



TECHNICAL DATA SHEET

CHEMITAC 11

DESCRIPTION:

Chemitac 11 is a one coat thermoreactive primer for bonding elastomers as NBR, ACM and solid PU with steel, aluminum, aramid, textile fibers and glass by vulcanization process.

The textile fibers can be:

- Cotton, cellulose, polyamide, polyester and aramid.

Chemitac 11 is also used in two coats systems together with an adhesive to bonding NR, SBR, BR, CR, NBR, HNBR, IIR, CIIR, BIIR, CSM y EPDM.

Chemitac 11 is a heavy metals free product.

TYPICAL PHYSICAL CHARACTERISTICS:

Appearance	:	Grey liquid.
Non-volatile solids (1h @ 105°C)	:	26,00%
Specific gravity at 25°C	:	0,945 g/cm ³
Viscosity Brookfield at 25°C	:	150 cps - #2 spindle @ 30 rpm.
Viscosity Ford Cup # 4 at 25°C	:	25 s.
Diluents	:	MEK / MIBK
Bonding Temperature Range	:	130 to 200°C
Shelf life	:	1 year (closed can below 25°C).

CHEMICAL COMPOSITION:

Polymers and fillers stabilized in aromatic and ketone solvents.

HOW TO PREPARE THE SURFACE:

Prepare the metal surface properly by removing completely oil, grease and dirt.

Blasting the surface with grit blasting steel so that the surface roughness is greater than 15 µm.

For aluminum surfaces we recommend the use of aluminum oxide as abrasive.

Clean again the substrate to remove dust from blasting residues.

If specified, the metal part can be phosphatized, galvanized, chromate conversion treated or KTL, before applying adhesive.



HOW TO APPLY CHEMITAC:

Agitation: We recommend stir Chemitac 11 before the application to avoid settle down.

Dilution: Dilution of the product depends on the applications methods.
We recommend that dilution is always made with MEK or MIBK.

Dipping: For this application we recommend diluting between 50 and 100% v/v.

Brushing: For this application we recommend diluting between 20 and 50% v/v.

Spray: For this application we recommend diluting between 50 and 100% v/v.

Application Layer: The film obtained by applying Chemitac 11 is thin and grey. The layer thickness must be between 3 and 8 μm .

Parts with Chemitac 11 already applied can be stored for 30 days before vulcanization if stored in a dust and moisture free condition.

Drying: Dry the film between 10 and 30 minutes at room temperature. If it is necessary to reduce drying time, we recommend to use forced air for 2 minutes at 65°C maximum. Do not use in this stage of process temperatures above 82°C to avoid adhesive pre-cure.

After this process, follow to vulcanization.

If Chemitac 11 is being used as primer, then, it is necessary applying the adhesive over.

TOXICITY:

Breathing vapors for a prolonged period of time is harmful to health.

Use Chemitac 11 only with facial breathing mask, gloves, protection glass and appropriate ventilation.

Continuous contact with the skin may cause irritation.

Adhesive Chemitac 11 may be fatal if swallowed.

If swallowed, do not induce vomiting, but call a physician.

STORAGE:

Keep container tightly closed during storage and always keep away from heat sources. Store in an environment below 10°C increases the shelf life of the adhesive.



PACKING AND STACKING CONDITIONS:

Packing types as well as the recommended maximum amounts for stacking depends on the production place of the product like below:

Place	Can/sample	Bucket 10.0 L	Bucket 30.0 L	Drum 200.0 L
Europe	0,40 Kg / 6 units	8 Kg / 6 units	27 Kg / 3 units	190 Kg / 3 units

Place	Can	Gallon	Bucket 25 L	Drum 200 L
Brasil	0,85 Kg / 6 units	3,5 Kg / 6 units	22 Kg / 3 units	190 Kg / 3 units

SAFETY INFORMATIONS:

Consult the product MSDS for safety information.

ADDITIONAL INFORMATION:

For more information on this and other products, please visit our Website:

www.chemitac.com