

CHEMOSIL 411 Universal Bonding Agent

GENERAL

CHEMOSIL 411 is a very universal, one-coat Bonding Agent.

When a high degree of corrosion and dynamic resistance is required, however, it should be applied in combination with CHEMOSIL 211 primer.

Although even with a one-coat application CHEMOSIL 411 provides good corrosion, oil and solvent resistance, the additional application of CHEMOSIL 411 primer particularly enhances corrosion and temperature resistance.

CHEMOSIL 411 is suitable for bonding of Natural Rubber (NR), Polyisoprene (IR), Polybutadiene (BR), Styrene Butadiene (SBR), Polychloroprene (CR), Nitrile Rubber (NBR), Butyl Rubber (IIR) and Ethylene Propylene Rubber (EPDM) to metals and plastics.

The combination of CHEMOSIL 211 + CHEMOSIL 411 is ideally suited for soft NR and NBR compounds in TM and IM production.

Technical Data

Composition	Polymers and Fillers dispersed in Xylene
Colour	Black-green
Viscosity 4 mm Ford-Cup	60 - 85 s
Specific Gravity	0,960 – 1,020 g/cm ³
Flashpoint	27° C
Solid Content	25 – 29 % by weight
Shelf life	12 months

Application

CHEMOSIL 411 can be applied by spraying dipping or brush. For the recommended coating thickness of approximately 15 microns, the following dilution is recommended:

Brush	Undiluted
Dipping	Undiluted or 20 % dilution with Xylene or Toluene
Spraying	40 – 60 % dilution with Xylene or Toluene

Important

Undiluted CHEMOSIL 411 must be thoroughly prior to application to assure homogeneity.

Diluted product must be stirred continuously to avoid sedimentation (separation).

When dry, CHEMOSIL 411 forms a black film on the metal part, providing excellent corrosion protection.

Metal parts properly primed with CHEMOSIL 211 can be stored for several weeks in a clean environment.

Cautionary Information

Before using this or any CHEMOSIL 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.

All information is based upon laboratory tests and industrial experience, and is intended for use, at their own risk, by persons having technical skill.

We assume no liability in connection with the use of the product described here in. Values stated in this bulletin 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 CHEMOSIL.

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