

CHEMLOK® 6254 ADHESIVE

Technical Data Sheet

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

Chemlok 6254 adhesive provides excellent adhesion 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 adhesive over Chemlok 205 or 207 primer for maximum protection or when environmental conditions are severe.

Elastomers

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

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: Special attention should be given to mixing the adhesive. 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 Adhesives 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.

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 - 1020 (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.

Applying: Apply adhesive 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 adhesive should be 12.7-25.4 micron (0.5-1.0 mil). For bonding cured rubber, dry film thickness of 25.4-50.8 micron (1.0-2.0 mil) is normally used.

Curing: Chemlok 6254 adhesive cures during the rubber vulcanization process.

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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