

Chemlok® 234X (NW) Adhesive

Technical Data Sheet

Chemlok® 234X (NW) adhesive is a general purpose covercoat adhesive designed for use over Chemlok 205 primer to bond a wide variety of vulcanized or unvulcanized rubber compounds to metal or 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:

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

Versatile – when used in combination with Chemlok 205 primer, bonds a variety of cured and uncured elastomer compounds; flexible enough to bond uncured to cured systems, as well as cured elastomers to cured elastomers with similar compositions.

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

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 234X (NW) 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.

Typical Properties*

Appearance	Black Liquid
Viscosity cps @ 25°C (77°F) Brookfield LVT Spindle 2, 30 rpm	400 - 1000
seconds Zahn Cup #4	35 - 70
Density kg/m ³ (lb/gal)	887.51 - 947.48 (7.40 - 7.90)
Solids Content by Weight, %	16.5 - 19.5
Flash Point (Seta), °C (°F)	30 (86)
Solvents	Xylene

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

Applying – Apply adhesive by brush, dip, roll coat or spray methods.

Regardless of application method, the dry film thickness of Chemlok 234X (NW) adhesive should be 12.7-25.4 micron (0.5-1.0 mil). For bonding cured rubber, dry film thickness of 20.3-38.1 micron (0.8-1.5 mil) is normally used.

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 times may 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.

Post-Vulcanization Bonding – PV bonds are obtained when bondline temperature reaches 149-177°C (300-350°F) for 20-40 minutes. Maintain 5-10% compression of the vulcanized rubber section during cure and cool down to ensure intimate contact at the rubber/metal interface. Assembly lubricants may be necessary depending on the molded assembly configuration. Naphthenic assembly oils can be used if assembly without lubrication is not possible.

Cleanup – Use xylene for clean up.

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. Do not store or use near heat, sparks or open flame.

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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