

CHEMLOK® NX-100 ADHESIVE

Technical Data Sheet

Chemlok® NX-100 adhesive is a covercoat adhesive that bonds a variety of elastomers to various substrates during vulcanization of the elastomer. It is composed of a mixture of polymers and heat-reactive components dissolved or dispersed in an organic solvent system.

For general use, Chemlok NX-100 adhesive should be used as a covercoat adhesive over Chemlok 205 primer.

Features and Benefits

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

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

Elastomers

- Natural Rubber (NR)
- Styrene-butadiene (SBR)
- Polychloroprene (CR)
- 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.

Allow primer to thoroughly dry before applying Chemlok NX-100 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 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.

Applying: Apply adhesive by brush, roll coat, 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 NX-100 adhesive should be 12.7-25.4 micron (0.5-1.0 mil).

Typical Properties*

Appearance	Black Liquid
Viscosity, cps @ 25°C (77°F) Brookfield LVT Spindle 2, 30 rpm	100 - 600
Density kg/m ³ (lb/gal)	960 - 1000 (8.00 - 8.30)
Solids Content by Weight, %	19 - 23
Flash Point (Seta), °C (°F)	25 (77)
Solvents	Xylene

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

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).

Shelf Life/Storage

Shelf life is one year 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.

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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