

# Chemlok® 5151 Adhesive

## Technical Data Sheet

Chemlok® 5151 one-coat adhesive is used to bond uncured fluoroelastomers to metal. It can also be used to bond fluoroelastomers to phosphatized metals.

### Features and Benefits:

**Excellent Appearance** – provides good cosmetics; non-pigmented.

**Versatile** – bonds a wide variety of fluoroelastomers; bonds bisphenol or peroxide-curing elastomers; accommodates a wide variety of postcures.

**Easy to Apply** – low viscosity allows for easy application.

**Fluid Resistant** – provides excellent resistance to immersion in ASTM Oils #1 and #3.

### Elastomers:

- Fluoroelastomer (FKM)
- Viton®
- Polyacrylate (ACM)
- Epichlorohydrin (ECH)

### 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.

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

**Mixing** – No agitation is required before or during use. If dilution is needed, a dilution of 2-3 parts MEK to 1 part adhesive will provide excellent primary adhesion and environmental resistance.

**Applying** – Apply adhesive by brush, dip or spray methods. Dip application is preferred to maintain precise control over adhesive thickness.

**Drying/Curing** – Allow adhesive to air-dry, maintaining forced air drying temperatures below 93°C (200°F).

Chemlok 5151 adhesive cures at 165-188°C (330-370°F). Post cures of 12-24 hours at 204-232°C (400-450°F) can be used. For exceptionally thick parts, use a step postcure beginning at 149°C (300°F), and increase the temperature in 10°C (50°F) increments at two hour intervals until a temperature of 204-232°C (400-450°F) is achieved.

**Cleanup** – Use alcohol or MEK for clean up.

### Typical Properties\*

Appearance	Reddish-yellow Liquid
Viscosity, seconds Zahn Cup #1	25 - 30
Density kg/m <sup>3</sup> (lb/gal)	814.8 - 862.7 (6.8 - 7.2)
Solids Content by Weight, %	11 - 16
Flash Point (Seta), °C (°F)	-5 (+22)
Solvents	MEK

\*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 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.

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