

CHEMLOK® 6411 LH ADHESIVE

Technical Data Sheet

Chemlok® 6411LH adhesive is a low Hazardous Air Pollutant (HAP) covercoat adhesive that bonds rubber compounds to metal. It is composed of a mixture of polymers and heat-reactive components dissolved or dispersed in a low HAP organic solvent system.

Chemlok 6411LH general-purpose adhesive is designed to meet low hazardous air pollutant guidelines while offering strong adhesion and environmental resistance.

Features and Benefits

Versatile: bonds a wide variety of elastomer compounds to rigid substrates when used in combination with Chemlok 205LH or 207LH primer. Use of Chemlok 205LH or 207LH primer helps to ensure environmental resistance of the bonded assembly and adhesion to the substrate.

Easy to Apply: applies easily by spray methods.

Environmentally Resistant: provides good resistance to heat, oil and corrosive-type conditions.

Environmentally Preferred: contains low HAP content.

Elastomers

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

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 6411LH 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 t-butyl acetate. 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 spray methods. Avoid applying thick coats which result in poor drying and may lead to film displacement during molding.

Dry film thickness of Chemlok 6411LH adhesive should be 15.2-25.4 micron (0.6-1.0 mil).

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 minutes at room temperature. Drying time can be shortened by using hot air drying ovens or tunnels up to 90°C (194°F).

Typical Properties*

Appearance	Black Liquid
Viscosity, cps @ 25°C (77°F) Brookfield LVT Spindle 2, 30 rpm	100 - 700
Density kg/m ³ (lb/gal)	970.6 - 1018.5 (8.1 - 8.5)
Solids Content by Weight, %	22 - 26
Flash Point (Seta), °C (°F)	14 (58)
Solvents	N-Butyl Propionate, Dimethyl Carbonate, Naphtha

*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 below 25°C (77°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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