

CHEMLOK® Y-1520A ADHESIVE

Technical Data Sheet

Chemlok® Y-1520A adhesive is a clear, one-coat adhesive used to bond specialty elastomers to metal and plastics during vulcanization of the rubber. Chemlok Y-1520A adhesive is useful for bonding fluoroelastomers, polyacrylates, and many peroxide-curing elastomers to metals, including phosphatized metals.

Features and Benefits

Environmentally Resistant: provides outstanding resistance to Reference Fuel B, ASTM Oil No. 1, 50/50 Prestone®/water and 90 wt. gear lube.

Low Viscosity: maintains low viscosity for spray and dip (hand or tumble) applications.

Elastomers

- Fluoroelastomer (FKM) - peroxide cure
- Polyacrylate (ACM)
- Epichlorohydrin (ECH)
- Silicone (VMQ, PMQ, PVMQ) - peroxide cure

Application

Surface Preparation: Chemlok Y-1520A adhesive is primarily used on phosphated metal parts and mechanically prepared parts, including metals and plastics. Lightly blast parts and follow with a solvent wipe.

For further detailed information on surface preparation of specific substrates, refer to Chemlok Adhesives application guide.

Mixing: No mixing is required before or during use. If dilution is needed, use 2-3 parts of methanol or ethanol to 1 part adhesive.

Applying: Apply adhesive by brush, dip or spray methods. Dip application is preferred to maintain precise control over adhesive thickness.

Drying/Curing: Allow adhesive to air-dry for a minimum of 30 minutes prior to bonding. Chemlok Y-1520A adhesive cures during the rubber vulcanization process. Bond coated parts within three days of application.

Cleanup: Use alcohol or methanol to clean up equipment. Mechanical removal is the best method for ensuring adhesive removal.

Typical Properties*	
Appearance	Clear Liquid
Viscosity, cSt	<10
Density kg/m ³ (lb/gal)	800.0 - 830.0 (6.7 - 6.9)
Solids Content by Weight, %	8.0 - 9.2
Flash Point (Seta), °C (°F)	11 (52)
Solvents	Ethyl and Methyl Alcohol

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

Shelf Life/Storage

Shelf life is one year 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.

Parker Lord
Engineered Materials Group
111 LORD Drive
Cary, NC 27511-7923
USA
phone +1 877 275-5673
www.parker.com/EPM

DS3270 OD 09/26 Rev.7

Information and specifications subject to change without notice and without liability therefor.
Trademarks used herein are the property of their respective owners.

© 2026 Parker Hannifin Corporation



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.

Information provided herein is based upon tests believed to be reliable. In as much as Parker Lord has no control over the manner in which others may use this information, it does not guarantee the results to be obtained. In addition, Parker Lord does not guarantee the performance of the product or the results obtained from the use of the product or this information where the product has been repackaged by any third party, including but not limited to any product end-user. Nor does the company make any express or implied warranty of merchantability or fitness for a particular purpose concerning the effects or results of such use.

WARNING — USER RESPONSIBILITY. FAILURE OR IMPROPER SELECTION OR IMPROPER USE OF THE PRODUCTS DESCRIBED HEREIN OR RELATED ITEMS CAN CAUSE DEATH, PERSONAL INJURY AND PROPERTY DAMAGE.

This document and other information from Parker-Hannifin Corporation, its subsidiaries and authorized distributors provide product or system options for further investigation by users having technical expertise.

The user, through its own analysis and testing, is solely responsible for making the final selection of the system and components and assuring that all performance, endurance, maintenance, safety and warning requirements of the application are met. The user must analyze all aspects of the application, follow applicable industry standards, and follow the information concerning the product in the current product catalog and in any other materials provided from Parker or its subsidiaries or authorized distributors.

To the extent that Parker or its subsidiaries or authorized distributors provide component or system options based upon data or specifications provided by the user, the user is responsible for determining that such data and specifications are suitable and sufficient for all applications and reasonably foreseeable uses of the components or systems.