CHEMLOK® EP6804-22 ADHESIVE

Technical Data Sheet

Chemlok® EP6804-22 adhesive is a conductive one-coat adhesive that bonds a wide variety of vulcanized or unvulcanized 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 EP6804-22 adhesive has excellent adhesion and corrosion resistance when used with aluminum and mechanically or chemically treated cold rolled steel.

Features and Benefits

Convenient: requires only a single coat for most applications, reducing labor, inventory and shipping costs.

Versatile: can be used in a variety of applications where conductivity is required.

Elastomers

- Natural Rubber (NR)
- Polyisoprene (IR)
- Styrene-butadiene (SBR)
- Polybutadiene (BR)
- Polychloroprene (CR)
- Nitrile (NBR)
- Butyl (IIR)
- EPDM Polymers
- 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 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 toluene or xylene. 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 brush, dip, spray or any method that gives a uniform coating and avoids excessive runs or tears.

The conductivity of the adhesive film is dependent on the dry film thickness. Regardless of application method, the dry film thickness of Chemlok EP6804-22 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.

Typical Properties*

Appearance	Black Liquid
Viscosity, cps @ 25°C (77°F) Brookfield LVT Spindle 2, 30 rpm	50 - 250
Density kg/m^3 (lb/gal)	 958.6 - 1006.5 (8.0 - 8.4)
Solids Content by Weight, %	24 - 27
Flash Point (Seta), °C (°F)	9 (48)
Solvents	Toluene, Xylene

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

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Drying/Curing: Allow adhesive to air-dry for 30-60 minutes at 16-32°C (60-90°F). Longer dry times may be necessary during humid conditions. Moderate drying temperatures of up to 93°C (200°F) can be used for short periods of time; usually 15-20 minutes at 93°C (200°F) is adequate.

Cleanup: Use xylene or toluene for clean up.

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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