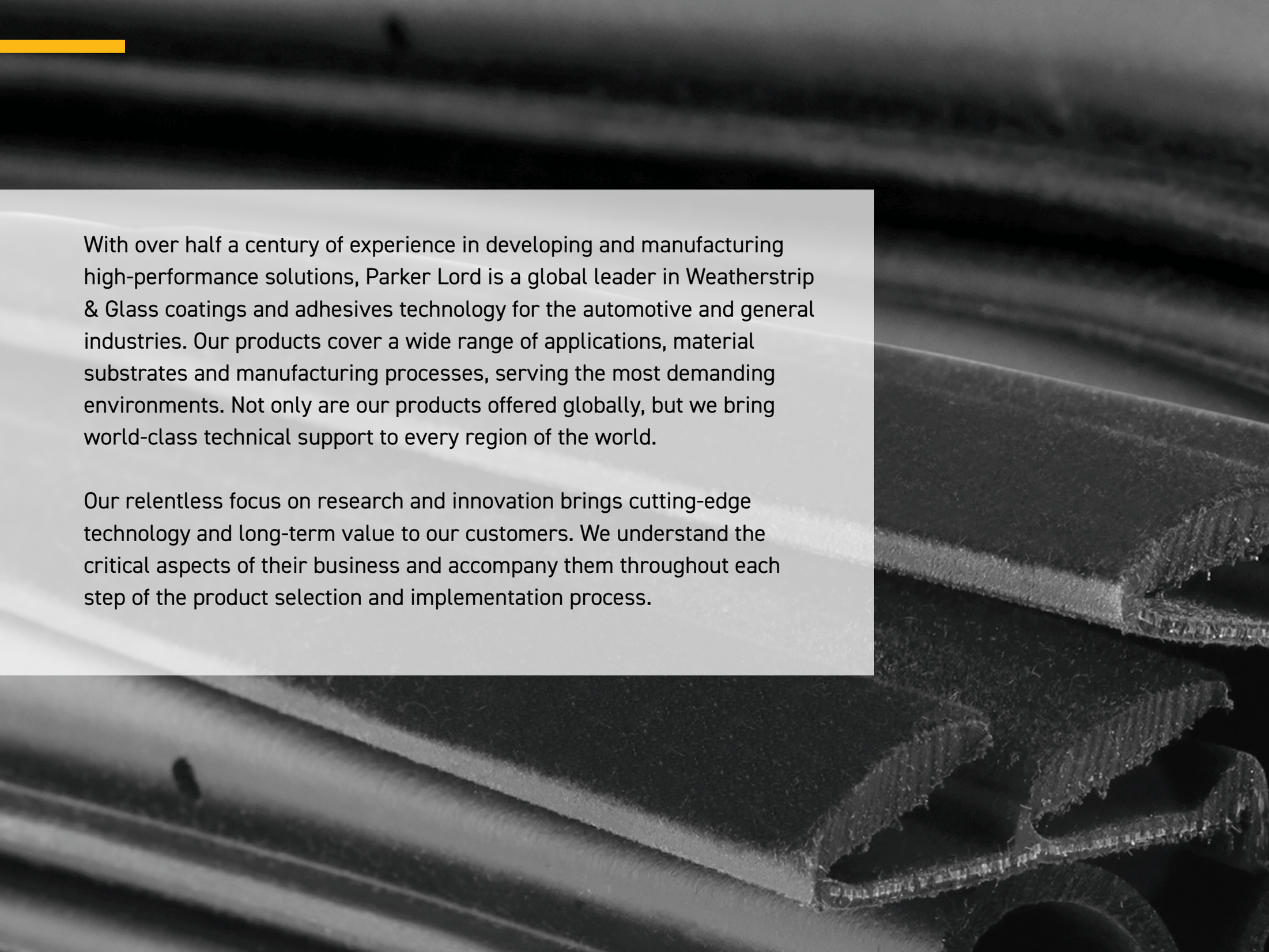
WEATHERSTRIP & GLASS COATINGS AND ADHESIVES

Selector Guide

US & Canada

Parker | Lord



With over half a century of experience in developing and manufacturing high-performance solutions, Parker Lord is a global leader in Weatherstrip & Glass coatings and adhesives technology for the automotive and general industries. Our products cover a wide range of applications, material substrates and manufacturing processes, serving the most demanding environments. Not only are our products offered globally, but we bring world-class technical support to every region of the world.

Our relentless focus on research and innovation brings cutting-edge technology and long-term value to our customers. We understand the critical aspects of their business and accompany them throughout each step of the product selection and implementation process.

SIPIOL® WEATHERSTRIP COATINGS

Sipiol® weatherstrip coatings significantly improve the performance and lifetime of automotive sealings on passenger and commercial vehicles. We collaborate with our customers and partners to develop coatings that meet the demanding specifications of the automotive industry.

Our coating solutions are designed to offer excellent noise reduction performance and increased passenger comfort. They are particularly suited for applications on electric vehicles. These coatings provide abrasion resistance and are formulated to withstand the harshest environments including extreme temperatures, UV rays, water, ice and cleaning chemicals. Our products are mostly water-based and do not contain any toxic classified substances, meeting the industry's increased demand for sustainable solutions.

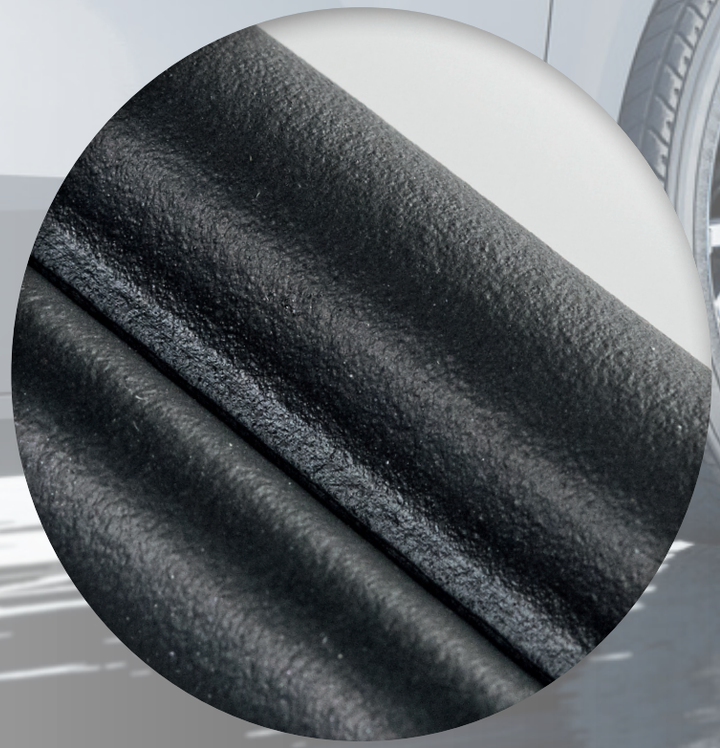
Sipiol weatherstrip coatings are approved by the leading global car manufacturers. See full product listing for primers, cross-linkers, thickeners and setting aides.

Features & Benefits

- Excellent noise reduction
- High abrasion resistance
- High resistance to UV exposure
- One-component and two-component systems
- Water-based systems
- Spray and brush application
- Coatings can be over-painted

Primers

- Solvent- and water-based systems
- Suitable for a variety of elastomers
- Different activation temperatures
- Spray and brush application



APPLICATION	SMOOTH COATINGS	PARTICULATED COATINGS
PRIMARY DOOR SEALING, TRUNK-BONNET, HOOD SEALING	WL 1120-21 (1K), WL 1120-23 (1K), WL 2010-23 (2K), Autoseal RC-3007S (2K)	
SECONDARY DOOR SEALING, FRAMELESS DOORS, CONVERTIBLES	WL 2010-24 (2K)	WL 2015-22P (2K), WL 1025-21 (1K), WL 1026-21 (1K)
GLASS RUN CHANNELS		WL 2015-22P (2K), WL 1025-21 (1K), WL 1026-21 (1K)
SUN ROOFS	WL 2010-24 (2K)	WL 1026-21 (1K), WL 1025-21 (1K)

1K 2K

See Selector Guide insert for technical data.

FLOCKLOK® & FLOCKSIL® FLOCK ADHESIVES

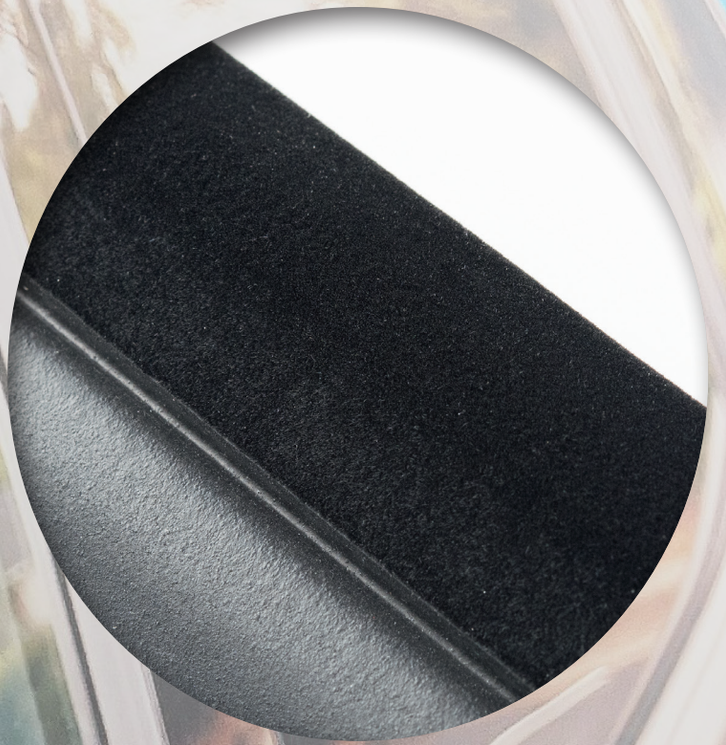
Flocklok® and Flocksil® flock adhesives are designed to adhere polyester or nylon flock fibers to a variety of elastomers (including EPDM, NR, CR, SBR) and thermoplastic elastomers (TPE). The flocked elastomer forms an insulating weather seal around windows, protecting passenger cars and commercial vehicles from dust and dirt entering the cabin. Our flock adhesives provide excellent durability, abrasion resistance and adhesion. They protect the rubber sealing from wear, facilitate glass sliding and contribute to noise reduction and increased passenger comfort.

Features & Benefits

- One-component and two-component systems
- Different solvent compositions and curing times
- Excellent adhesion to a variety of substrates and types of flock
- Process compatibility – can be applied online and offline

Catalysts

- Customizable to specific customer processes
- High efficiency
- DTBL-free versions available



COLOR	SUBSTRATES		
	EPDM, NR, CR, SBR	TPE	PVC, ALCRYIN (MPR), NYLON, ABS
BROWN	Flocklok 852F Flocklok 853A Flocksil 1501 SF		
BLACK	Flocksil 1503 EA Flocksil 1506 G1	Flocksil 1506 G1	
CLEAR OR YELLOW		Autoseal RC-3902H	Flocklok 7000/7204

1K 2K

See Selector Guide insert for technical data.

CHEMLOK® GLASS ENCAPSULATION ADHESIVES

Chemlok® glass encapsulation adhesives are designed for the production of automotive windshields, side windows (modular windows) and rear windows. They form a strong bond between the polymer and the window glass during the encapsulation process. We recommend different adhesive systems to bond the glass, depending on the polymer used.

Features & Benefits

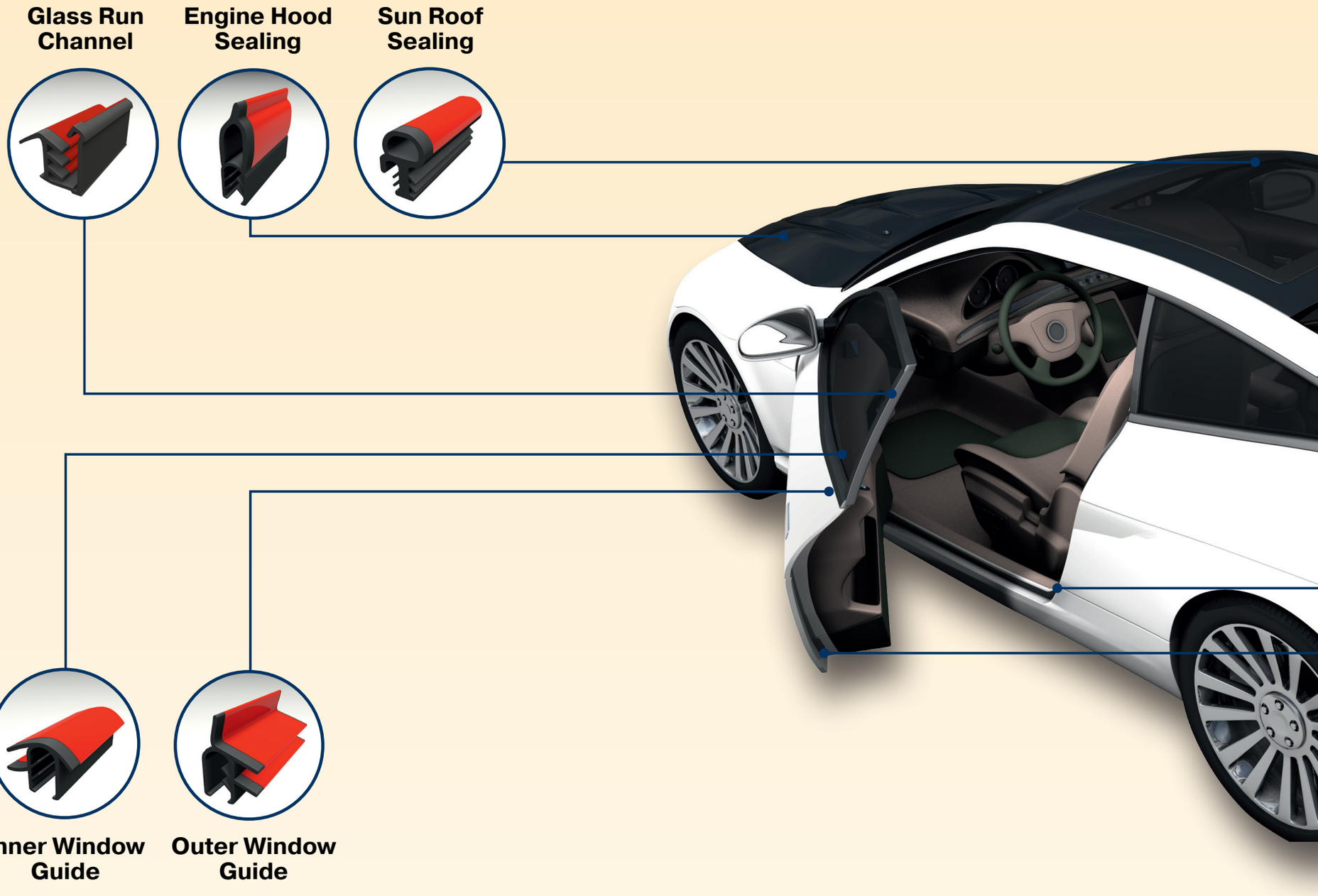
- Product solutions for all common polymers (PVC, RIM PU, TPE, EPDM)
- Long history of proven product performance
- Easy application
- Integrated UV tracers
- Selection of available primers

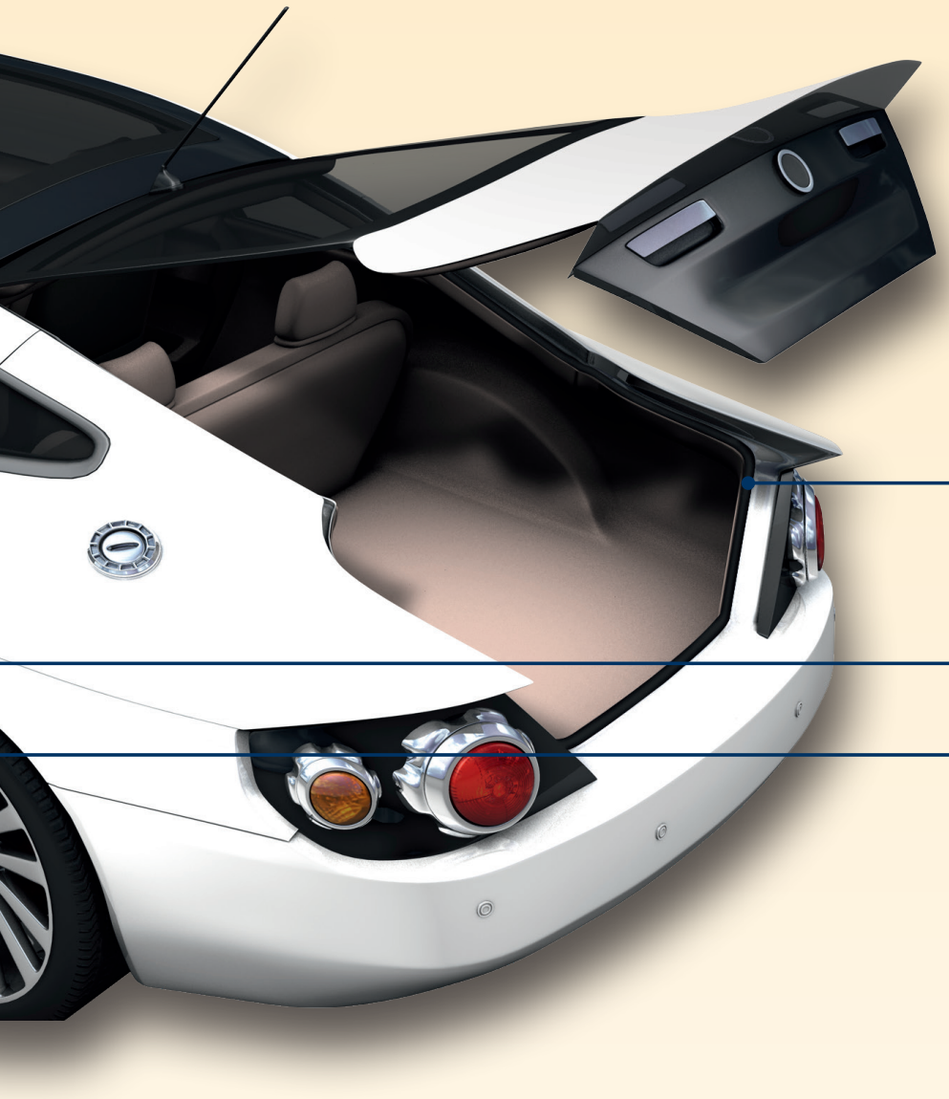
INJECTED POLYMER	GLASS, METAL AND PLASTICS ONLY	STEEL, ALUMINUM, E-COATED METAL, GLASS, FABRIC, ARCHITECTURAL AND AUTOMOTIVE GLASS, CONCRETE AND SOME PLASTICS
PVC	489/456	
TPE	144 (Primer), 487 A/B (Adhesive)	144 (Primer), 487 A/B (Adhesive)
SILICONE RUBBER, FKM, PA, PET	AP-133	AP-133
RIM-PU	AP-134 (Primer), 144 (Primer)	AP-134 (Primer), 144 (Primer)
EPDM	144 (Primer), 6150 (Adhesive), 8560S-1 (Adhesive)	

● Primer ○ Adhesive

See Selector Guide insert for technical data.

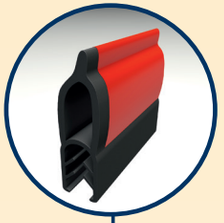
AUTOMOTIVE WEATHERSTRIP APPLICATIONS





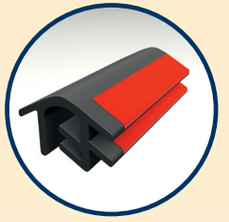
For Convertibles :

Trunk Sealing

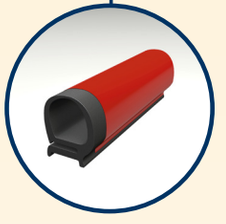


Windshield Header Sealing

Top Case Cover Sealing



Primary Door Sealing



Secondary Door Sealing

WEATHERSTRIP COATINGS

PRODUCT	MAIN APPLICATION	MAIN SUBSTRATE	1K/2K	BASE	PARTICLE SIZE, µm	COLOR	SOLIDS, %	VISCOSITY mPa·s / cps except as noted	NOISE REDUCTION	ABRASION RESISTANCE	WEATHERING	COEFFICIENT OF FRICTION
Sipiol® WL 1120-21	Door sealing, trunk-bonnet, hood sealing	EPDM, Sponge	1K	Aqueous	No Particles	Black	30.0-34.5	10-100	++	++	+++	0.3
Sipiol WL 1120-23	Door sealing, trunk-bonnet, hood sealing, o-rings	EPDM, Sponge	1K	Aqueous	No Particles	Black	31-36	10-150	++	+++	+++	0.3
Sipiol WL 2010-23	Door sealing, trunk-bonnet, hood sealing	EPDM, TPE, Sponge	2K (WV 21 F)	Aqueous	No Particles	Black	31-36	400-600	++	+++	+++	0.26
Sipiol WL 2010-24	Door sealing, trunk-bonnet, hood sealing	EPDM, TPE, Sponge	2K (WV 21 F)	Aqueous	No Particles	Black	31-35	50-150	++	+++	+++	0.26
Sipiol WL 2015-22P	Secondary door sealing, frameless doors, convertibles	EPDM, TPE, Sponge	2K (WV 21 F)	Aqueous	60	Black	34-39	150-300	+++	+++	+++	0.16
Sipiol WL 1025-21	Secondary door sealing, frameless doors, convertibles	EPDM, Sponge	1K	Aqueous	60	Black	36.5-40.5	40-100	+++	+++	+++	0.16
Sipiol WL 1026-21	Secondary door sealing, frameless doors, convertibles, sun roof, electric vehicles	EPDM, Sponge	1K	Aqueous	30	Black	36-40	50-150	+++	+++	++++	0.16
Sipiol WL 1620-21 G	Anti-friction coatings for o-rings	EPDM	1K	Aqueous	No Particles	Matte or Glossy Transparent	31-36, 36-40	10-150, 50-250	++	++	N/A	N/A
Autoseal® RC-3007S	Door sealing, trunk-bonnet, hood sealing	Sponge	2K (AS-3463B)	Aqueous	No Particles	Black	28.5-32.5	200-1000	++++	++	+++	++

+ meets expectations
++ good
+++ very good
++++ excellent

CROSS-LINKERS / ADHESION PROMOTERS / THICKENERS / SETTING AIDES

PRODUCT	MAIN APPLICATION	SUBSTRATE	PROPOSED % IN WEIGHT	CURING REQUIREMENT, °C	POT LIFE
Sipiol WV 21 F	Curative for 2K rubber coating	EPDM, TPE	3	25-200	8 hr at 25°C
Sipiol WV 23	Curative for 2K rubber coating	EPDM	1K = 1-3 2K = 8	130-200	No pot life limitation
Autoseal 3463B	Cross-linker for 2K rubber coating	EPDM	2.50	25-182	24-48 hr
Sipiol HV 3	Adhesion Promoter	EPDM, TPE	5-10 for all systems	N/A	Infinite pot life; can be used as a primer on TPE
Sipiol TH2	Thickener	EPDM, TPE	0.2-2	-	No pot life limitation
Sipiol WM 2	Setting aide	all substrates	-	25-180	No pot life limitation
Autoseal RC-1500	Adhesion Promoter	EPDM, Sponge	10	180	No pot life limitation
Autoseal RC-804B	Cross-linker for 2K rubber coating	EPDM, Sponge	2-5	149-288	8-10 hr

PRIMER FOR COATINGS

PRODUCT	MAIN SUBSTRATE	SOLVENT	COLOR	SOLIDS, %	MAIN APPLICATION
Chemlok® 459X	TPE, TPO, EPDM	Xylene	Amber	2.7-4.1	Primer for coatings and flock adhesive
Autoseal RC-1017	TPO or cured EPDM	Toluene	Clear/Tan	3.0-5.0	Primer for double layer tapes
Autoseal 459D	TPE, TPO, EPDM	Cyclohexane, MPK	Clear, Straw Yellow	2.8-4.4	Primer for coatings and flock adhesives
Autoseal RC-1028K	EPDM, TPO, PP	Methylcyclohexane, Butyl acetate, Ethanol, 2-Propanol	Light Yellow to Brown	3.3-4.3	Primer for coatings and flock adhesives
Autoseal RC-1019	TPO, PP, EPDM	Toluene, Isopropyl Alcohol, Cyclohexane	Clear/Tan	2.7-3.7	Primer for coatings and flock adhesives
Autoseal RC-1023	PVC, PBT, PET	Toluene, MEK, Cyclohexane, 2-Propanol	Yellow to Brown	4.8-6.8	Primer for coatings and flock adhesives
Sipiol WP 8556	TPE, EPDM, NR, HNBR	Water	Opaque Yellow	7.0-10.0	Primer for coatings and flock adhesives
Cuvertin® X 8536	TPE, TPO, EPDM	Xylene	Clear to Yellow	1.8-2.2	Primer for coatings and flock adhesives

FLOCK ADHESIVES

PRODUCT	MAIN APPLICATION	1K/2K	MAIN SUBSTRATE	SOLVENT	COLOR	SOLIDS, %	VISCOSITY mPa·s / cps except as noted	CURING, MIN	ADHESION	ABRASION	HUMIDITY STABILITY	SPECIFIC PROPERTIES
Flocksil® 1501 SF	Brush or spray	1K	EPDM, NR, CR, SBR	MIBK, Ethyl Acetate, Xylene	Brown	45-49	20-100	5 @ 180°C	+++	+++	+++	Slow curing
Flocksil 1503 EA	Brush or spray	1K	EPDM, NR, CR, SBR, TPE	Xylene, Ethyl Acetate, Methoxyisopropyl Acetate	Black	40-44	40-100	2 @ 180°C	++++	++++	++++	Fast curing
Flocksil 1506 G 1	Brush or spray	1K	EPDM, NR, CR, SBR, TPE	Xylene, Ethyl Acetate, Methoxyisopropyl Acetate	Black	40-44	40-100	2.5 @ 180°C	++++	++++	++++	Low temperature cure
Flocklok® 852F	Inline or offline	1K	EPDM, NR, CR, SBR	Xylene, Ethyl Benzene, Acetone	Brown	52-56	50-100 seconds (Zahn #2)	2 @ 204°C	+++	+++	+++	Fast curing
Flocklok 853A	Brush or spray	1K	EPDM, NR, CR, SBR	Toluene, Xylene, MIBK, Acetates, Aromatic pretroleum desillate, Acetone	Brown	46.5-50.5	80-200	3 @ 204°C	+++	+++	+++	Long open time
Flocklok 7000/7204	Brush or spray	2K	PVC, Alcryin®, Sunprene®, nylon, ABS, etc.	7000: MEK 7204: Xylene, Acetates	Clear, Amber-colored	7000: 29-31 7204: 13.5-16.5	7000: 970-2500 7204: 15	3 @135°C	+++	+++	+++	For specific substrates
Autoseal RC-3902H	Inline, drop or roll	2K	TPO	Water	Light Yellow	28.5-32.5	400-1000	5-10 @ 150°C	+++	+++	+++	Water borne adhesive

+ meets expectations
++ good
+++ very good
++++ excellent

CUVERTIN® CATALYSTS

PRODUCT	MAIN APPLICATION	SUBSTRATE	PROPOSED % IN WEIGHT	POT LIFE
Cuvertin K 4	Catalyst for flock adhesive	EPDM, TPE	1-3	7 hr
Cuvertin K 24	CMR-free catalyst for flock adhesive	EPDM, TPE	1-4	7 hr

CHEMLOK® GLASS ENCAPUSLATION ADHESIVES

PRODUCT	MAIN APPLICATION	1K/2K	SOLVENT	COLOR	SOLIDS, %	VISCOSITY mPa·s / cps
Chemlok 487 A/B	Bond thermoplastic elastomers (TPE) to glass, metal and plastics during injection molding	2K	A: Xylene B: MIBK	Clear	A: 12.6-15 B: 1-2	A: 100-350 B: 1-10
Chemlok 489/456	Bond PVC to glass, metals and plastics during injection molding	2K	489: MIBK/Xylene 456: Xylene	Amber	489: 9-11 456: 49-51	489: 80-195 456: <25
Chemlok AP-133	Bond unvulcanized silicone rubber to glass, metals, plastics and textiles	1K	Methanol, Ethanol, Tolune	Clear	4.8-6.2	0-5
Chemlok 144	Bond RIM urethane to glass	1K	Toluene, n-Butanol, Ethanol	Clear, Straw Yellow	4.8-6.2	1-8 cSt
Chemlok 6150, Chemlok 8560S-1	Bond EPDM to glass during injection molding	1K	6150: Xylene 8560S-1: Water	Black	6150: 21-25 8560S-1: 38-42	6150: 200-1000 8560S-1: 50-250

CHEMLOK® PRIMERS

PRODUCT	MAIN SUBSTRATE	SOLVENT	COLOR	SOLIDS, %	MAIN APPLICATION
Chemlok 144	Glass fabric, steel, aluminum, brass, e-coated metal, architectural and automotive glass, concrete and some plastics	Toluene, n-Butanol, Ethanol	Clear, Straw Yellow	4.8-6.2	Injection Molding
Chemlok AP-134	Architectural and automotive glass, glass fabric, steel, aluminum, brass, e-coated metal, concrete and some plastics	Toluene, n-Butanol, Ethanol	Clear, Straw Yellow	4.8-6.2	Injection Molding

Parker Lord
Engineered Materials Group
111 LORD Drive
Cary, NC 27511-7923
USA
phone +1 877 275-5673
www.parker.com/EPM

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