

CHEMOSIL® 211 PRIMER AND/OR ADHESIVE

Technical Data Sheet

Chemosil® 211 primer is a heat-activated material designed for use as a substrate primer under other Chemosil covercoat adhesives, or as a one-coat adhesive for bonding unvulcanized nitrile elastomer compounds. 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: can be used as a primer under a wide variety of Chemosil covercoat adhesives.

Convenient: can be used as a one-coat adhesive to bond unvulcanized nitrile elastomer compounds to metal and plastics.

Easy to Apply: applies easily by spray, dip, brush or roll coat methods.

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

Elastomers

- Nitrile (NBR)

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.

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

Mixing: Thoroughly stir primer before use, and agitate sufficiently during use to keep dispersed solids uniformly suspended. If dilution is needed, use ketone-type solvents such as MEK and MIBK. Note proper dilution for various application methods is best achieved by experience. Give careful attention to agitation since dilution will accelerate settling.

Applying: Apply primer by brush, roll coat, dip or spray methods. Avoid applying thick coats which result in poor drying and may lead to film displacement during molding.

Regardless of application method, the dry film thickness of Chemosil 211 primer should be 8-12 micron (0.3-0.5 mil).

Drying/Curing: Thoroughly dry parts coated with Chemosil 211 primer before applying the covercoat adhesive. This will take at least 30 minutes at room temperature. Drying time can be shortened by using hot air drying ovens or tunnels up to 90°C (194°F).

Cleanup: Use MIBK or MEK for clean up.

Shelf Life/Storage

Shelf life is one year from date of manufacture when stored by the recipient below 25°C (77°F) in original, unopened container.

Typical Properties*

| | |
|------------------------------------------------------------------------|----------------------------|
| Appearance | Grey Liquid |
| Viscosity, cps @ 25°C (77°F) Brookfield LVT Spindle 2, 30 rpm | 90 - 170 |
| Density @ 20°C (68°F) g/cm ³ (lb/gal) | 0.92 - 0.96 (7.7 - 8.0) |
| Solids Content by Weight, % Dry residue, 30 minutes @ 130°C (266°F) | 22 - 26 |
| Flash Point, °C (°F) Pensky-Martens | 17 (62) |
| Solvents | MIBK, Xylene |

*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.

Verify Volatile Organic Compounds (VOC) requirements with the applicable local, regional and state air quality authorities before importing, selling or using this product. VOC rules, thresholds and reporting obligations vary by jurisdiction; compliance is the responsibility of the importer/seller/owner.

For industrial/commercial use only. Must be applied by trained personnel only. Not to be used in household applications. Not for consumer use.

Parker Lord
Engineered Materials Group
111 LORD Drive
Cary, NC 27511-7923
USA
www.parker.com/EPM

Parker Hannifin GmbH
Itterpark 8
40724 Hilden
Germany
phone +49 (0) 2103 252 310

DS3901E OD 11/25 Rev.4

Information and specifications subject to change without notice and without liability therefor.
Trademarks used herein are the property of their respective owners.

© 2025 Parker Hannifin Corporation



Values stated in this document 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.

Information provided herein is based upon tests believed to be reliable. In as much as Parker Lord has no control over the manner in which others may use this information, it does not guarantee the results to be obtained. In addition, Parker Lord does not guarantee the performance of the product or the results obtained from the use of the product or this information where the product has been repackaged by any third party, including but not limited to any product end-user. Nor does the company make any express or implied warranty of merchantability or fitness for a particular purpose concerning the effects or results of such use.

WARNING — USER RESPONSIBILITY. FAILURE OR IMPROPER SELECTION OR IMPROPER USE OF THE PRODUCTS DESCRIBED HEREIN OR RELATED ITEMS CAN CAUSE DEATH, PERSONAL INJURY AND PROPERTY DAMAGE.

This document and other information from Parker-Hannifin Corporation, its subsidiaries and authorized distributors provide product or system options for further investigation by users having technical expertise.

The user, through its own analysis and testing, is solely responsible for making the final selection of the system and components and assuring that all performance, endurance, maintenance, safety and warning requirements of the application are met. The user must analyze all aspects of the application, follow applicable industry standards, and follow the information concerning the product in the current product catalog and in any other materials provided from Parker or its subsidiaries or authorized distributors.

To the extent that Parker or its subsidiaries or authorized distributors provide component or system options based upon data or specifications provided by the user, the user is responsible for determining that such data and specifications are suitable and sufficient for all applications and reasonably foreseeable uses of the components or systems.