

# Chemlok® Y-1540 Adhesive

## Description

LORD 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.

## 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.

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.

## Typical Properties\*

Appearance	Red Liquid
Viscosity, cps @ 25°C (77°F) Brookfield LVT Spindle 2, 60 rpm	~3
Density kg/m <sup>3</sup> (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

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

# LORD TECHNICAL DATA

**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 Chemlok Y-1540 adhesive by dip or brush methods.

**Drying/Curing** – Allow Chemlok Y-1540 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°F (200°F) can also be used. Bond coated parts within 2-3 days after coating.

**Cleanup** – Use alcohol or ketones to clean up Chemlok Y-1540 adhesive.

## Shelf Life/Storage

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

## Cautionary Information

Before using this or any 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.

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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### LORD Corporation World Headquarters

111 Lord Drive  
Cary, NC 27511-7923  
USA

### Customer Support Center (in United States & Canada)

+1 877 ASK LORD (275 5673)

[www.lord.com](http://www.lord.com)

For a listing of our worldwide locations, visit [LORD.com](http://LORD.com).

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