



Technical Data Sheet

LOCTITE TP 650

Known as EMRALON TP 650

April 2017

PRODUCT DESCRIPTION

LOCTITE TP 650 provides the following product characteristics:

Technology	Solvent based
Product Type	Primer
Application	EPDM and TPV
Features	<ul style="list-style-type: none"> • Supports strong adhesive strength between substrate and coating or adhesive • Usable for multiple substrates • Can provide low friction coatings with enhanced abrasion resistance performance for weather-strip seals • Very low solid content
Benefits	<ul style="list-style-type: none"> • Robustness in durability and performance of applied coating or adhesive • Economic savings by use of one primer for rubber or plastics • Enhances robustness of produced part that results in improved quality • Cost-savings through reduced inventory and dilution extension for non-critical applications
Typical Applications	<ul style="list-style-type: none"> • Priming of EPDM rubber and thermoplastic substrates prior to application of a top coating or an adhesive

LOCTITE TP 650 is a specially formulated liquid primer designed to improve the adhesion of coatings and adhesives onto sponge, moulded or dense EPDM rubber and also on TPV substrates.

It is an easy to apply, ready-to-use primer.

The application of relatively low dry film weights is recommended to promote effective adhesion of topcoats or adhesives onto difficult-to-bond substrates.

LOCTITE TP 650 can be applied as is for achieving enhanced glass chisel abrasion resistance with glass run coatings.

It is also recommended for thermoplastic Elastomers prior to application of a low friction coating or adhesive.

TYPICAL PROPERTIES

Wet	
Solvent	xylene
Solids content	1.5 to 2.5 %
Viscosity	< 15 mPas
Measuring system	Brookfield
Temperature	20 °C
Speed	20 rpm
Flashpoint	26 °C
Density	850 to 890 kg/m ³
Theoretical Coverage	approx. 17 m ² /kg at 1 µm dry coatings thickness
Cured	
Colour	Clear

PRELIMINARY STATEMENT

Prior to application it is necessary to read the Safety Data Sheet for information about precautionary measures and safety recommendations. Also, for chemical products exempt from compulsory labelling, the relevant precautions should always be observed.

METHOD OF USE

Surface Preparation

Surfaces to be coated must be clean, dry and free from dust and grease. Usually an alcohol wipe is sufficient.

Mixing and Dilution

The product is supplied ready-for-use.

Stirring and shaking the material is recommended prior to use to improve uniformity.

Application

The product can be applied by swab or spray application.

It is preferable that only a thin even layer of coating be applied (approx. 1 µm (0.04 mil) dry).

For spray application in small volume production and prototype, a suction cup gun may be used.

In full production a standard spray system designed to apply solvent-based coatings can be used.

LOCTITE TP 650 should be applied as is for applications onto thermoplastic substrates and applications where maximum abrasion resistance is required.

Drying Conditions

Air dry the coated parts for 5 to 10 minutes at room temperature or for 10 seconds at 60 to 80 °C (depending on humidity) before applying the final coating or adhesive.

Drying time for production operations can be decreased by passing coated parts through infrared heat or through batch or conveyor ovens.

When applying to hot substrates, ensure that primer does not boil nor blister.

APPLICATION ASSISTANCE

Henkel's Application Specialists are available to assist you in production start-up with LOCTITE TP 650.

For more information visit our website at <http://www.henkel-adhesives.com/automotive/areas-of-application42518.htm?nodeid=8799631999118> for the Henkel global location nearest you.

STORAGE / HANDLING

Keep container tightly closed when not in use.

Store in a cool (not below 5 °C), well ventilated area.

Keep away from heat, sparks, and open flame.



Protect material from direct sunlight.

Ground and bond containers when transferring materials.

Empty containers may retain hazardous properties.

Follow all MSDS/label warnings even after container is emptied.

Transit and interim storage situations (i.e. receiving) are not encompassed by Henkel's storage requirements. It should be noted however that all efforts should be made to store material as required, as soon as possible. Material removed from containers may be contaminated during use. Do not return product to the original container. Henkel Corporation cannot assume responsibility for product which has been contaminated or stored under conditions other than those previously indicated. If additional information is required, please contact your local Technical Service Center or Customer Service Representative.

Shelf life:

2 years from date of qualification under original seal.

PACKAGING

20 kg

ADDITIONAL INFORMATION

Disclaimer

Note:

The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. The product can have a variety of different applications as well as differing application and working conditions in your environment that are beyond our control. Henkel is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product. Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

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Reference 0.2