

Chemlok® 6108 Adhesive

Technical Data Sheet

Chemlok® 6108 adhesive is a covercoat adhesive used to bond 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 6108 adhesive is a non-chlorinated solvent adhesive that provides strong resistance to harsh environments. In some applications, it may be used as a one-coat adhesive.

Features and Benefits:

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

Non-Chlorinated Solvent System – suitable for solvent incineration.

Environmentally Resistant – provides superior resistance to heat, oils and salt spray.

Elastomers:

- Natural Rubber (NR)
- Polyisoprene (IR)
- Styrene-butadiene (SBR)
- Polybutadiene (BR)
- Chlorinated Polyethylene (CPE)
- Chlorosulfonated Polyethylene (CSM)
- 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 6108 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.

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

Regardless of application method, the dry film thickness of Chemlok 6108 adhesive should be 17.8-25.4 micron (0.7-1.0 mil).

Curing – Chemlok 6108 adhesive cures during the rubber vulcanization process.

Cleanup – Use solvents such as xylene and MEK to remove adhesive before heat is applied. Once cured, removal by solvent is not possible.

Typical Properties*

Appearance	Black Liquid
Viscosity, cps @ 25°C (77°F) Brookfield LVT Spindle 2, 30 rpm	300 -1000
Density kg/m ³ (lb/gal)	950 -1000 (7.9 -8.3)
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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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.

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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