

CHEMLOK® 6254

Technical Data Sheet

Chemlok® 6254 is a one-coat surface treatment used for affixing rubber compounds to metal in applications which require a heat- and oil-resistant system. It is composed of a mixture of polymers, organic compounds and mineral fillers dissolved or dispersed in an organic solvent system.

Chemlok 6254 provides excellent performance and corrosion resistance when used with mechanically or chemically treated cold rolled steel or aluminum.

Features and Benefits

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

Excellent Appearance: provides a continuous film appearance.

Process Compatible: resists sweeping; accommodates a wide range of processing conditions, including extended prebake.

Environmentally Resistant: provides excellent resistance to salt spray.

Versatile: can be used as a covercoat over Chemlok 205 or 207 for maximum protection or when environmental conditions as severe.

Elastomers

- Natural Rubber (NR)
- Polychloroprene (CR)
- Polyisoprene (IR)
- Nitrile (NBR)
- Styrene-butadiene (SBR)
- Hydrogenated Nitrile (HNBR)
- Polybutadiene (BR)
- Butyl (IIR)
- EPDM Polymers
- Polyacrylate (ACM)
- Chlorinated Polyethylene (CPE)
- Chlorosulfonated Polyethylene (CSM)

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 application guide.

Mixing: Special attention should be given to mixing Chemlok 6254. Agitation methods and times will vary depending on container size and time in inventory. To ensure a homogeneous mix and uniform appearance, refer to Chemlok application guide for recommended mixing procedures.

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 Chemlok 6254 by brush, spray, dip or any other method that gives a uniform coating and avoids excessive runs and tears.

Regardless of application method, the dry film thickness of Chemlok 6254 should be 12.7-25.4 micron (0.5-1.0 mil). For affixing cured rubber, dry film thickness of 25.4-50.8 micron (1.0-2.0 mil) is normally used.

Curing: Chemlok 6254 cures during the rubber vulcanization process.

Typical Properties*

Appearance	Black Liquid
Viscosity, cps @ 25°C (77°F) Brookfield LVT Spindle 2, 30 rpm	150 - 450
Density kg/m ³ (lb/gal)	980.0 - 1020.0 (8.2 - 8.5)
Solids Content by Weight, %	25 - 30
Flash Point (Seta), °C (°F)	7 (44)
Solvents	Xylene, Toluene

*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 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.

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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DS6023CE OD 03/26 Rev.3

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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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CHEMLOK® 6254

技术说明书

Chemlok® 6254作为单涂,主要针对耐热及耐油体系的应用,帮助和促进各种橡胶化合物附着至金属。本品是聚合物、有机化合物和矿物填料在有机溶剂体系内溶解或分散形成的混合物。

Chemlok 6254可以为经过机械或化学处理的冷轧钢材或铝材提供卓越的高强度性能和防腐蚀性能。

特征和优点

涂敷简单:涂敷方法简单,喷涂、浸涂或刷涂均可。

外观出色:涂层外观连续均匀。

工艺兼容性:涂层耐冲刷;可适应各种工艺条件,包括长时间预烘烤。

耐环境性:耐盐雾性出众。

用途广泛:作为面涂可与Chemlok205或207配合使用,可以提供最大程度的保护或适应严苛的环境条件。

弹性体

- 天然橡胶 (NR)
- 聚异戊二烯 (IR)
- 丁苯橡胶 (SBR)
- 顺丁橡胶 (BR)
- EPDM 聚合物
- 氯化聚乙烯 (CPE)
- 氯磺化聚乙烯 (CSM)
- 氯丁橡胶 (CR)
- 丁腈橡胶 (NBR)
- 氢化丁腈橡胶 (HNBR)
- 丁基橡胶 (IIR)
- 聚丙烯酸酯 (ACM)

使用方法

表面处理:在涂敷前,应彻底清洗金属表面。使用溶剂型除油剂或碱性清洗剂去除金属表面的保护油、切削油和油脂。选择适当的化学清洗或机械清洗方法除去金属表面的锈、氧化层或氧化膜。

对于特定基材的表面处理的详细信息请参阅Chemlok/Chemosil应用指南。

混合:应特别注意Chemlok 6254的搅拌。搅拌方法和时间并没有统一的要求,应根据包装筒的大小和储存时间而定。为了确保均匀的混合和统一的外观,请参阅Chemlok应用指南获取推荐的混合步骤。

如果需要稀释,可使用二甲苯或甲苯。注意:针对不同涂敷方式的稀释最好通过经验获得。稀释会加速沉降,搅拌时须特别注意。

涂敷:Chemlok 6254可采用刷涂、喷涂、浸涂或任何可提供均一涂膜、避免涂膜流淌或撕裂的涂敷工艺。

不论采用何种涂敷方式,Chemlok 6254的干膜厚度应为12.7-25.4微米(0.5-1.0密尔)。针对已固化橡胶,通常干膜厚度为25.4-50.8微米(1.0-2.0密尔)。

固化:Chemlok 6254在橡胶硫化过程中固化。

保质期/储藏要求

自发货之日起,保质期为六个月,但是收货人必须使用出厂未开封的原装容器,且保存在21-27°C (70-80°F)环境下。储藏或使用不得靠近热源、火花或明火。

典型特性*

外观	黑色液体
粘度, cps @ 25°C (77°F) Brookfield粘度计 2号转子, 转速30 rpm	150 - 450
密度 kg/m ³ (lb/gal)	980.0 - 1020.0 (8.2 - 8.5)
固体含量, %	25 - 30
闪点 (Seta), °C (°F)	7 (44)
溶剂	二甲苯、甲苯

*典型数据不可作为产品标准之用。

警示信息

使用本品或派克洛德 (Parker Lord) 任何产品之前, 请参阅安全数据表 (SDS) 和产品标签上关于安全使用和处理的说明。

在进口、销售或使用本产品之前, 请与当地及相关国家区域的空气质量主管部门核实挥发性有机物 (VOC) 的要求。VOC 的规定、阈值和报告义务因地区而异; 合规责任在于进口商/销售商/所有者。

仅可用于工业/商业用途。要求本品在有组织排放下使用。使用本品者事先必须接受相关培训。不得用于家庭用途。不得用于消费品。

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DS6023CE OD 03/26 Rev.3

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