

CHEMLOK® Y-1540 ADHESIVE

Technical Data Sheet

Chemlok® Y-1540 adhesive is a one-coat adhesive used to bond peroxide curing silicone, EPDM and fluoroelastomers to cold rolled and phosphatized steel.

Features and Benefits

Environmentally Resistant: resists temperatures of 260°C (500°F) when bonding silicone rubber; provides good resistance to hot motor oils.

Easy to Apply: low viscosity allows for easy application by brush or dip methods.

Excellent Appearance: provides good cosmetics; dries to a clear to slight red coating.

Elastomers

- Nitrile (NBR) - peroxide cure
- Hydrogenated Nitrile (HNBR) - peroxide cure
- Fluoroelastomer (FKM) - peroxide cure
- EPDM - peroxide cure
- Silicone (VMQ, PMQ, PVMQ) - peroxide cure
- EPDM/Silicone Blends

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: No mixing is required before or during use. If dilution is needed, use methanol or ethanol at a ratio of 1:1, by volume.

Applying: Apply adhesive by dip or brush methods.

Drying/Curing: Allow adhesive to air-dry for at least 3 hours at 16-38°C (60-100°F) prior to bonding. Oven drying at temperatures up to 93°C (200°F) can also be used. Bond coated parts within 2-3 days after coating.

Cleanup: Use alcohol or ketones to clean up adhesive.

Shelf Life/Storage

Shelf life is six months from date of shipment when stored by the recipient at 10-32°C (50-90°F) in original, unopened container.

Typical Properties*

Appearance	Red Liquid
Viscosity, cps @ 25°C (77°F) Brookfield LVT Spindle 2, 60 rpm	~3
Density kg/m ³ (lb/gal)	838.8 - 862.8 (7.0 - 7.2)
Solids Content by Weight, %	8 - 12
Flash Point (Seta), °C (°F)	9.4 (49)
Solvents	Methanol, Ethanol

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

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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