**Chemlok® 8560S Adhesive**

**Description**
LORD Chemlok® 8560S adhesive is a general purpose, one-coat aqueous adhesive used to bond a wide variety of vulcanized and unvulcanized rubber compounds to metal.

A single coat of Chemlok 8560S adhesive will bond compounds based on natural rubber (NR), polyisoprene (IR), styrene-butadiene (SBR), polybutadiene (BR), poly-chloroprene (CR) and nitrile (NBR) polymers to a variety of metals such as carbon and alloy steels, stainless steel and aluminum during the vulcanization process.

Chemlok 8560S adhesive has been formulated using water as the carrier system and does not contain co-solvents.

When environmental conditions are severe, Chemlok 8560S adhesive is recommended to be used over Chemlok 8007 aqueous primer.

**Features and Benefits**
- **Versatile** – serves as a post vulcanization (cured rubber) bonding agent capable of bonding a wide variety of vulcanized rubber compounds.
- **Convenient** – requires only a single coat for most applications, reducing labor, inventory and shipping costs.
- **Environmentally Friendly** – uses water for dilution; has low VOC emissions.

**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.

**Typical Properties***

<table>
<thead>
<tr>
<th>Property</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Appearance</td>
<td>Black Liquid</td>
</tr>
<tr>
<td>Viscosity</td>
<td></td>
</tr>
<tr>
<td>cps @ 25°C (77°F)</td>
<td>50-250</td>
</tr>
<tr>
<td>Brookfield LVT Spindle 2, 30 rpm</td>
<td></td>
</tr>
<tr>
<td>seconds</td>
<td>15-25</td>
</tr>
<tr>
<td>Zahn Cup #2</td>
<td></td>
</tr>
<tr>
<td>Density</td>
<td>1174.3-1222.2 (9.8-10.2)</td>
</tr>
<tr>
<td>Solids Content by Weight, %</td>
<td>38-42</td>
</tr>
<tr>
<td>Flash Point (Seta), °C (°F)</td>
<td>&gt;93 (&gt;200)</td>
</tr>
<tr>
<td>Solvents</td>
<td>Deionized Water</td>
</tr>
<tr>
<td>pH</td>
<td>6-8</td>
</tr>
</tbody>
</table>

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

- 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.

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 mix Chemlok 8560S adhesive before use. Do not shake. To prevent foaming, mechanical mixing should not exceed 30 rpm. The addition of anti-foaming agents is not recommended. If dilution is needed, use deionized water.

Applying – Apply Chemlok 8560S adhesive by spray or dip methods. For best results, preheat the metal parts to 49-60°C (120-140°F) prior to spray application.

For optimum adhesion and environmental resistance, the dry film thickness of Chemlok 8560S adhesive should be 12.7-25.4 micron (0.5-1.0 mil). Where minimum environmental resistance is required, film thickness in the lower range can be used on easy-to-bond rubber compounds.

Thicker films within this range may be necessary on certain hard-to-bond rubber compounds where maximum environmental resistance is required or for post vulcanization bonding.

Drying – Allow applied adhesive to air-dry for approximately 30-60 minutes at room temperature. Oven drying at 49-71°C (120-160°F) in a recirculating forced air oven is recommended. Allow longer dry times during humid conditions.

Shelf Life/Storage
Shelf life is three months from date of shipment when stored in a well ventilated area at 21-27°C (70-80°F) in original, unopened container. Do not freeze product.

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.

Information provided herein is based upon tests believed to be reliable. In as much as LORD Corporation has no control over the manner in which others may use this information, it does not guarantee the results to be obtained. In addition, LORD Corporation 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.

Chemlok and “Ask Us How” are trademarks of LORD Corporation or one of its subsidiaries.

LORD provides valuable expertise in adhesives and coatings, vibration and motion control, and magnetically responsive technologies. Our people work in collaboration with our customers to help them increase the value of their products. Innovative and responsive in an ever-changing marketplace, we are focused on providing solutions for our customers worldwide ... Ask Us How.