Chemlok® 6016 Adhesive

Technical Data Sheet

Chemlok® 6016 adhesive is a general purpose adhesive used to bond a 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 6016 adhesive is a non-chlorinated solvent adhesive that can be applied as a one- or two-coat system depending on environmental conditions.

Features and Benefits:

Versatile – bonds a variety of elastomers; can be used as a covercoat adhesive over Chemlok 205 or 207 primer for maximum protection or when environmental conditions are severe.

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

Excellent Appearance – provides continuous film appearance.

Easy to Apply – provides slow evaporation rate suitable for spray applications.

Elastomers:

- Natural Rubber (NR)
- Polyisoprene (IR)
- Styrene-butadiene (SBR)
- Polybutadiene (BR)
- 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.

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 spray, brush or dip methods.

When using Chemlok 6016 adhesive as a one-coat adhesive, the dry film thickness should be 17.8-25.4 micron (0.7-1.0 mil) for optimum adhesion. When used as a covercoat over a primer, the dry film thickness of Chemlok 6016 adhesive should be 15.2-20.3 micron (0.6-0.8 mil).

Curing – Chemlok 6016 adhesive cures during the rubber vulcanization process.

Cleanup – Use solvents such as xylene and MEK to remove adhesive before heat is applied. Remove cured adhesive by mechanical blasting methods.

Typical Properties*	
Appearance	Black Liquid
Viscosity, seconds Zahn Cup #3	35-100
Density kg/m^3 (lb/gal)	 960-1010 (8.0-8.4)
Solids Content by Weight, %	24.5-27.5
Flash Point (Seta), °C (°F)	27 (81)
Solvents	Xylene

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

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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