CHEMLOK® 238 ID ADHESIVE

Technical Data Sheet

Chemlok® 238 ID adhesive is a covercoat adhesive used to bond a variety of non-polar elastomers to themselves or to Chemlok 205 primed metals and other rigid substrates. It is composed of a mixture of polymers, organic compounds and mineral fillers dissolved or dispersed in an organic solvent system.

Features and Benefits

Versatile: bonds non-polar rubber compounds based on butyl and EPDM; flexible enough to bond uncured to cured systems, as well as cured elastomers to cured elastomers with similiar compositions.

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

Elastomers

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

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.

If applicable, allow primer to thoroughly dry before applying Chemlok 238 ID adhesive.

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

Mixing: Special attention should be given to mixing the adhesive. Agitation methods and times will vary depending on container size and time in inventory. To ensure a homogenous mix and uniform appearance, refer to Chemlok Adhesives application guide for recommended mixing procedures.

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 any method that gives a uniform coating and avoids excessive runs or tears.

Regardless of application method, the dry film thickness of Chemlok 238 ID adhesive should be 10.2-25.4 micron (0.4-1.0 mil). For bonding cured rubber, dry film thickness of 25.4-38.1 micron (1.0-1.5 mil) is normally used.

Typical Properties*

Appearance	Black Liquid
Viscosity, cps @ 25°C (77°F) Brookfield LVT Spindle 2, 30 rpm	200 - 800
Density kg/m^3 (lb/gal)	 898.7 - 946.6 (7.5 - 7.9)
Solids Content by Weight, %	16.5 - 19.0
Flash Point (Seta), °C (°F)	26 (79)
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 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 in a well ventilated area 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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