

CHEMLOK® 236X ADHESIVE

Technical Data Sheet

Chemlok® 236X adhesive is a covercoat adhesive that bonds a variety of uncured elastomers to primed metal parts. It is composed of a mixture of polymers, organic compounds and mineral fillers dissolved or dispersed in an organic solvent system.

Chemlok 236X adhesive is recommended for use over Chemlok 205 primer.

Features and Benefits

Non-Chlorinated Solvent System: suitable for solvent incineration, saving cost of recovery equipment.

Easy to Apply: demonstrates improved spray characteristics at lower levels of dilution compared to other chlorinated solvent products.

Elastomers

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

Application

Surface Preparation: Thoroughly clean metal surfaces prior to primer 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 236X 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 toluene or xylene. 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 or spray methods.

Regardless of application method, the dry film thickness of Chemlok 236X adhesive should be 12.7-25.4 micron (0.5-1.0 mil).

Typical Properties*

Appearance	Black Liquid
Viscosity, cps @ 25°C (77°F) Brookfield LVT Spindle 2, 30 rpm	125 - 500
Density kg/m ³ (lb/gal)	910.7 - 946.6 (7.6 - 7.9)
Solids Content by Weight, %	15 - 19
Flash Point (Seta), °C (°F)	30 (86)
Solvents	Xylene

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

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 30-60 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.

Shelf Life/Storage

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

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.

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