

Chemlok® 298 Primer

Description

LORD Chemlok® 298 primer is a solvent-based primer designed to provide excellent bond performance and environmental resistance for high performance applications. It is composed of a mixture of polymers, organic compounds and mineral fillers dissolved or dispersed in an organic solvent system.

Features and Benefits

Excellent Adhesion – adheres well to properly prepared metals, such as cold rolled steel and aluminum.

Temperature Resistant – when used in combination with Chemlok 6956 adhesive, provides exceptional resistance to high heat applications and environments.

Fluid Resistant – when used in combination with Chemlok 6956 adhesive, provides excellent resistance to hot solutions of water and ethylene glycol or propylene glycol.

Corrosion Resistant – provides excellent corrosion resistance when used with properly prepared metals.

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.

Typical Properties*

Appearance	Gray Liquid
Viscosity, cps @ 25°C (77°F) Brookfield LVT Spindle 2, 30 rpm	<800
Density kg/m ³ (lb/gal)	974.2 (8.13)
Solids Content by Weight, %	25
Flash Point (Seta), °C (°F)	16 (61)
Solvents	Methyl Isobutyl Ketone (MIBK), Xylene

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

LORD TECHNICAL DATA

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.

Mixing – Thoroughly stir Chemlok 298 primer before use, and agitate sufficiently during use to keep dispersed solids uniformly suspended. If dilution is needed, use MIBK as diluent.

Applying – Apply primer by brush or spray methods. Regardless of application method, dry film thickness of Chemlok 298 primer should be 7.6-12.7 micron (0.3-0.5 mil) for optimum adhesion and environmental resistance.

- Brushing
Apply full strength; avoid multiple brush strokes.
- Spraying
Dilute Chemlok 298 primer with MIBK at a mix ratio of 2 parts primer to 1 part solvent, by volume. Chemlok 298 primer requires dedicated application equipment, i.e., pressure pots, fluid lines and spray guns. Gelling can occur if Chemlok 298 primer comes in contact with other Chemlok primers and adhesives.

Drying/Curing – Thoroughly dry parts coated with Chemlok 298 primer before applying adhesive. Typical drying conditions are 4-5 minutes at 65.5°C (150°F). Drying schedule may vary depending on size of part being coated.

Cleanup – Use solvents such as MIBK or Methyl Ethyl Ketone (MEK) to remove wet or dry primer. Once heat cured, the primer must be removed by mechanical blasting methods.

Shelf Life/Storage

Shelf life is six months from date of shipment when stored in a well ventilated area at 21-27°C (70-80°F) in original, unopened container.

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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