Chemlok® 6258 Adhesive

Technical Data Sheet

Chemlok® 6258 adhesive is a high-performing adhesive that bonds rubber compounds to metal. It is proven in applications that require a combination of strong adhesion with high fatigue resistance and high tensile strength.

Chemlok 6258 adhesive provides excellent corrosion resistance when used with mechanically or chemically treated cold rolled steel or aluminum.

Features and Benefits:

Versatile – bonds a variety of elastomers; can be used as a covercoat adhesive over Chemlok 205 or 207 primer for maximum protection or when environmental conditions are severe.

Convenient – requires only a single coat for most applications, reducing labor, solvent usage, inventory and shipping costs; contains high solvent content for roller coat applications.

Process Compatible – provides excellent resistance to sweeping, ideal for transfer or injection molding operations.

Environmentally Resistant – provides excellent resistance to water, humidity, salt spray and high temperatures.

Elastomers:

- Natural Rubber (NR)
- Polyisoprene (IR)
- Styrene-butadiene (SBR)
- Polybutadiene (BR)
- Polychloroprene (CR)
- Nitrile (NBR)
- EPDM Polymers

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 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.

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

When using Chemlok 6258 adhesive as a one-coat adhesive, the dry film thickness should be 17.8-25.4 micron (0.7-1.0 mil) for optimum adhesion. When used as a covercoat over a primer, the dry film thickness of Chemlok 6258 adhesive should be 12.7-25.4 micron (0.5-1.0 mil).

Curing – Chemlok 6258 adhesive cures during the rubber vulcanization process.

Cleanup – Use xylene, toluene or ketones for clean up.

Typical Properties*	
Appearance	Black Liquid
Viscosity, seconds Zahn Cup #3	25 - 45
Density kg/m^3 (lb/gal)	 970.6 - 1006.5 (8.1 - 8.4)
Solids Content by Weight, %	24.5 - 28
Flash Point (Seta), °C (°F)	5 (41)
Solvents	Xylene, Toluene

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

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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Parker LORD
Engineered Materials Group

111 LORD Drive
Cary, NC 27511-7923
USA

phone +1 877 ASK LORD (275 5673)

www.lord.com