

Chemlok® 6956 Adhesive

Description

LORD Chemlok® 6956 adhesive is a high performance adhesive used to bond a variety of elastomer compounds to substrates. It is composed of a mixture of polymers, organic compounds and mineral fillers dissolved or dispersed in an organic solvent system.

Chemlok 6956 adhesive will bond compounds based on natural rubber (NR), polyisoprene (IR), styrene-butadiene (SBR), polybutadiene (BR) and polychloroprene (CR) polymers to metals.

Chemlok 6956 adhesive is recommended for use over Chemlok 298 primer. Chemlok 6956 adhesive can also be used without a primer in some applications.

Features and Benefits

Excellent Adhesion – adheres well to properly prepared metals, such as cold rolled steel and aluminum.

Temperature Resistant – provides exceptional resistance to high heat applications and environments.

Fluid Resistant – provides excellent resistance to hot solutions of water and ethylene glycol or propylene glycol.

Corrosion Resistant – provides excellent corrosion resistance when used with properly prepared metals.

Application

Surface Preparation – Thoroughly clean metal surfaces prior to primer 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	Black Liquid
Viscosity, cps @ 25°C (77°F) Brookfield LVT Spindle 3, 30 rpm	300
Density kg/m ³ (lb/gal)	934.6 (7.8)
Solids Content by Weight, %	20
Flash Point (Seta), °C (°F)	16 (61)
Solvents	Xylene, Methyl Isobutyl Ketone (MIBK)

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

LORD TECHNICAL DATA

Mixing – Thoroughly stir Chemlok 6956 adhesive before use, and agitate sufficiently during use to keep dispersed solids uniformly suspended. If dilution is needed, use xylene as diluent.

Applying – Apply adhesive by brush or spray methods.

- **Brushing**
Apply full strength; avoid multiple brush strokes.
- **Spraying**
Dilute Chemlok 6956 adhesive with xylene at a mix ratio of 2 parts adhesive to 1 part solvent, by volume. Chemlok 6956 adhesive requires dedicated application equipment, i.e., pressure pots, fluid lines and spray guns. Gelling can occur if Chemlok 6956 adhesive comes in contact with other Chemlok primers and adhesives.

Regardless of application method, dry film thickness of Chemlok 6956 adhesive should be 12.7-25.4 micron (0.5-1.0 mil) for optimum adhesion and environmental resistance. Thicker films may be necessary on certain hard-to-bond rubber compounds and where maximum environmental resistance is required. Applying Chemlok 6956 adhesive to preheated substrates will help build the correct film thickness. If Chemlok 6956 adhesive is used without a primer, the dry film thickness must be at least 23 micron (0.9 mil).

Drying/Curing – Thoroughly dry coated parts before handling. Typical drying conditions are 5 minutes at 65.5°C (150°F). When using forced air heat, cool the

inserts to room temperature before stacking parts to avoid adhesive blocking.

Wear clean gloves when handling coated parts and keep coated parts covered to prevent airborne materials from contaminating the surface. If coated parts are properly protected, long layover times between adhesive application and bonding usually have no adverse effect on the bond.

Chemlok 6956 adhesive can be used in compression, transfer or injection molding procedures. Do not mold Chemlok 6956 adhesive in the same mold cavity as components coated with other Chemlok adhesives.

Cleanup – Use xylene to remove wet or dry adhesive. Once cured, the adhesive must be removed by mechanical blasting methods.

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.

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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