Chemosil® 211 Primer and/or Adhesive

Technical Data Sheet

Chemosil® 211 primer is a heat-activated material designed for use as a substrate primer under other Chemosil covercoat adhesives, or as a one-coat adhesive for bonding unvulcanized nitrile elastomer compounds. It is composed of a mixture of polymers, organic compounds and mineral fillers dissolved or dispersed in an organic solvent system.

Features and Benefits:

Versatile – can be used as a primer under a wide variety of Chemosil covercoat adhesives.

Convenient – can be used as a one-coat adhesive to bond unvulcanized nitrile elastomer compounds to metal and plastics.

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

Durable – provides high tear and cohesive strength, as well as excellent environmental resistance when used in combination with Chemosil covercoat adhesives.

Elastomers:

- Nitrile (NBR)

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/Chemosil Adhesives application guide.

Mixing – Thoroughly stir primer before use, and agitate sufficiently during use to keep dispersed solids uniformly suspended. If dilution is needed, use ketone-type solvents such as MEK and MIBK. Note proper dilution of various application methods is best achieved by experience. Give careful attention to agitation since dilution will accelerate settling.

Applying – Apply primer 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 211 primer should be 8-12 micron (0.3-0.5 mil).

Drying/Curing – Thoroughly dry parts coated with Chemosil 211 primer before applying the covercoat adhesive. This will take 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).

Cleanup – Use MIBK or MEK for clean up.

Shelf Life/Storage:

Shelf life is one year from date of manufacture when stored by the recipient below 25°C (77°F) in original, unopened container.

Typical Properties*	
Appearance	Grey Liquid
Viscosity, cps @ 25°C (77°F) Brookfield LVT Spindle 2, 30 rpm	90 - 170
Density @ 20°C (68°F) g/cm^3 (lb/gal)	 0.92 - 0.96 (7.7 - 8.0)
Solids Content by Weight, % Dry residue, 30 minutes @ 130°C (266°F)	22 - 26
Flash Point, °C (°F) Pensky-Martens	17 (62)
Solvents	MIBK, Xylene

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

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.

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