

CHEMLOK® EP6897-61 ADHESIVE

Technical Data Sheet

Chemlok® EP6897-61 adhesive is a one-coat adhesive used to bond castable and RIM urethane elastomers to metal. It is composed of a mixture of polymers and curatives dissolved in an organic solvent system.

Chemlok EP6897-61 adhesive provides bond strengths greater than the tear strength of the urethane substrate. It also works on polyether and polyester castable urethanes of varying hardness, based on both TDI and MDI.

Features and Benefits

Versatile: bonds metal to a wide variety of polyether and polyester compounds, including RIM urethane.

Convenient: requires only a single coat for most applications, minimizing application costs.

Fast Drying: dries fast to allow rapid turnaround times, reducing the number of coated parts kept in inventory.

Excellent Appearance: provides good cosmetics; does not interfere with aesthetics of finished part.

Economical: eliminates the need to inventory several products due to the adhesive's versatility.

Elastomers

- Castable Urethane
- RIM Urethane
- Millable Urethane
- Thermoplastic Urethane (TPU)

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, mix Chemlok EP6897-61 adhesive, at a 1:1 ratio by volume, with a 1:1 blend of xylene and MEK.

Applying: Apply adhesive by brush, dip or spray methods. To avoid film bubbling, do not apply Chemlok EP6897-61 adhesive to substrates hotter than 82°C (180°F).

Regardless of application method, dry film thickness of Chemlok EP6897-61 adhesive should be 19.05-31.75 micron (0.75-1.25 mil).

Typical Properties*

Appearance	Clear, Slightly Yellow Liquid
Viscosity cps @ 25°C (77°F) Brookfield LVT Spindle 2, 30 rpm	100 - 300
seconds Zahn Cup #3	20 - 40
Density kg/m ³ (lb/gal)	886.7 - 910.7 (7.4 - 7.6)
Solids Content by Weight, %	20.5 - 23.5
Flash Point (Seta), °C (°F)	5 (41)
Solvents	MEK, Xylene, Dowanol® BC300

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

Drying/Curing: Allow coated parts to air-dry for 30-60 minutes at room temperature. Drying times can be shortened by air drying for 15 minutes at room temperature followed by oven drying for 15 minutes at 65°C (150°F).

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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