

CHEMLOK® 8310 PRIMER

OBSOLETE

Technical Data Sheet

Chemlok® 8310 water-based primer is designed for use in adhesive applications to provide excellent corrosion resistance and functional protection for NVH components. Chemlok 8310 primer has been tested against and meets the GM9984132 Grade E test criteria.

Applied via an automated dip process, Chemlok 8310 primer must be applied over clean ferrous substrates.

Features and Benefits

Substrate Protection: provides excellent corrosion, chemical, heat and mar-scratch resistance properties that help improve overall product performance and durability.

Manufacturing Process: applied via traditional dip process.

Environmentally Preferred: formulated to be free of toxic heavy metals and have minimal VOC and HAPs content.

Application

Surface Preparation: Remove all oils, grease, wax, etc. from the substrate prior to application. Typically, traditional water-based alkaline cleaning systems are sufficient to prepare the substrate.

Applying: Apply primer by a dip process utilizing a typical immersion time of 15-60 seconds. The bath requires constant circulation to optimize application consistency and maximize bath life. If required, substrate may be rinsed.

Dehydrating/Curing: Process primer coated part through a dehydrating oven for approximately 10 minutes at 71°C (160°F). Cure in a final bake oven until temperature of part reaches at least 200°C (392°F).

Cleanup: Use water to clean equipment or parts.

Shelf Life/Storage

Shelf life is one year from date of shipment when stored in original, unopened container. If frozen, allow material to thaw at room temperature up to 30°C (86°F).

Typical Properties*

Appearance	Black Liquid
Viscosity, cps @ 25°C (77°F) Brookfield LVT Spindle 2, 30 rpm	1 - 100
Density kg/m ³ (lb/gal)	1050 (8.70)
Solids Content by Weight, %	12 - 15
Flash Point (Seta), °C (°F)	≥93 (≥201)
pH	2.0
Volatile Organic Content (VOC), g/L	0
Hazardous Air Pollutants (HAP), g/L	0.3

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

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.

Product Performance*

Product	Description	Pass/Fail	Results	Rating Method
Chemlok 8310	Gloss	Pass	60 @ 85°C	–
Chemlok 8310	Pencil Hardness	Pass	6H	–
Chemlok 8310	Cross-Hatch Adhesion	Pass	>99%	Method A
Chemlok 8310	Impact - direct side	–	160	Visual only
Chemlok 8310	Impact - reverse side	–	160	Visual only
Chemlok 8310	Humidity Resistance	Pass	100%	GM 9071P B (Adhesion)
Chemlok 8310	Humidity Resistance	Pass	10	ASTM D714 (Blisters)
Chemlok 8310	Gravelometer	Pass	6 or 7	Method B
Chemlok 8310	Corrosion Resistance	Pass	3 mm	GM 9102P (Creep)
Chemlok 8310	Corrosion Resistance	Pass	10	ASTM D714 (Blisters)
Chemlok 8310	Corrosion Resistance	Pass	3 mm	ASTM D610 (Corrosion)
Chemlok 8310	Cyclic Corrosion	Pass	3 mm	GM 9102P (Creep)
Chemlok 8310	Cyclic Corrosion	Pass	10	GM 8101G

**Performance testing completed on cold rolled steel lab panels.

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