

Chemlok® EP5809-34 Adhesive

Technical Data Sheet

Chemlok® EP5809-34 adhesive is a one-coat adhesive that bonds thermoplastic urethane to metal. Chemlok EP5809-34 adhesive may also be used in bonding castable and/or millable urethane to metal.

Features and Benefits:

Convenient – requires only a single coat for most applications, reducing labor, inventory and shipping costs.

Easy to Use – ready to use directly out of container without dilution.

Excellent Appearance – dries to a clear and colorless coating; requires no dyes to be added.

Low Viscosity – requires no agitation; allows for easy application by spray, dip, wipe or brush methods.

Elastomers:

- Castable 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.

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

Drying/Curing – Allow coated parts to dry in moist air (50%-80% RH) for one hour prior to molding. Prebaking is generally not required but may assist in attaining the highest levels of resistance to in-service conditions. Prebake of 30 minutes at 121°C (250°F) is suggested.

Cleanup – Use mechanical methods to clean up adhesive.

Shelf Life/Storage:

Shelf life is six months from date of shipment when stored by the recipient in a dry, well ventilated area at 21-27°C (70-80°F) in original, unopened container.

After opening, protect adhesive from moisture contamination by installing a desiccant cartridge.

Typical Properties*

Appearance	Clear Liquid
Viscosity, cps @ 20°C (68°F)	3 - 7
Density kg/m ³ (lb/gal)	745 - 821 (6.55 - 6.85)
Solids Content by Weight, %	8.5 - 11.5
Flash Point (Seta), °C (°F)	21 (70)
Solvents	IPA

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

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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