

CHEMLOK® 5150 ADHESIVE

Technical Data Sheet

Chemlok® 5150 solvent-based adhesive is used to bond uncured fluoroelastomers to metal. It can also be used to bond fluoroelastomers with an incorporated cure system to mechanically prepared metals as well as phosphatized metals, like those used in the manufacture of dynamic seals. Chemlok 5150 adhesive also adheres fluoroelastomers to stainless steel, aluminum and brass.

Features and Benefits

Excellent Appearance: provides good cosmetics; resists staining or discoloring of non-black elastomers.

Versatile: bonds a wide variety of fluoroelastomers and metals; accommodates a wide variety of postcures and is tolerant of compounding variables.

Easy to Apply: low viscosity allows for easy application.

Fluid Resistant: provides good resistance to Reference Fuel C, No. 2 diesel and other fluids.

Elastomers

- Fluoroelastomer (FKM)
- Viton®

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: No agitation is required before or during use. If dilution is needed, satisfactory results are usually obtained with dilutions of 1:1 using methanol or ethanol. Dilutions of 10 parts alcohol to 1 part adhesive are possible.

Applying: Apply adhesive by dip, tumble spray or regular spray methods.

Drying/Curing: Allow adhesive to air-dry, maintaining forced air drying temperatures below 93°C (200°F).

Chemlok 5150 adhesive cures at 165-188°C (330-370°F). Post cures of 12-24 hours at 204-232°C (400-450°F) can be used. For exceptionally thick parts, use a step postcure beginning at 149°C (300°F), and increase the temperature in 10°C (50°F) increments at two hour intervals until a temperature of 204-232°C (400-450°F) is achieved.

Typical Properties*

Appearance	Clear to Pale Yellow Liquid
Density kg/m ³ (lb/gal)	780 - 830 (6.5 - 6.9)
Solids Content by Weight, %	4.9 - 5.8
Flash Point, °C (°F)	6 (43)
Solvents	Methanol

*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 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.

Verify Volatile Organic Compounds (VOC) requirements with the applicable local, regional and state air quality authorities before importing, selling or using this product. VOC rules, thresholds and reporting obligations vary by jurisdiction; compliance is the responsibility of the importer/seller/owner.

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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