

Chemlok® 217 Adhesive

Technical Data Sheet

Chemlok® 217 adhesive is a one-coat adhesive used to bond nitrile or neoprene elastomers to metals or other substrates during vulcanization of the elastomer. The adhesive provides ample processing latitude and readily adapts to conventional application and molding methods.

For maximum protection or when environmental conditions are extremely aggressive, Chemlok 217 adhesive can be used over Chemlok 205 primer.

Features and Benefits:

Heat and Environmentally Resistant – provides excellent heat and environmental resistance.

Fast Drying – dries quickly to a hard coating.

Versatile – bonds under a variety of production conditions.

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

Easy to Apply – applies easily by spray, dip or brush methods.

Elastomers:

- Nitrile (NBR)
- Polychloroprene (CR)
- Polyacrylate (ACM)

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 using, and agitate sufficiently during use to keep dispersed solids uniformly suspended. If dilution is needed, use a solvent mix ratio of 2 parts MEK and 1 part xylene. Drying time can be increased by adding greater amounts of xylene; drying time can be decreased by adding lesser amounts of xylene.

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

Regardless of application methods, the dry film thickness of Chemlok 217 adhesive should be 2.5-10.2 micron (0.1-0.4 mil).

Drying/Curing – Allow adhesive to dry at room temperature or elevated temperatures until visual examination of the film has shown that all solvent has evaporated.

Cleanup – Use solvents such as MEK and xylene to remove adhesive before heat is applied. Remove cured adhesive by grit blasting, grinding or belt sanding.

Typical Properties*

Appearance	Black Liquid
Viscosity, cps @ 25°C (77°F) Brookfield LVT Spindle 2, 30 rpm	75 - 150
Density kg/m ³ (lb/gal)	922.7 - 958.6 (7.7 - 8.0)
Solids Content by Weight, %	23 - 27
Flash Point (Seta), °C (°F)	-2 (+28)
Solvents	MEK, Xylene

*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 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.

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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Parker Lord
Engineered Materials Group

111 LORD Drive
Cary, NC 27511-7923
USA

phone +1 877 275 5673

www.Parker.com/EPM