Chemlok® 6260 Adhesive

Description

LORD Chemlok® 6260 adhesive is a one-coat adhesive used to bond a variety of vulcanized and unvulcanized rubber compounds to metal. It is formulated without heavy metals and composed of a mixture of polymers, organic compounds and mineral fillers dissolved or dispersed in an organic solvent system.

A single coat of Chemlok 6260 adhesive will bond compounds based on natural rubber (NR), polyisoprene (IR), styrene-butadiene (SBR), polybutadiene (BR), polychloroprene (CR) nitrile (NBR), butyl (IIR) and EPDM polymers to metal.

Chemlok 6260 adhesive has excellent adhesion and corrosion resistance when used with mechanically or chemically treated cold rolled steel or aluminum. For maximum protection or when environmental conditions are severe, Chemlok 6260 adhesive can be used over Chemlok 205 primer or Chemlok 207 primer.

Features and Benefits

Easy to Apply – applies easily by spray, dip or brush methods.

Process Compatible – resists sweeping; accommodates a wide range of processing conditions at moderate temperatures, including extended prebake.

Identifiable Appearance – provides a brown color for easy identification when used over black anti-corrosion coatings.

Environmentally Resistant – provides excellent resistance to salt spray.

Environmentally Recommended – formulated without heavy metals.

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

Typical Properties*

Appearance	Brown Liquid
Viscosity	
cps @ 25°C (77°F) Brookfield LVT Spindle 2, 30 rpm	100 - 600
seconds Zahn Cup #3	12 - 68
Density	
kg/m^3	976.59 - 1018.52
(lb/gal)	(8.15 - 8.50)
Solids Content by Weight, %	26 - 30
Flash Point (Seta), °C (°F)	6 (44)
Solvents	Xylene

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

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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.

Mixing – Thoroughly stir Chemlok 6260 adhesive before use, and agitate sufficiently during use to keep dispersed solids uniformly suspended. Use an air-driven or other explosion-proof mixer for agitator drums or on other smaller containers. If dilution is needed, use xylene or toluene.

Applying – Apply Chemlok 6260 adhesive by brush, dip, spray or any method that gives a uniform coating and avoids excessive runs or tears. Spray and dip application methods are recommended for obtaining uniform control and dry film thickness.

For optimum adhesion and environmental resistance, the dry film thickness of Chemlok 6260 adhesive should be 17.8-25.4 micron (0.70-1.0 mil). Where minimum environmental resistance is required, film thickness in the lower range can be used on easy-to-bond rubber compounds. Thicker films may be necessary on certain hard-to-bond rubber compounds and where maximum environmental resistance is required. For bonding cured rubber, dry film thickness of 25.4-50.8 micron (1.0-2.0 mil) are normally used.

Shelf Life/Storage

Shelf life is six 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 store or use near heat, sparks or open flame.

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.

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