

# Chemlok® 6100 Adhesive

## Technical Data Sheet

Chemlok® 6100 adhesive is a covercoat adhesive that bonds a variety of elastomers to various metals. It is composed of a mixture of polymers, organic compounds and mineral fillers dissolved or dispersed in an organic solvent system.

Chemlok 6100 adhesive provides excellent adhesion to mechanically or chemically treated cold rolled steel or aluminum and is highly resistant to salt spray.

### Features and Benefits:

**Versatile** – bonds a variety of elastomers and metals when used in combination with Chemlok 205 or 207 primer.

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

**Excellent Appearance** – provides a continuous film appearance.

**Process Compatible** – resists sweeping; accommodates a wide range of processing conditions including extended prebake.

**Environmentally Resistant** – provides excellent resistance to salt spray.

**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)
- Chlorinated Polyethylene (CPE)
- Chlorosulfonated Polyethylene (CSM)
- Hytrel TPE only
- Polychloroprene (CR)
- Nitrile (NBR)
- Butyl (IIR)
- EPDM Polymers

### Application:

**Surface Preparation** – Thoroughly clean metal surfaces prior to primer 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.

Allow primer to thoroughly dry before applying Chemlok 6100 adhesive.

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.

### Typical Properties\*

Appearance	Black Liquid
Viscosity, cps @ 25°C (77°F) Brookfield LVT Spindle 2, 30 rpm	350 - 750
Density kg/m <sup>3</sup> (lb/gal)	940 - 980 (7.8 - 8.2)
Solids Content by Weight, %	21 - 24
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.

Regardless of application method, the dry film thickness of Chemlok 6100 adhesive should be 12.7-25.4 micron (0.5-1.0 mil).

**Curing** – Chemlok 6100 adhesive cures during the rubber vulcanization process.

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

## 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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