

Chemlok® 6150 Adhesive

Technical Data Sheet

Chemlok® 6150 adhesive is a one-coat adhesive used to bond a variety of elastomers to various metals. It is composed of a mixture of polymers, organic compounds and mineral fillers dissolved or dispersed in an organic solvent system.

Chemlok 6150 adhesive provides strong adhesion and environmental resistance to harsh environments. It is a non-chlorinated solvent adhesive that can be applied as a one- or two-coat system.

Features and Benefits:

Versatile – bonds a wide variety of elastomers to metals, plastics and fabrics; suitable for existing production lines; tolerates a wide variety of stock formulations.

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

Durable – provides rubber tearing bonds; provides superior adhesion to plated metals, lowering scrap rates.

Elastomers:

- Natural Rubber (NR)
- Polyisoprene (IR)
- Styrene-butadiene (SBR)
- Polybutadiene (BR)
- Polychloroprene (CR)
- Nitrile (NBR)
- Butyl (IIR)
- EPDM Polymers
- Polyepichlorohydrin (ECO)

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.

Apply Chemlok 6150 adhesive to stainless steel, aluminum, brass and other nonferrous substrates within one-half hour after cleaning. For ferrous substrates such as steel, a long layover can be tolerated if no rust is formed.

For further detailed information on surface preparation of specific substrates, refer to Chemlok Adhesives application guide.

Mixing – Thoroughly stir adhesive before use, and agitate sufficiently during use to keep dispersed solids uniformly suspended. If needed, proper dilution for the various application methods is best achieved by experience. Give careful attention to agitation since dilution will accelerate settling.

Applying – Apply adhesive by brush, dip, roll coat, spray or any other method that gives a uniform coating and avoids excessive runs and tears.

When using Chemlok 6150 adhesive as a one-coat adhesive, the dry film thickness should be 17.8-30.5 micron (0.7-1.2 mil). When used as a covercoat over a primer, the dry film thickness of Chemlok 6150 adhesive should be 15.2-20.3 micron (0.6-0.8 mil).

Typical Properties*

Appearance	Black Liquid
Viscosity, cps @ 25°C (77°F) Brookfield LVT Spindle 2, 30 rpm	200 - 1000
Density kg/m ³ (lb/gal)	930 - 980 (7.76 - 8.18)
Solids Content by Weight, %	21.0 - 25.0
Flash Point (Seta), °C (°F) Pensky-Martens	28 (82)
Solvents	Xylene

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



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Drying/Curing – Allow the applied adhesive to dry until visual examination of the film has shown that all solvent has evaporated. This will take approximately 20-40 minutes at room temperature. Drying time can be shortened by either preheating the metal inserts or oven drying after application. Metal parts may be preheated to a maximum of 65°C (150°F) prior to adhesive application. For coated parts, moderate drying temperatures should be used, but temperatures as high as 149°C (300°F) may be used for very short periods of time. Maximum air flow at minimum temperatures will give the best results.

Cleanup – Use solvents such as xylene and MEK to remove adhesive before heat is applied. Once cured, removal by solvent is not possible.

Shelf Life/Storage:

Shelf life is one year from date of shipment when stored by the recipient in a well ventilated area at 21-27°C (70-80°F) in original, unopened container. Do not store or use near heat, sparks or open flame. Keep container tightly closed when not in use.

Chemlok 6150 adhesive is moisture sensitive. Minimize exposure of the adhesive to moisture during application and storage. Avoid excessive exposure to high humidity.

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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