

CHEMLOK® 6225 ADHESIVE

Technical Data Sheet

Chemlok® 6225 adhesive is a covercoat adhesive that bonds a wide variety of elastomers to various metals. It is composed of dissolved organic polymers and dispersed fillers in a xylene and methyl isobutyl ketone (MIBK) solvent system.

Chemlok 6225 adhesive offers excellent adhesion to soft NR compounds with semi-EV cure systems.

Features and Benefits

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

Environmentally Resistant: provides superior resistance to heat and salt spray.

Easy to Apply: applies easily by dip, spray, brush or roll coat methods.

Elastomers

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

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 6225 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 brush, dip, spray or roll coat methods.

Regardless of application method, the dry film thickness of Chemlok 6225 adhesive should be 15.2-20.3 micron (0.6-0.8 mil).

Typical Properties*

Appearance	Black Liquid
Viscosity cps @ 25°C (77°F) Brookfield LVT Spindle 2, 30 rpm seconds Zahn Cup #2	50 - 200 25 - 80
Density kg/m ³ (lb/gal)	970 - 1020 (8.1 - 8.5)
Solids Content by Weight, %	25.5 - 29.5
Flash Point (Seta), °C (°F)	27 (81)
Solvents	Xylene, MIBK

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

Drying/Curing: Allow the applied adhesive to dry until visual examination of the film has shown that all solvent has evaporated. This will take approximately 30-60 minutes at room temperature. Drying time can be shortened by either preheating the metal inserts or oven drying after application. Metal parts may be preheated to a maximum of 65°C (150°F) prior to adhesive application. For coated parts, moderate drying temperatures should be used, but temperatures as high as 93°C (200°F) may be used for very short periods of time. Maximum air flow at minimum temperatures will give the best results.

Cleanup: Use solvents such as xylene and MEK to remove adhesive before heat is applied. Remove cured adhesive by mechanical blasting methods.

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.

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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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