

# Chemlok® 6250 Adhesive

## Technical Data Sheet

Chemlok® 6250 adhesive is a one-coat adhesive used to bond a variety of elastomers to various substrates. It is composed of a mixture of polymers, organic compounds and mineral fillers dissolved or dispersed in an organic solvent system.

Chemlok 6250 adhesive is a non-chlorinated solvent adhesive that provides strong adhesion to a wide variety of materials, including glass and fabric.

### Features and Benefits:

**Versatile** – bonds a wide variety of elastomer compounds to metals, plastics, glass and fabrics; 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.

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

### Elastomers:

- Natural Rubber (NR)
- Polyisoprene (IR)
- Styrene-butadiene (SBR)
- Polybutadiene (BR)
- Polychloroprene (CR)
- Nitrile (NBR)
- Chlorinated Polyethylene (CPE)
- Chlorosulfonated Polyethylene (CSM)
- Butyl (IIR)
- EPDM Polymers
- Polyepichlorohydrin (ECO)
- Polyacrylate (ACM)
- Ethylene Acrylic (AEM)
- Hytrel TPE only

### 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 needed, 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	100 - 550
Density kg/m <sup>3</sup> (lb/gal)	928.7 - 976.6 (7.75 - 8.15)
Solids Content by Weight, %	22 - 26
Flash Point (Seta), °C (°F)	27 (81)
Solvents	Xylene

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



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**Applying** – Apply adhesive by brush, dip, spray or any other method that gives a uniform coating and avoids excessive runs and tears.

When using Chemlok 6250 adhesive as a one-coat adhesive, the dry film thickness should be 20.3-30.5 micron (0.8-1.2 mil). When used as a covercoat over a primer, the dry film thickness of Chemlok 6250 adhesive should be 15.2-20.3 micron (0.6-0.8 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 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.

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

## Shelf Life/Storage:

Shelf life is six months 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.

Chemlok 6250 adhesive is moisture sensitive. Minimize exposure to moisture during application and storage.

## 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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