

CHEMLOK® EP5080-11 PRIMER

Technical Data Sheet

Chemlok® EP5080-11 primer, a non-pigmented version of Chemlok 205 primer, is designed for use as a substrate primer under Chemlok covercoat adhesives to bond a wide variety of vulcanized and unvulcanized rubber compounds to metals and other rigid substrates. Chemlok EP5080-11 primer may also be used as a one-coat adhesive to bond nitrile elastomers to metal.

Features and Benefits

Versatile: can be used as a primer under a wide variety of Chemlok covercoat adhesives.

Easy to Apply: applies easily by brush, dip, spray or roll coat methods; suitable for existing production lines.

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

Fluid Resistant: provides excellent resistance to ASTM Oils #1 and #3 and Reference Fuel B.

Convenient: requires only a single coat application to bond nitrile rubber compounds to rigid substrates during vulcanization.

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.

Apply Chemlok EP5080-11 primer to stainless steel, aluminum, brass or other nonferrous substrates within one hour after cleaning. For ferrous substrates such as steel, a longer layover can be tolerated if no rust is formed.

For further detailed information on surface preparation of specific substrates, refer to Chemlok Adhesives application guide.

Mixing: Thoroughly stir primer before use. Primer does not require extensive mixing. If dilution is needed, use ketone-type solvents such as MEK and MIBK. Note proper dilution for the various application methods is best achieved by experience. Give careful attention to agitation since dilution will accelerate settling.

Applying: Apply primer by brush, dip, roll coat, spray or any method that gives a uniform coating and avoids excessive runs or tears.

Typical Properties*

Appearance	Hazy Amber Liquid
Viscosity cps @ 25°C (77°F) Brookfield LVT Spindle 1, 30 rpm	0 - 25
seconds Zahn Cup #1	28 - 35
Density kg/m ³ (lb/gal)	840.0 - 870.0 (7.0 - 7.22)
Solids Content by Weight, %	12 - 16
Flash Point (Seta), °C (°F)	15 (59)
Solvents	MIBK, MEK, Xylene

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

Normally the dry film thickness of Chemlok EP5080-11 primer should be 5.1-10.2 micron (0.2-0.4 mil). When using Chemlok EP5080-11 primer over grit blasted substrates or when using it in conjunction with Chemlok covercoats, apply a dry film thickness at the high end of the range. For certain applications (i.e., swaging or smooth substrates), apply Chemlok EP5080-11 primer at the low end of the film thickness range.

Drying/Curing: Thoroughly dry coated parts before applying the covercoat adhesive. This will take approximately 30-45 minutes at room temperature. It is best to use temperatures of 65-93°C (150-200°F) and abundant circulating air; however, forced air drying is possible at temperatures up to 149°C (300°F) for short periods of time. Maximum air flow at minimum temperatures will give the best results. After parts have dried, apply Chemlok covercoats using similar application methods.

Cleanup: Clean areas with a rag as soon as possible using MEK.

Shelf Life/Storage

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

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.

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