CHEMLOK® 6260 ADHESIVE

Technical Data Sheet

Chemlok® 6260 adhesive is a one-coat adhesive that bonds rubber compounds to metal. It is composed of a mixture of polymers, organic compounds and mineral fillers dissolved or dispersed in an organic solvent system.

Chemlok 6260 adhesive provides excellent adhesion and corrosion resistance when used with mechanically or chemically treated cold rolled steel or aluminum.

Features and Benefits

Versatile: bonds a variety of elastomers; can be used as a covercoat adhesive over Chemlok 205 or 207 primer for maximum protection or when environmental conditions are severe.

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

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

Identifiable Appearance: provides a brown color for easy identification when used over black anti-corrosion coatings.

Environmentally Resistant: provides excellent resistance to salt spray.

Elastomers

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

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: 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.

Typical Properties*

Appearance	Brown Liquid
Viscosity cps @ 25°C (77°F) Brookfield LVT Spindle 2, 30 rpm	 100 - 600
seconds Zahn Cup #3	12 - 68
Density kg/m^3 (lb/gal)	 976.6 - 1018.5 (8.15 - 8.50)
Solids Content by Weight, %	26 - 30
Flash Point (Seta), °C (°F)	6 (44)
Solvents	Xylene

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

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Applying: Apply adhesive by brush, dip, spray 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 6260 adhesive should be 17.8-25.4 micron (0.7-1.0 mil). For bonding cured rubber, dry film thickness of 25.4-50.8 micron (1.0-2.0 mil) is normally used.

Curing: Chemlok 6260 adhesive cures during the rubber vulcanization process.

Shelf Life/Storage

Shelf life is six months from date of shipment when stored by the recipient in a well ventilated area 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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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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