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

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.

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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.

OD DS3904E 12/22 Rev.3

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