLOK® 485/CURATIVE 44

技术说明书

Chemlok® 485/Curative 44作为双组分表面处理剂,在注射成型工艺中,可促进PVC和Alcryn® 粘接至金属、橡胶等基材上。

特征和优点

用途广泛: 可适用于广泛的各种热塑性弹性体。

易于涂敷: 通过喷涂、刷涂或浸涂方式可轻松涂敷。

使用方便: 大多数应用只需单层涂敷。对于严苛的环境,在使用前先涂敷一层Chemlok 205GB底涂。

使用方法

表面处理: 去除表面的油脂、油、指印、灰尘、脱模剂和其它污染物。穿戴耐化学品的手套。使用沾有例如丙酮、MEK 或异丙醇溶剂的清洁抹布擦拭表面。金属表面上可使用适当的碱性脱脂剂。冲洗金属,然后待其彻底干燥。

混合: 彻底搅拌Chemlok 485。搅拌时,向100份Chemlok 485中加入6-10份Chemlok Curative 44固化剂(按照重量计算)。

使用前,彻底混合两个组分。室温保存且没有水气污染,混合后的溶液作业时间约为一个月。

如果需要稀释,可使用二甲苯以3:1(混合溶液:溶剂)的重量比进行稀释。

涂敷: 采用喷涂、刷涂或浸涂的方式。

不论采用何种涂敷方式,Chemlok 485/Curative 44的干膜厚度应为17.8-25.4微米(0.7-1.0密尔)。

干燥/固化: 成型之前,需将涂胶件置于18-27°C (65-80°F),相对湿度不低于45%的环境下1-2小时。干燥时间可通过烘箱干燥缩短,93°C (200°F) 4分钟或138°C (280°F) 2分钟。由于热沉效应,更大的零件可能需要更长的烘箱干燥时间。

为了得到最佳的粘接效果,建议在涂胶完成后24小时内完成注塑成型。

虽然最佳效果需要在涂敷和干燥后迅速成型方可实现,但只要小心保护已涂敷的工件不受污染,它可放置一周再进行处理。在成型之前,需将已涂敷的工件预热至 107-121°C (225-250°F),然后迅速将它们放入模具。

清理: 使用二甲苯或丁酮(MEK)等溶剂清除多余的未经硫化的Chemlok 485/Curative 44。完全固化后需要使用机械打磨的方式去除Chemlok 485/Curative 44。

保质期/储藏要求

原始未开封的包装容器,在21-27°C (70-80°F)的温度下保存,自发货日起,保质期为一年。

典型特性*

	485	Curative 44
外观	透明至琥珀色的液体	透明褐色液体
粘度, cps @ 25°C (77°F) Brookfield粘度计 2号转子, 转速30 rpm	400-1000	< 10 (典型值)
密度 kg/m ³ (lb/gal)	850.8 - 874.7 (7.1 - 7.3)	1010.0 - 1040.0 (8.4 - 8.7)
固体含量, %	15 - 17	47 - 51.5
闪点 (Seta), °C (°F)	-4 (+24)	29 (85)
溶剂	丁酮 (MEK), 二甲苯	二甲苯

*典型数据不可作为产品标准之用。

警示信息

使用本品或派克洛德 (Parker Lord) 任何产品之前, 请参阅安全数据表 (SDS) 和产品标签上关于安全使用和处理的说明。

在进口、销售或使用本产品之前, 请与当地及相关国家区域的空气质量主管部门核实挥发性有机物 (VOC) 的要求。VOC 的规定、阈值和报告义务因地区而异; 合规责任在于进口商/销售商/所有者。

仅可用于工业/商业用途。使用本品者事先必须接受相关培训。不得用于家庭用途。不得用于消费品。

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