

# Chemlok® 6224 Adhesive

## Technical Data Sheet

Chemlok® 6224 adhesive is a high-performing covercoat adhesive that bonds a wide 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 6224 adhesive displays excellent prebake resistance and is highly resistant to boiling water, salt spray, high temperatures and other harsh environments.

### Features and Benefits:

**Versatile** – bonds a variety of elastomers and metals when used in combination with Chemlok 205 Primer.

**Environmentally Resistant** – provides superior resistance to heat, water, salt spray, chemicals, oils, solvents and corrosive atmospheres.

**Prebake Resistant** – coated parts retain adhesion quality even after prebake for 7-10 minutes at 160°C (320°F).

**Easy to Apply** – applies easily by brush, dip, spray, or roll coat methods.

### Elastomers:

- Natural Rubber (NR)
- Polyisoprene (IR)
- Styrene-butadiene (SBR)
- Polychloroprene (CR)
- Nitrile (NBR)

### Application:

**Surface Preparation** – Thoroughly clean metal surfaces prior to adhesive 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.

Allow primer to thoroughly dry before applying Chemlok 6224 adhesive.

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 dilution is needed, use xylene or toluene. Note 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, spray or roll coat methods.

Regardless of application method, the dry film thickness of Chemlok 6224 adhesive should be 12.7-25.4 micron (0.5-1.0 mil). Note optimum film thickness for a particular bonded part is dependent on the rubber formulation and the level of adhesion required.

### Typical Properties\*

Appearance	Black Liquid
Viscosity, cps @ 25°C (77°F) Brookfield LVT Spindle 2, 30 rpm	100 - 300
Density kg/m <sup>3</sup> (lb/gal)	982 - 1006 (8.15 - 8.35)
Solids Content by Weight, %	25.5 - 28.5
Flash Point (Seta), °C (°F)	27 (81)
Solvents	Xylene

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



ENGINEERING YOUR SUCCESS.

**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 45-60 minutes at room temperature. Drying time can be shortened by using hot air drying ovens or tunnels. Moderate drying temperatures of 65-93°C (150-200°F) should be used, but temperatures as high as 149°C (300°F) may be used for very short periods of time. Actual metal temperature should not exceed 82°C (180°F). 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. Remove cured adhesive by mechanical blasting methods.

## 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. Avoid excessive exposure to high humidity. Keep container tightly closed when not in use.

## 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.

Information provided herein is based upon tests believed to be reliable. In as much as Parker LORD has no control over the manner in which others may use this information, it does not guarantee the results to be obtained. In addition, Parker LORD does not guarantee the performance of the product or the results obtained from the use of the product or this information where the product has been repackaged by any third party, including but not limited to any product end-user. Nor does the company make any express or implied warranty of merchantability or fitness for a particular purpose concerning the effects or results of such use.

**WARNING – USER RESPONSIBILITY. FAILURE OR IMPROPER SELECTION OR IMPROPER USE OF THE PRODUCTS DESCRIBED HEREIN OR RELATED ITEMS CAN CAUSE DEATH, PERSONAL INJURY AND PROPERTY DAMAGE.**

This document and other information from Parker-Hannifin Corporation, its subsidiaries and authorized distributors provide product or system options for further investigation by users having technical expertise.

The user, through its own analysis and testing, is solely responsible for making the final selection of the system and components and assuring that all performance, endurance, maintenance, safety and warning requirements of the application are met. The user must analyze all aspects of the application, follow applicable industry standards, and follow the information concerning the product in the current product catalog and in any other materials provided from Parker or its subsidiaries or authorized distributors.

To the extent that Parker or its subsidiaries or authorized distributors provide component or system options based upon data or specifications provided by the user, the user is responsible for determining that such data and specifications are suitable and sufficient for all applications and reasonably foreseeable uses of the components or systems.

©2020 Parker Hannifin - All Rights Reserved

Information and specifications subject to change without notice and without liability therefor. Trademarks used herein are the property of their respective owners.

OD DS4389 02/20 Rev.2



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)