

CHEMLOK® 6450-1 ADHESIVE

Technical Data Sheet

Chemlok® 6450-1 adhesive is a high-temperature adhesive used to bond NBR and HNBR compounds to metal. It can be applied as either a covercoat or one-coat adhesive.

When used as a two-coat system, bonds formed with Chemlok 6450-1 adhesive and Chemlok 207 primer are resistant to many adverse environmental conditions found in downhole applications, as well as display excellent tear strength.

Features and Benefits

Versatile: bonds a variety of NBR and HNBR compounds to a variety of metal substrates when used in combination with Chemlok 207 primer; can be used as a one-coat adhesive.

Chemically Resistant: resists a variety of fluids, including oils and fuels, and various aqueous environments.

Environmentally Resistant: provides excellent resistance to water, humidity, salt spray and high temperatures.

Elastomers

- Nitrile (NBR)
- Hydrogenated Nitrile (HNBR)

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.

If applicable, allow primer to thoroughly dry before applying Chemlok 6450-1 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. Dilution is not required; however if desired, MEK or xylene can be used as a diluent.

Applying: Apply adhesive by brush, spray or dip methods. For flow or pour application, Chemlok 6450-1P adhesive is recommended.

Regardless of application method, the dry film thickness of Chemlok 6450-1 adhesive should be 15.2-20.3 micron (0.6-0.8 mil).

Drying/Curing: Thoroughly dry coated parts prior to bonding assemblies. Chemlok 6450-1 adhesive cures during the rubber vulcanization process.

Cleanup: Use solvents such as xylene and MEK to remove adhesive before heat is applied. Once cured, removal by solvent is not possible.

Typical Properties*

Appearance	Green-Black Liquid
Viscosity, cps @ 25°C (77°F) Brookfield LVT Spindle 1, 60 rpm	0 - 100
Density kg/m ³ (lb/gal)	916.5 - 964.6 (7.65 - 8.05)
Solids Content by Weight, %	23 - 27
Flash Point (Seta), °C (°F)	0 (32)
Solvents	MEK, Xylene

*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.

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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