

CHEMLOK® 259 ADHESIVE

Technical Data Sheet

Chemlok® 259 adhesive is a covercoat adhesive that bonds uncured rubber to metal substrates during the vulcanization of the elastomer. It is recommended for use over Chemlok 207 primer.

Features and Benefits

Versatile: when used in combination with Chemlok 207 primer, bonds a variety of elastomers to a variety of substrates including aluminum, brass and grit blasted or phosphatized steel.

Chemically Resistant: resists a variety of fluids including ethylene glycol, propylene glycol and silicone oil.

Environmentally Resistant: provides excellent resistance to water, humidity, salt spray and high temperatures.

Elastomers

- Natural Rubber (NR)
- Polychloroprene (CR)
- Polyisoprene (IR)
- Nitrile (NBR)
- Styrene-butadiene (SBR)
- Butyl (IIR)
- Polybutadiene (BR)
- EPDM Polymers
- Chlorinated Polyethylene (CPE)
- 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 259 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 or spray methods.

Regardless of application method, the dry film thickness of Chemlok 259 adhesive should be 10.2-20.3 micron (0.4-0.8 mil).

Curing: Chemlok 259 adhesive cures during the rubber vulcanization process.

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

Typical Properties*

| | |
|---|-------------------------------|
| Appearance | Green-Black Liquid |
| Viscosity, cps @ 25°C (77°F) Brookfield LVT Spindle 2, 30 rpm | 100 - 500 |
| Density kg/m ³ (lb/gal) | 982.6 - 1018.5 (8.2 - 8.5) |
| Solids Content by Weight, % | 25 - 29 |
| Flash Point (Seta), °C (°F) | 6.6 (44) |
| Solvents | Toluene, Xylene |

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

Shelf Life/Storage

Shelf life is six months 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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