

Chemlok® 8006 Primer

Description

LORD Chemlok® 8006 aqueous primer is designed to bond elastomers to metals and other substrates when used with Chemlok aqueous covercoat adhesives.

Features and Benefits

Environmentally Friendly – uses water for dilution; provides reduced VOC emissions.

Versatile – functions as an effective primer for many materials such as steel, phosphated steel, nylon, aluminum and brass.

Durable – maintains excellent metal adhesion under flexing and high-stress conditions.

Environmentally Resistant – provides excellent resistance to water, salt spray, glycol, oil and heat.

Easy to Use – easily redispersed within 5 to 15 minutes of stirring; imparts little or no settling.

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.

- **Chemical Cleaning**

Chemical treatments are readily adapted to automated metal treatment and adhesive application lines. Chemical treatments are also used on metal parts that would be distorted by blast cleaning or where tight tolerances must be maintained. Phosphatizing is a commonly used chemical treatment for steel, while conversion coatings are commonly used for aluminum.

- **Mechanical Cleaning**

Grit blasting is the most widely used method of mechanical cleaning. However machining, grinding or wire brushing can be used. Use steel grit to blast clean steel, cast iron and other ferrous metals. Use aluminum oxide, sand or other nonferrous grit to blast clean stainless steel, aluminum, brass, zinc and other nonferrous metals.

For further detailed information on surface preparation of specific substrates, refer to Chemlok Adhesives application guide. Handle clean metal surfaces with clean gloves to avoid contamination with skin oils.

Typical Properties*

Appearance	Gray Liquid
Viscosity, cps @ 25°C (77°F) Brookfield LVT Spindle 2, 30 rpm	15-100
Density kg/m ³ (lb/gal)	1150.3-1198.3 (9.6-10.0)
Solids Content by Weight, %	34-38
Flash Point (Seta), °C (°F)	>93 (>200)
Solvents	Deionized Water
pH	5-7

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

LORD TECHNICAL DATA

Mixing – Thoroughly mix Chemlok 8006 primer before using. This will disperse any soft settling which may have occurred during storage. Do not shake. To prevent foaming, mechanical mixing should not exceed 30 rpm. The addition of anti-foaming agents is not recommended.

In most cases, dilution is not required. Deionized water is recommended if dilution is necessary. Add water gradually while stirring either by hand or by using another low-shear mixing method.

Applying – Preheat substrates to 60-65°C (140-150°F). Spray primer on the heated parts. This heat and spray method prevents runs and sags and gives a dry coating ready for covercoat application. All spray equipment, including pressure pots, hoses, guns and nozzles, should be stainless steel or plastic.

For optimum adhesion and environmental resistance, the dry film thickness of Chemlok 8006 primer should be 7.6-12.7 micron (0.3-0.5 mil).

Drying – If no preheat is employed, parts will dry in 30-60 minutes at room temperature. Wear clean gloves when handling coated parts and keep coated parts covered to prevent contamination.

Cleanup – Use soap and water to remove wet primer. Dried primer is not water-soluble and must be removed with a solvent such as acetone, methyl ethyl ketone (MEK) or isopropyl alcohol.

Shelf Life/Storage

Shelf life is six months from date of shipment when stored at 21-27°C (70-80°F) in original, unopened container. Do not freeze product.

Cautionary Information

Before using this or any LORD product, refer to the Material Safety Data Sheet (MSDS) 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 technical data sheet 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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