

Chemlok® 256 Adhesive

OBSOLETE

Description

LORD Chemlok® 256 adhesive is a general purpose one-coat adhesive used to bond rubber compounds based on natural rubber (NR), styrene-butadiene (SBR), polychloroprene (CR), nitrile (NBR) and EPDM polymers to metal during vulcanization. It is composed of a mixture of polymers, organic compounds and fillers dissolved or dispersed in an organic solvent system.

For maximum protection or when environmental conditions are extremely aggressive, Chemlok 256 adhesive can be used over Chemlok 205 primer.

Features and Benefits

Easy to Apply – high solids content allows for roll coating application.

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

Process Compatible – resists sweeping; ideal for transfer or injection molding operations.

Application

Surface Preparation – Thoroughly clean metal surfaces prior to adhesive 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.

- **Chemical Cleaning**
Chemical treatments are readily adapted to automated metal treatment and adhesive application lines. Chemical treatments are also used on metal parts that would be distorted by blast cleaning or where tight tolerances must be maintained. Phosphatizing is a commonly used chemical treatment for steel, while conversion coatings are commonly used for aluminum.
- **Mechanical Cleaning**
Grit blasting is the most widely used method of mechanical cleaning. However machining, grinding or wire brushing can be used. Use steel grit to blast clean steel, cast iron and other ferrous metals. Use aluminum oxide, sand or other nonferrous grit to blast clean stainless steel, aluminum, brass, zinc and other nonferrous metals.

Typical Properties*

Appearance	Black Liquid
Viscosity, cps @ 25°C (77°F) Brookfield LVT Spindle 2, 30 rpm	100-350
Density kg/m ³ (lb/gal)	970.6-1006.5 (8.1-8.4)
Solids Content by Weight, %	23.5-26.5
Flash Point (Seta), °C (°F)	7 (44)
Solvents	Xylene, Toluene

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

LORD TECHNICAL DATA

For further detailed information on surface preparation of specific substrates, refer to Chemlok Adhesives application guide. Handle clean metal surfaces with clean gloves to avoid contamination with skin oils.

Mixing – Thoroughly stir Chemlok 256 adhesive before use, and agitate sufficiently during use to keep dispersed solids uniformly suspended. If dilution is needed, use xylene or toluene as diluents.

Applying – Apply Chemlok 256 adhesive by brush, spray, dip, roll coat or spin/dip methods.

When using Chemlok 256 adhesive as a one-coat adhesive, the dry film thickness should be 17.8-25.4 micron (0.7-1.0 mil) for optimum adhesion and environmental resistance. When used as a covercoat over Chemlok 205 primer, the dry film thickness of Chemlok 256 adhesive should be 12.7-25.4 micron (0.5-1.0 mil).

Curing – Chemlok 256 adhesive cures during the rubber vulcanization process.

Cleanup – Use xylene, toluene or ketones to clean up Chemlok 256 adhesive.

Shelf Life/Storage

Shelf life is one year from date of shipment when stored 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 LORD product, refer to the Material Safety Data Sheet (MSDS) 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.

Values stated in this technical data sheet 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.

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