

# Chemlok® 608 Adhesive

## Technical Data Sheet

Chemlok® 608 adhesive is a one-coat adhesive designed for bonding unvulcanized silicone elastomers to various rigid substrates.

Chemlok 608 adhesive also provides excellent adhesion to a wide variety of commercially available silicone compounds which require a post cure.

### Features and Benefits:

**Convenient** – requires only a single coat, reducing labor, inventory and shipping costs.

**Versatile** – offers excellent adhesion to a variety of silicone compounds.

**Environmentally Resistant** – provides excellent resistance to many aggressive service environments.

**Economical** – used for most applications at dilutions of 500-1000% with dry alcohol solvents.

### Elastomers:

- Silicone (VMQ, PMQ, PVMQ) - peroxide cure

### 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 Adhesives application guide.

**Mixing** – Chemlok 608 adhesive is best applied as a dilute solution. Specific dilution rates are dependent upon rubber type, substrate and bond performance requirements. Best results have been obtained using methanol in a range from 5-10 parts solvent to 1 part adhesive, by volume.

**Applying** – Apply adhesive in a uniformly thin coat.

**Drying/Curing** – Allow applied adhesive to air-dry for 10-30 minutes at room temperature. Drying time can be shortened by using heat sources to facilitate drying. Temperatures in the range of 65-93°C (150-200°F) for 5-15 minutes may be used for force drying. Maximum air flow at minimum temperature will give the best results.

Coated parts may be bonded immediately after air-drying. For best results, the parts should be coated and bonded in the same day.

A variety of commercially available silicone stocks have been successfully bonded with Chemlok 608 adhesive. Use press-cure times and temperatures recommended by the elastomer manufacturers for each compound.

Silicone-to-metal bonds formed with Chemlok 608 adhesive are resistant to most aggressive environments encountered in end-use service.

### Typical Properties\*

Appearance	Clear to Hazy Yellow Liquid
Density kg/m <sup>3</sup> (lb/gal)	830 - 860 (6.9 - 7.2)
Solids Content by Weight, %	18 - 20
Flash Point (Seta), °C (°F)	3 (38)
Solvents	Methanol, Naptha, Isopropanol, Ethanol

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



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## Shelf Life/Storage:

Shelf life is two years from date of shipment when stored by the recipient at 21-27°C (70-80°F) in original, unopened container.

Tightly close the container when not in use to prevent solvent evaporation and possible moisture contamination. Do not return unused or diluted adhesive to original container. Take care to avoid moisture contamination indicated by a milky white appearance.

## 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.

*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 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.

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Parker LORD  
**Engineered Materials Group**

111 LORD Drive  
Cary, NC 27511-7923  
USA

phone +1 877 ASK LORD (275 5673)

[www.lord.com](http://www.lord.com)