

CHEMLOK® 487 A/BX

Technical Data Sheet

Chemlok® 487 A/BX is a two-component system used to affix thermoplastic elastomers (TPEs) to metals, glass, plastics (both thermoplastic and thermoset) and other elastomers during injection molding. Chemlok 487 works well on Santoprene®, Kraton® and Sarlink® thermoplastic elastomers.

When using Chemlok 487 to mold TPEs to glass, apply Chemlok 144 as a primer prior to application of Chemlok 487.

Features and Benefits

Durable: provides a strong, durable system that, in many instances, has strength equal to or greater than the elastomer being molded.

Fast Drying: allows for spray application; provides a uniform coating over a large surface area, accelerated solvent evaporation and a shortened drying time.

Versatile: affixes a variety of TPEs to a variety of substrates.

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, methyl ethyl ketone 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 487A component. While stirring Chemlok 487A component, add Chemlok 487BX component using the following mix ratio:

by Weight 100:13.6, 487A to 487BX
by Volume 100:15.0, 487A to 487BX

Thoroughly mix the two components before use. Transfer the mixed system to an enclosed vessel where it can be kept free from moisture contamination. Mixed working life is approximately one week at room temperature. Solids content, by volume, of mixed adhesive is 10-11%.

If dilution is needed, use xylene or toluene.

Applying: Apply Chemlok 487 by dip, brush or spray methods.

Regardless of application method, the dry film thickness of Chemlok 487 should be 17.8-25.4 micron (0.7-1.0 mil), which requires that a wet film thickness of 170-244 micron (6.7-9.6 mil) be applied.

Drying/Curing: Allow Chemlok 487 to air-dry for one hour at room temperature. Oven heat methods will accelerate drying to less than 10 minutes at 93°C (200°F).

Although optimum performance is achieved when molding is done shortly after application and drying, coated parts can sit for 4 to 5 days 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.

Typical Properties*

	487A	487BX
Appearance	Clear to Yellow Liquid	Clear, Colorless Liquid
Viscosity, cps @ 25°C (77°F) Brookfield LVT Spindle 2, 30 rpm	100 - 350	1-10
Density kg/m ³ (lb/gal)	860.0 - 910.0 (7.2 - 7.6)	803.0 - 851.0 (6.7 - 7.1)
Solids Content, % by Weight by Volume	12.6 - 15 11-12	1-2 1-2
Flash Point (Seta), °C (°F)	27 (81)	9 (49)
Solvents	Xylene	Isopropyl Alcohol, Xylene

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

For insert molding, apply Chemlok 487 to prepared metal or plastic inserts at a dry film thickness of 17.8-25.4 micron (0.7-1.0 mil). For harsh environments, prime metal inserts with Chemlok 205 before applying Chemlok 487 as a topcoat.

For injection molding TPEs to glass, clean the glass surface with a vinegar-based glass cleaner and apply Chemlok 144 as a primer. Thoroughly hydrolyze Chemlok 144 before applying Chemlok 487 as a topcoat. Allow Chemlok 487 to air-dry for one hour at room temperature or for 3-10 minutes at 93°C (200°F). Preheat primed and topcoated glass to 121°C (250°F) prior to injection molding. Exercise caution in removing assemblies from the mold and allow molded assemblies to layover for 24 hours before testing.

Cleanup: Use ketone or aromatic type solvents for clean up of uncured Chemlok 487. Thoroughly cured Chemlok 487 may require solvent immersion for extended periods of time, followed by mechanical abrasion.

Shelf Life/Storage

Shelf life of each component is one year from date of manufacture when stored by the recipient at 21-27°C (70-80°F) in original, unopened container.

Chemlok 487 components are moisture sensitive. Minimize exposure to moisture during application and storage.

To help prevent the formation of a gel-like consistency, store

Chemlok 487A component above 21°C (70°F). If, however, a gel-like consistency does develop, heat Chemlok 487A component to temperature above 49°C (120°F) and shake material until it returns to a homogeneous liquid.

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® 487 A/BX

技术说明书

Chemlok® 487 A/BX 作为双组分体系表面处理剂, 在注射成型期间, 可帮助和促进热塑性弹性体 (TPE) 粘接至金属、玻璃、塑料 (热塑性和热固性均可) 及其他弹性体。Chemlok 487 也适合用于 Santoprene®、Kraton® 和 Sarlink® 热塑性弹性体。

使用 Chemlok 487 将 TPE 成型至玻璃时, 需先涂敷 Chemlok 144 底涂, 然后再涂敷本品。

特征和优点

耐久性强: 提供一个坚固耐用的系统, 在许多情况下, 其强度等于或大于成型的弹性体。

快速干燥: 允许进行喷涂, 可实现大表面积上的均匀涂敷, 提升溶剂蒸发速度并缩短干燥时间。

用途广泛: 可帮助和促进各种 TPE 附着至多种基材。

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。穿戴防化手套。使用浸透了某种溶剂 (例如, 丙酮、丁酮或异丙醇) 的干净抹布擦拭表面。金属表面上可使用适当的碱性脱脂剂。冲洗金属, 然后待其表面干透。

混合: 彻底搅拌 Chemlok 487A 组分。在搅拌 Chemlok 487A 组分的同时, 使用以下混合比添加 Chemlok 487BX 组分:

按重量	100:13.6, 487A 与 487BX
按体积	100:15.0, 487A 与 487BX

使用前, 彻底混合两个组分。将混合后的体系转移到密封容器中, 以免被湿气污染。室温下, 混合后的有效时间约为一周。固态成分占混合后胶粘剂体积的 10-11%。

如果需要稀释, 可使用二甲苯或甲苯。

涂敷: Chemlok 487 可采用浸涂、刷涂或喷涂。

不论采用何种涂敷方式, Chemlok 487 的干膜厚度应为 17.8-25.4 微米 (0.7-1.0 密尔), 这要求涂敷的湿膜厚度为 170-244 微米 (6.7-9.6 密尔)。

干燥/固化: Chemlok 487 自然风干需要一个小时。采用烤箱加热法将温度升至 93°C (200°F) 时, 干燥时间可减少至 10 分钟以内。

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 4 至 5 天再进行处理。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。

对于插入模具, 应在准备好的金属或塑料插入件上涂敷干膜厚度为 17.8-25.4 微米 (0.7-1.0 mil) 的 Chemlok 487。对于严苛的环境, 需为金属插入件涂敷 Chemlok 205 底涂, 然后再涂敷 Chemlok 487 面涂。

典型特性*

	487A	487BX
外观	透明至浅黄色液体	清澈无色液体
粘度, cps @ 25°C (77°F) Brookfield 粘度计 2号转子, 转速 30 rpm	100 - 350	1 - 10
密度 kg/m ³ (lb/gal)	860.0 - 910.0 (7.2 - 7.6)	803.0 - 851.0 (6.7 - 7.1)
固体含量% 按重量 按体积	12.6 - 15 11 - 12	1 - 2 1 - 2
闪点 (Seta), °C (°F)	27 (81)	9 (49)
溶剂	二甲苯	异丙醇, 二甲苯

*典型数据不可作为产品标准之用。

对于将 TPE 注射成型至玻璃, 需使用醋基玻璃清洁剂清洁玻璃表面, 然后涂敷 Chemlok 144 底涂。彻底水解 Chemlok 144 后, 再涂敷 Chemlok 487 面涂。待 Chemlok 487 在室温下空气中干燥一小时, 或在 93°C (200°F) 下干燥 3-10 分钟。将涂了底涂和面涂的玻璃预热至 121°C (250°F), 然后再注射成型。将零部件从模具中移出时务必小心; 应停放零部件 24 小时后, 再进行测试。

清理: 使用酮类或芳香族溶剂清理未固化的 Chemlok 487。完全固化后可能需要使用溶剂长时间浸泡, 然后再通过机械打磨去除。

保质期/储藏要求

自生产之日起, 每个组分的保质期都是一年, 但是收货人必须使用出厂未开封的原装容器, 且保存在 21-27°C (70-80°F) 的环境下。

Chemlok 487 的两个组分均对湿气敏感。在涂敷和储藏过程中应尽量减少与湿气接触。

为避免形成均匀凝胶状, 请将 Chemlok 487A 组分保存在 21°C (70°F) 以上的环境中。但是, 如果已经成为了均匀凝胶状, 请将 Chemlok 487A 组分加热至 49°C (120°F) 以上, 并进行晃动, 直至其变回均质液体为止。

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。要求本品在有组织排放下使用。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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