

CHEMLOK® 6125 ADHESIVE

Technical Data Sheet

Chemlok® 6125 adhesive is a covercoat adhesive that bonds a wide 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 6125 adhesive provides improved heat resistance while offering excellent resistance to water, salt spray, chemicals, oils, solvents and corrosive atmospheres.

Features and Benefits

Versatile: bonds a variety of elastomers and metals when used in combination with Chemlok 205 primer. Use of Chemlok 205 primer helps to ensure environmental resistance of the bonded assembly and adhesion to the substrate.

Excellent Appearance: provides a continuous film appearance.

Elastomers

- Natural Rubber (NR)
- Polyisoprene (IR)
- Styrene-butadiene (SBR)
- Polychloroprene (CR)
- Nitrile (NBR)

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 6125 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. Agitation methods and times will vary depending on container size and time in inventory. To ensure a homogeneous 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	70 - 200
seconds Zahn Cup #2	41
Density kg/m ³ (lb/gal)	970.0 - 1010.0 (8.1 - 8.4)
Solids Content by Weight, %	23 - 27
Flash Point (Seta), °C (°F)	27 (81)
Solvents	Xylene

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

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

Regardless of application method, the dry film thickness of Chemlok 6125 adhesive should be 12.7-25.4 micron (0.5-1.0 mil).

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 60°C (140°F) prior to adhesive application. For coated parts, moderate drying temperatures should be used, but temperatures as high as 93°C (200°F) may be used for very short periods of time. Maximum air flow at minimum temperatures will give the best results.

Cleanup: Use xylene to remove wet or dry adhesive. Remove cured adhesive by mechanical blasting methods.

Shelf Life/Storage

Shelf life is one year from date of shipment when stored by the recipient 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.

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