Chemlok® 6958 Adhesive

Technical Data Sheet

Chemlok® 6958 adhesive is a high-performing adhesive that bonds rubber compounds to metal. It is composed of a mixture of polymers, organic compounds and mineral fillers dissolved or dispersed in an organic solvent system.

Chemlok 6958 adhesive is recommended for use over Chemlok 299 primer. In some applications, it may be used without a primer.

Features and Benefits:

Excellent Adhesion – adheres well to properly prepared metals, such as cold rolled steel and aluminum.

Temperature Resistant – provides exceptional resistance to high heat applications and environments.

Fluid Resistant – provides excellent resistance to hot solutions of water and ethylene glycol or propylene glycol.

Corrosion Resistant – provides excellent corrosion resistance when used with properly prepared metals.

Elastomers:

- Natural Rubber (NR)
- Polyisoprene (IR)
- Styrene-butadiene (SBR)
- Polybutadiene (BR)
- Polychloroprene (CR)

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 6958 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 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 or spray methods.

Regardless of application method, the dry film thickness of Chemlok 6958 adhesive should be 12.7-25.4 micron (0.5-1.0 mil). If adhesive is used without a primer, dry film thickness must be at least 23 micron (0.9 mil).

Drying/Curing – Thoroughly dry coated parts prior to bonding assemblies. Chemlok 6958 adhesive cures during the rubber vulcanization process.

Cleanup – Use xylene to remove wet or dry adhesive. Remove cured adhesive by mechanical blasting methods.

Typical Properties*	
Appearance	Black Liquid
Viscosity, cps @ 25°C (77°F) Brookfield LVT Spindle 2, 30 rpm	30 - 500
Density kg/m^3 (lb/gal)	 910 - 960 (7.6 - 8.0)
Solids Content by Weight, %	20 - 24
Flash Point (Seta), °C (°F)	-9 (51)
Solvents	Methyl Ethyl Ketone (MEK), Toluene, Solvent Naphtha

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

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. Do not store or use near heat, sparks or open flame. Avoid excessive exposure to high humidity. Keep container tightly closed when not in use.

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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