

# Chemlok® AP-134 Primer

## Description

LORD Chemlok® AP-134 primer is a one-coat, moisture-cure primer used to promote adhesion to a variety of polar substrates. These substrates include architectural and automotive glass, steel, aluminum, brass, e-coated metal, glass fabric, ceramic tile, vitrified clay pipe, concrete and some plastics.

## Features and Benefits

**Versatile** – provides a wide range of product applications by functioning as a primer to a variety of polar substrates and as an adhesive for reaction injection molding (RIM) of polyurethane to glass.

**Easy to Apply** – applies easily by spray, dip or polyester felt applicator.

**Convenient** – requires only a single coat for most applications, reducing labor, solvent usage, inventory and shipping costs.

## Application

**Surface Preparation** – To ensure optimum adhesion to glass, clean the bond surface with a vinegar-modified glass cleaner. For other applications, wipe surface with a suitable solvent.

**Mixing** – No mixing is required before or during use. Dilution is not required.

**Applying** – Apply Chemlok AP-134 primer by spray, dip or polyester felt applicator. For optimum adhesion, the dry film thickness of Chemlok AP-134 primer should be 1.52-2.54 micron (0.06-0.10 mil).

**Drying/Curing** – Allow primer to hydrolyze in moist air (50-80% RH) at 21-32°C (70-90°F) for 1-2 hours. To reduce the hydrolysis time, parts can be cured in an oven at 88°C (190°F) for 3 minutes. Air being drawn into the oven should be 50-80% RH. The cure time can vary depending on the mass of the part being primed. Large parts require more time in an oven to complete cure, due to the heat sink effect of the larger mass.

For best adhesion, apply top coat or encapsulating polymer within 24 hours after primer cures.

## Typical Properties\*

Appearance	Clear, Straw Yellow Liquid
Viscosity, cSt @ 25°C (77°F)	0.0-8.0
Density	
kg/m <sup>3</sup>	863-899
(lb/gal)	(7.2-7.5)
Solids Content by Weight, %	4.8-6.2
Flash Point (Seta), °C (°F)	1 (35)
Solvents	Toluene, n-Butanol, Ethanol

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

# LORD TECHNICAL DATA

**Cleanup** – Use toluene or alcohol to remove wet primer. Remove cured primer by mechanical abrasion, blasting or grinding methods.

## Shelf Life/Storage

Shelf life is one year from date of shipment when stored in a dry, well ventilated area at 21-27°C (70-80°F) in original, unopened container.

After opening, protect primer from moisture contamination. If using a 55-gallon drum, install a desiccant cartridge to dry the air drawn into the drum when drawing off product.

## Cautionary Information

Before using this or any 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.

Values stated in this technical data sheet 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.

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