

# Chemlok® 8800 Adhesive

## Description

LORD Chemlok® 8800 adhesive is a one-coat, aqueous adhesive used for bonding silicone rubber, EPDM, HNBR, XHNBR, AFLAS, VAMAC and other peroxide-cured materials.

With good resistance to hot oils, hot water and other fluids, Chemlok 8800 adhesive is suitable for use in the manufacture of gaskets, seals and NVH components.

## Features and Benefits

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

**Environmentally Friendly** – uses water for dilution; provides reduced VOC emissions.

**Versatile** – bonds a wide range of compounds to many rigid substrates, such as zinc phosphatized steel, copper, nylon and aluminum.

**Environmentally Resistant** – provides good resistance to high temperature fluid environments.

## 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	Beige Liquid
Viscosity, cps @ 25°C (77°F) Brookfield LVT Spindle 2, 30 rpm	5-100
Density kg/m <sup>3</sup> (lb/gal)	1114-1174 (9.3-9.8)
Solids Content by Weight, %	28-32
Flash Point (Seta), °C (°F)	>93 (>200)
Solvents	Deionized Water

\*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** – Stir Chemlok 8800 adhesive for 5-10 minutes. Do not shake.

Chemlok 8800 adhesive is used full strength for dip applications. For spray application, dilute as needed using deionized water.

**Applying** – Apply Chemlok 8800 adhesive by spray or dip methods. For optimum adhesion, the dry film thickness of Chemlok 8800 adhesive should be 7.6-17.8 micron (0.3-0.7 mil).

- Spraying  
Apply adhesive to parts that have been preheated to 60-65°C (140-150°F).
- Dipping  
Apply adhesive at room temperature.

**Drying/Curing** – Use of heat forced air is recommended to thoroughly dry coated parts.

Chemlok 8800 adhesive cures and bonds during the rubber vulcanization process. Wear clean gloves when handling coated parts and keep coated parts covered to prevent airborne materials from contaminating the surface.

**Cleanup** – Use soap and water to remove wet adhesive. Remove dried adhesive with solvents such as acetone, MEK or alcohols.

## Shelf Life/Storage

Shelf life is 90 days from date of shipment when stored refrigerated 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.

### 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).

©2013 LORD Corporation OD DS4144 (Rev.0 6/13)

**LORD**  
AskUsHow™