

LORD® HPC Primer

Description

LORD® HPC primer is used to promote adhesion of LORD HPC and HRC coatings when used over natural rubber elastomers. 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 – enhances adhesion to a variety of natural rubber stocks.

Easy to Apply – applies easily by dip, brush or spray application.

Identifiable Appearance – red color aids visual inspection, ensuring uniform and complete primer coverage.

Application

Surface Preparation – Thoroughly clean substrates prior to primer application. Remove all surface contaminants using a hot water wash, warm alkaline wash or solvent wipe. Surface cleaning is not necessary if parts are coated with LORD HPC primer immediately after molding operations.

Mixing – If application method requires dilution, use toluene or xylene as diluents. For spray application, use mix ratio of 1:1 or 2:1 (primer to solvent), by weight.

Applying – Apply LORD HPC primer by brush, dip or spray method. If possible, preheat substrate to 38-65°C (100-150°F) prior to primer application, or use residual heat from molding process. For optimum adhesion, the dry film thickness of the primer should be approximately 2.5 micron (0.1 mil).

Spay aides, such as aluminum shims or M-12 Leneta squares, can be utilized during spray application to ensure a complete and continuous primer layer is being applied.

Drying/Curing – Dry times will vary depending on part size and air flow. Suggested dry time is 5 minutes in a forced air oven at 150°C (300°F).

Cleanup – Use xylene, toluene or methyl ethyl ketone (MEK) for clean up.

Shelf Life/Storage

Shelf life is one year from date of shipment when stored at 21-27°C (70-80°F) in original, unopened container.

Typical Properties*

Appearance	Red Liquid
Viscosity	
cps @ 25°C (77°F)	20-50
Brookfield LVT	
Spindle 3, 60 rpm	
seconds @ 25°C (77°F)	30-55
Zahn Cup #1	
Density	
kg/m ³	862.7-886.7
(lb/gal)	(7.2-7.4)
Solids Content by Weight, %	5.5-7.5
Flash Point (Seta), °C (°F)	7 (44)
Solvents	Toluene

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

LORD TECHNICAL DATA

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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