

Chemlok® 8008 Primer

Description

LORD Chemlok® 8008 aqueous primer is designed to bond elastomers to metals and other substrates when used with Chemlok aqueous covercoat adhesives. It is composed of a mixture of dispersed mineral fillers, organic compounds, resins and polymer latices in an aqueous medium.

Features and Benefits

Environmentally Friendly – provides low VOC and HAP for reduced emissions, allowing for safer work environment and regulatory compliance.

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

Environmentally Resistant – preferred aqueous Chemlok primer for glycol resistance; provides excellent resistance to water, salt spray, oil and heat.

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

Excellent Appearance – provides a smooth coating for use by dip or spray applications. The green color affords good contrast with aqueous covercoat adhesives and prepared substrates.

Easy to Use – easily redispersed within 5 to 15 minutes of stirring; imparts little or no settling; ready to use directly out of the container without dilution.

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	Green Liquid
Viscosity, cps @ 25°C (77°F) Brookfield LVT Spindle 2, 30 rpm	10-150
Density kg/m ³ (lb/gal)	1114.4 -1162.3 (9.3-9.7)
Solids Content by Weight, %	28-32
Flash Point (Seta), °C (°F)	>93 (>200)
Solvents	Deionized Water

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

LORD TECHNICAL DATA

Mixing – Thoroughly mix Chemlok 8008 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 suggested 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). This heat and spray method prevents runs and sags and gives a dry coating ready for covercoat application. Use contaminant-free air for spraying.

All spray equipment, including tanks, fixtures, pressure pots, hoses, guns and nozzles, should be stainless steel or plastic.

For optimum adhesion and environmental resistance, the dry film thickness of Chemlok 8008 primer should be 5.1-10.2 micron (0.2-0.4 mil).

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

When used in combination with aqueous Chemlok covercoat adhesives, Chemlok 8008 primer can be used to bond rubber by compression, transfer and injection molding procedures.

Cleanup – Use soap and water to remove wet primer. Dried primer is not water-soluble and must be removed with a ketone-type solvent.

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. Storage below 4°C (40°F) may be detrimental to the primer's properties.

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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