

Chemosil® 225 Adhesive

Technical Data Sheet

Chemosil® 225 adhesive is a covercoat material that bonds a variety of elastomer compounds to metal and plastic substrates during the vulcanization process. It is composed of a mixture of dispersed polymers and heat-reactive components in an organic solvent system.

Features and Benefits:

Versatile – when used in combination with Chemosil 211 primer, bonds a variety of elastomers and metals

Easy to Apply – applies easily by spray, dip, brush or roll coat methods.

Environmentally Resistant – provides superior resistance to heat and salt spray.

Elastomers:

- Natural Rubber (NR)
- Polychloroprene (CR)
- Polyisoprene (IR)
- Nitrile (NBR)
- Styrene-butadiene (SBR)
- Butyl (IIR)
- Polybutadiene (BR)

Application:

Surface Preparation – Thoroughly clean metal surfaces prior to primer 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.

Allow primer to thoroughly dry before applying Chemosil 225 adhesive.

For further detailed information on surface preparation of specific substrates, refer to Chemlok/Chemosil Adhesives application guide.

Mixing – Thoroughly stir adhesive before use, and agitate sufficiently during use to keep dispersed solids uniformly suspended. If dilution is needed, use xylene or toluene. 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 adhesive by brush, roll coat, dip or spray methods. Avoid applying thick coats which result in poor drying and may lead to film displacement during molding.

Regardless of application method, the dry film thickness of Chemosil 225 adhesive should be 10-15 micron (0.4-0.6 mil).

Drying/Curing – Allow applied adhesive to air-dry for at least 30 minutes at room temperature. Drying time can be shortened by using hot air drying ovens or tunnels up to 90°C (194°F).

Bonding occurs during vulcanization process of the rubber under recommended cure temperatures of 130-180°C (266-356°F). Lower temperatures [~100°C (212°F)] with extended cure times may also be used for tank lining applications.

Cleanup – Use xylene or toluene for clean up.

Typical Properties*

Appearance	Black Liquid
Viscosity, cps @ 25°C (77°F) Brookfield LVT Spindle 2, 30 rpm	80 - 250
Density @ 20°C (68°F) g/cm ³ (lb/gal)	0.98 - 1.02 (8.18 - 8.51)
Solids Content by Weight, % Dry residue, 30 minutes @ 130°C (266°F)	23 - 27
Flash Point, °C (°F) Pensky-Martens	27 (81)
Solvents	Xylene

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

Shelf Life/Storage:

Shelf life is two years from date of manufacture when stored by the recipient below 25°C (77°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.

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.

©2022 Parker Hannifin - All Rights Reserved

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

OD DS3904E 12/22 Rev.3



Parker Lord
Engineered Materials Group

111 LORD Drive
Cary, NC 27511-7923
USA

www.Parker.com/EPM

Lord Suisse Sàrl
A Parker Hannifin Company

La Tuilière 6
1163 Etoy
Switzerland

phone +41 (0) 21 821 85 00