

## ADHESIVE SELECTOR GUIDE

It's been more than 45 years since Chemlok® rubber-to-metal adhesives were first introduced. While much has changed during this time, several things remain constant: the quality of Chemlok adhesives, the strong commitment to new technologies and the excellent sales and technical support. Today – as

from the beginning – the Chemlok family is recognized as the industry leader in rubber-to-metal adhesives. That's why when manufacturers have a critical application that demands a proven rubber-to-metal adhesive, they look to the name they trust – Chemlok Adhesives.

ELASTOMER	SOLVENT BASED	EPCA <sup>1</sup> SOLVENT	AQUEOUS
<b>BUTYL TYPES</b>	205/252X	205/6100	8007/8560S
	205/252H	205/6254	8007/8560D
	205/253X		
<b>CHLORO-PRENE</b>	205/252X	205/6256	8007/8560S
	205/252H	205/6100	8007/8560D
	205/256	205/6125	8007/8210
	205/253X	205/6220	8007/8121
	250	6250	
		205/6225	
<b>EPDM</b>	205/252X	205/6100	8007/8560S
	205/252H		8007/8560D
	205/238		
	205/253X		
<b>EPICHLORO-HYDRIN</b>	250X	6250	8007/8560S
	205/233X		8007/8560D
<b>ETHYLENE-ACRYLIC</b>	250	205/6125	610
	250X	205/6220	8114
	5150	6250	130
	205/220		
<b>FLUORO-CARBON</b>	5150	5150	610
	5151	5151	8114 130
<b>NITRILE (NBR)</b>	205	205/6100	8110
	205/220	205/6125	8007/8560S
	TY-PLY BN	205/6220	8007/8560D
	205/252X	TY-PLY BN	8115
	205/252H		
	205/220		
<b>HNBR</b>	205/220	205/6220	–
		205/6125 207/259	

ELASTOMER	SOLVENT BASED	EPCA <sup>1</sup> SOLVENT	AQUEOUS
<b>NATURAL</b>	205/220	205/6254	8007/8210
	205/252X	205/6256	8007/8560S
	205/252H	205/6100	8007/8560D
	205/256	205/6125	
	205/253X	205/6220 205/6225	
<b>POLYACRYLATE</b>	250	6250	610
	250X		8110 130
<b>SBR</b>	205/252X	205/6254	8007/8210
	205/252H	205/6256	8007/8560S
	205/256	205/6100	8007/8560D
	205/253X	205/6125	
	205/220	205/6220	
		205/6225	
<b>SILICONE (PEROXIDE)</b>	607	607	–
	608	608	
	Y-1540	Y-1540	
<b>SILICONE (ADDITION)</b>	606	606	–
<b>TPE/TPO</b>	487A/B	487A/B	–
	480 + 44 <sup>2</sup>	480 + 44 <sup>2</sup>	
	485 + 44 <sup>2</sup>	485 + 44 <sup>2</sup>	
<b>URETHANE (CASTABLE)</b>	213	213	8600
<b>URETHANE (MILLABLE)</b>	219	6250	–
	250	TY-PLY BN	
	250X	219	
	TY-PLY BN		
<b>URETHANE (RIM)</b>	AP-144	AP-144	–
<b>URETHANE (TPU)</b>	213	213	8600
			610
			130

<sup>1</sup> EPCA refers to Environmentally Preferred Coatings and Adhesives.

<sup>2</sup> Also referred to as Chemlok Curative 44

The selection of an adhesive primarily depends upon the type of elastomers being bonded; however, the type of substrate can also affect the adhesive choice. Below are some suggested adhesives for various substrates. The choice of primer and adhesive is dependent upon not only the metal and elastomer but also the cure cycle of the elastomer and the chemical and environmental performance required. The adhesive systems shown below are some of the more common choices. They do not represent all possible adhesive system options.

METAL/SUBSTRATE	ONE-COAT ADHESIVES	PRIMERS
<b>ALUMINUM</b>	213 250X 6250 252X 253X 6100 TY-PLY BN 607 608 8560S 8210	205 207 8007
<b>COPPER/BRASS</b>	213 250X 6250 6254 TY-PLY BN 607 608 8560S 8210	205 207 8007
<b>ELECTRO-GALVANIZED STEEL</b>	250X 6250 252X 6100 8560S	205 207 8007
<b>GLASS/CERAMIC</b>	250X 6250	AP-134
<b>GRIT-BLASTED, DEGREASED STEEL</b>	213 250X 6250 252X 253X 6100 TY-PLY BN 607 608 8560S 8210	205 207 8007
<b>NYLON</b>	250X 6250 252X 6100 8560S	205 207 8007

METAL/SUBSTRATE	ONE-COAT ADHESIVES	PRIMERS
<b>TEXTILES (NYLON, POLYESTER)</b>	233 402X	—
<b>PHOSPHATIZED STEEL</b>	213 250X 6250 252X 253X 6100 TY-PLY BN 607 608 8560S 8210	205 207 8007
<b>STAINLESS STEEL</b>	250X 6250 252X 6100 8560S 607 608 TY-PLY BN	205 207 8007
<b>ZINC DICHROMATED METALS</b>	250X 6250 252X 6100 8560S	205 207

### 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 bulletin 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 Service Department.

Information provided herein is based upon tests believed to be reliable. Inasmuch 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.

For additional information, contact Lord Corporation at: 800-CHEMLOK (800-243-6565), FAX: 814/864-3452 or write: **Lord Corporation, Chemical Products, 2000 West Grandview Blvd., P.O. Box 10038, Erie, PA 16514-0038.**

**LORD Chemical Products**

A Division of Lord Corporation