CHEMLOK®
Adhesives

SELECTOR GUIDE

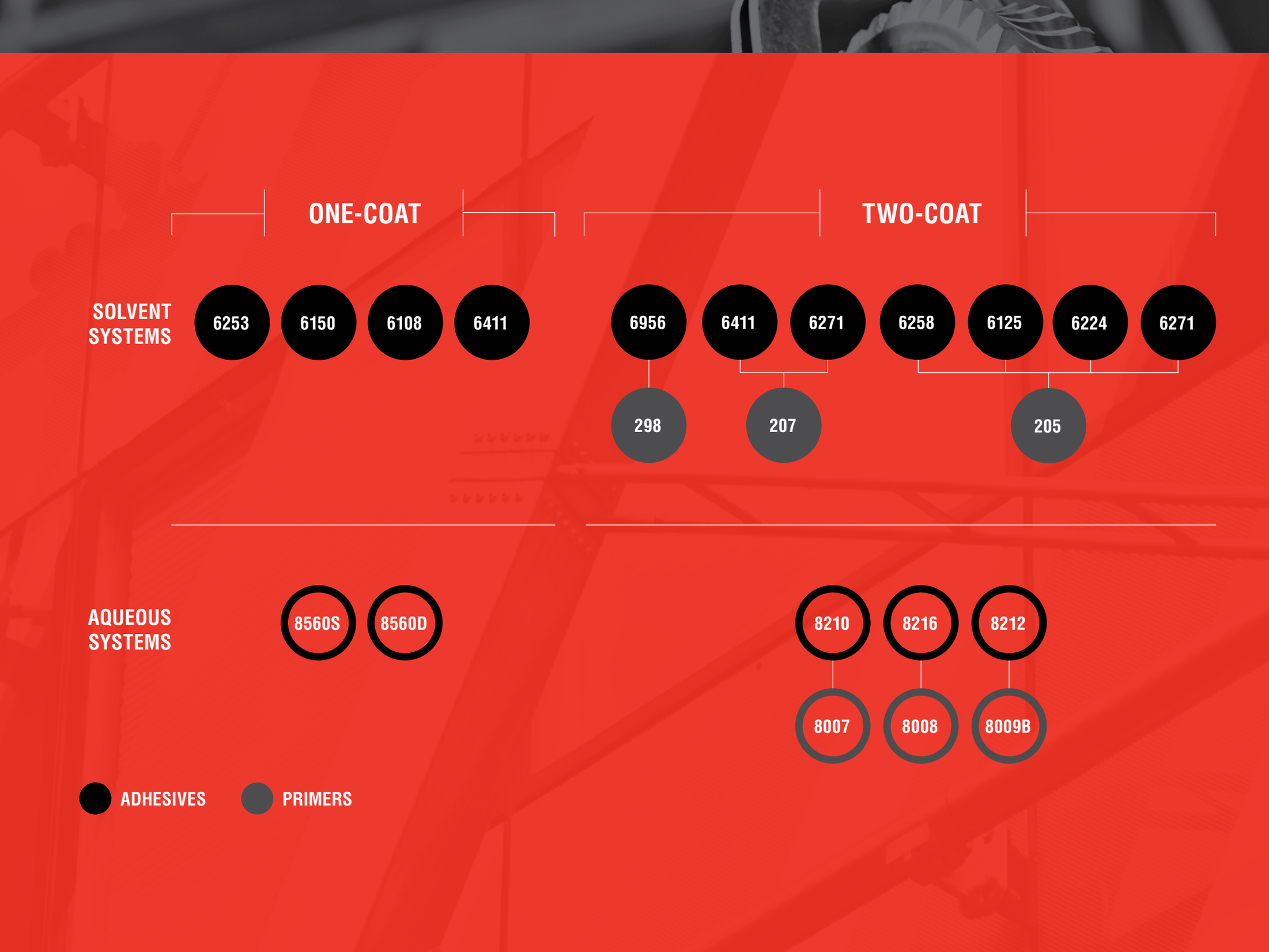
For over 60 years, Chemlok® Adhesives have been providing high performance rubber-to-metal bonds that reduce risk and improve processes in industries like automotive, power generation, civil engineering, oil and gas, and industrial applications. Whatever your challenge, we can help.

That's what makes Chemlok the ultimate in elastomer bonding. It's built on technology with generations of proven performance and delivered with uncompromising quality, service and performance.

LORD

GENERAL ELASTOMER SOLUTIONS

Typically the first choice for a bonding element is an elastomer. The type and details of its formulation will be based on the elastomer's intended function. Natural rubber and many synthetic elastomers make up the range of rubber polymers available. Things to consider when selecting an elastomer are performance requirements of the part, ease of mixing, processing and molding.


ONE-COAT
TWO-COAT
SOLVENT SYSTEMS
6253
6150
6108
6411
6956
6411
6271
6258
6125
6224
6271
298
207
205
AQUEOUS SYSTEMS
8560S
8560D
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8212
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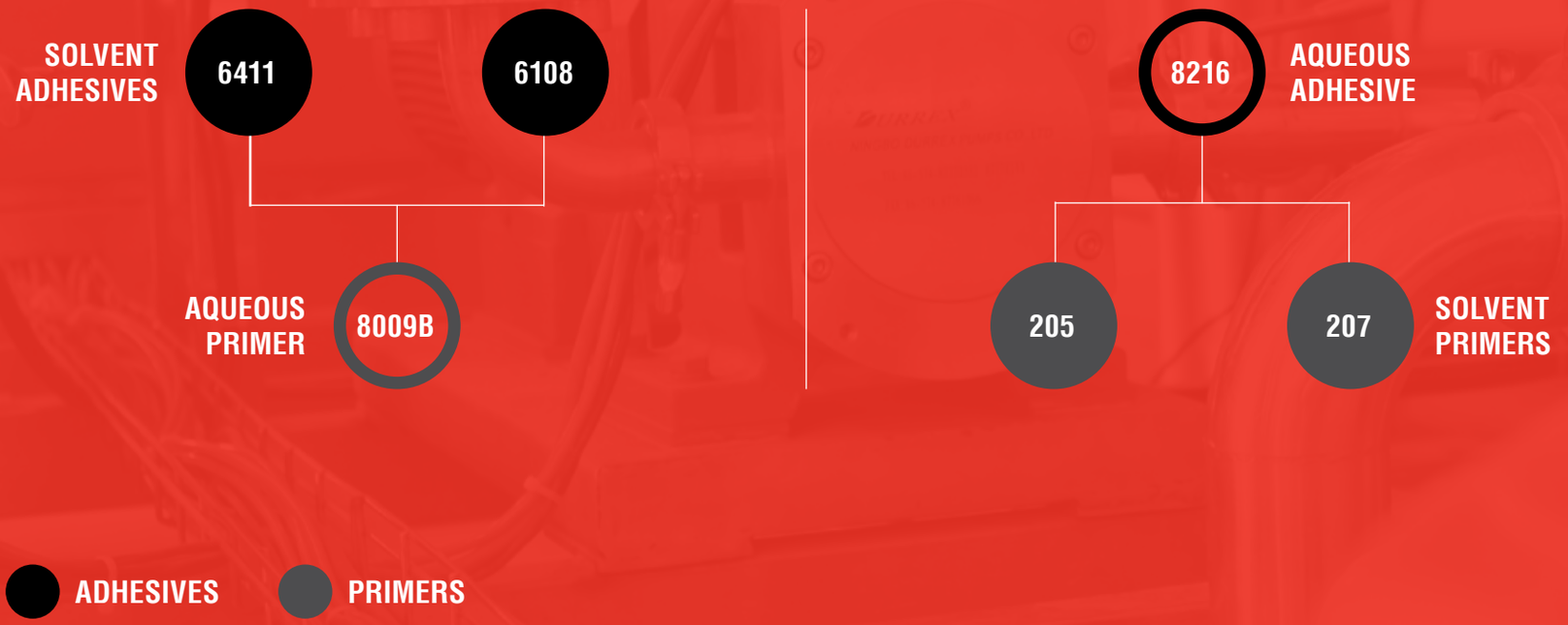
8009B
ADHESIVES
PRIMERS

GENERAL ELASTOMER HYBRID SOLUTIONS

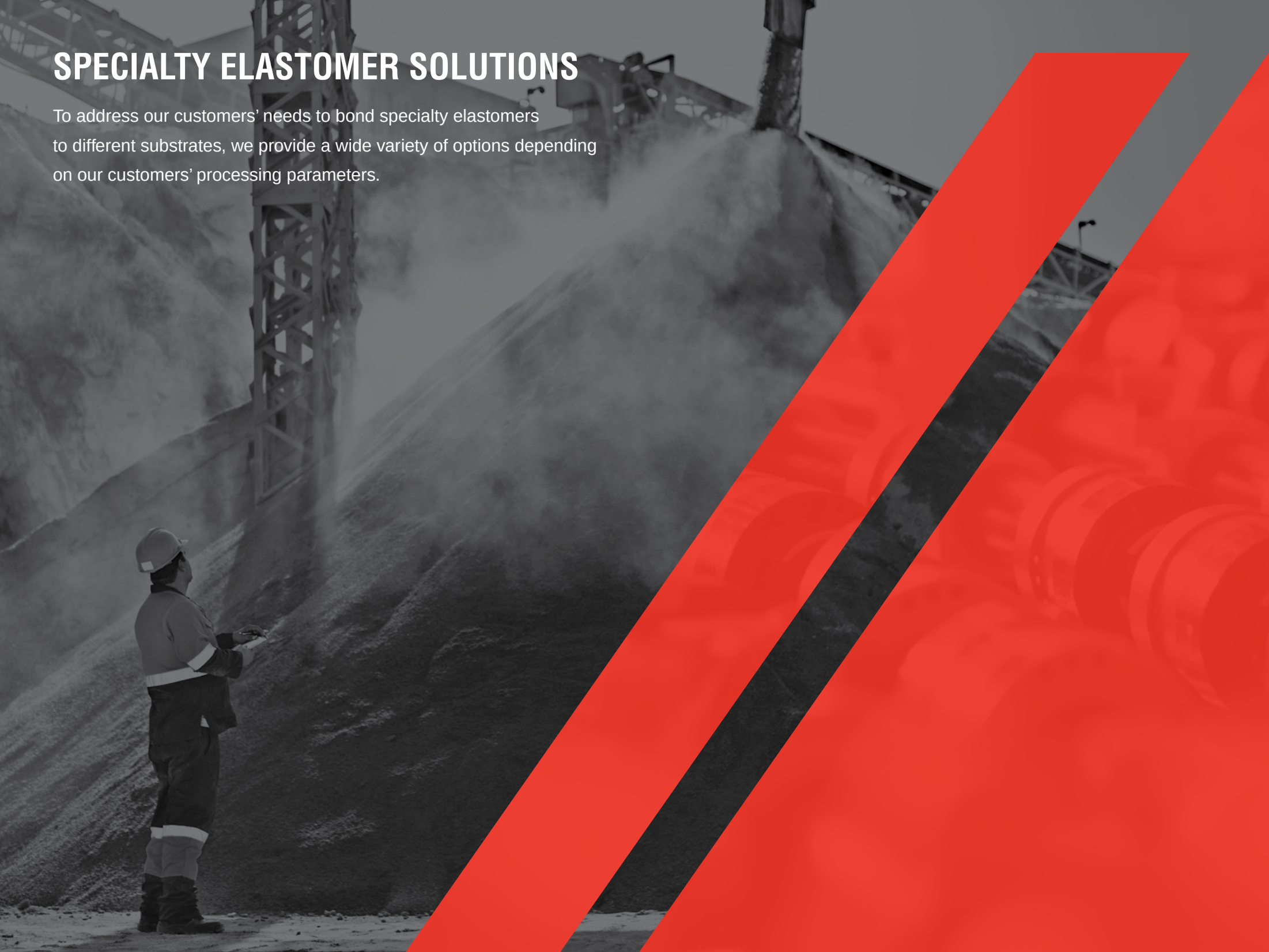
When you need an environmentally friendly adhesive that will bond a variety of natural and synthetic elastomers to primed metal, but don't have the resources to switch over to a fully aqueous system, look to our hybrid solutions. These environmentally friendly options will also bond cold-rolled steel, phosphatized steel, aluminum and other various substrates with the same level of performance that you have learned to trust.

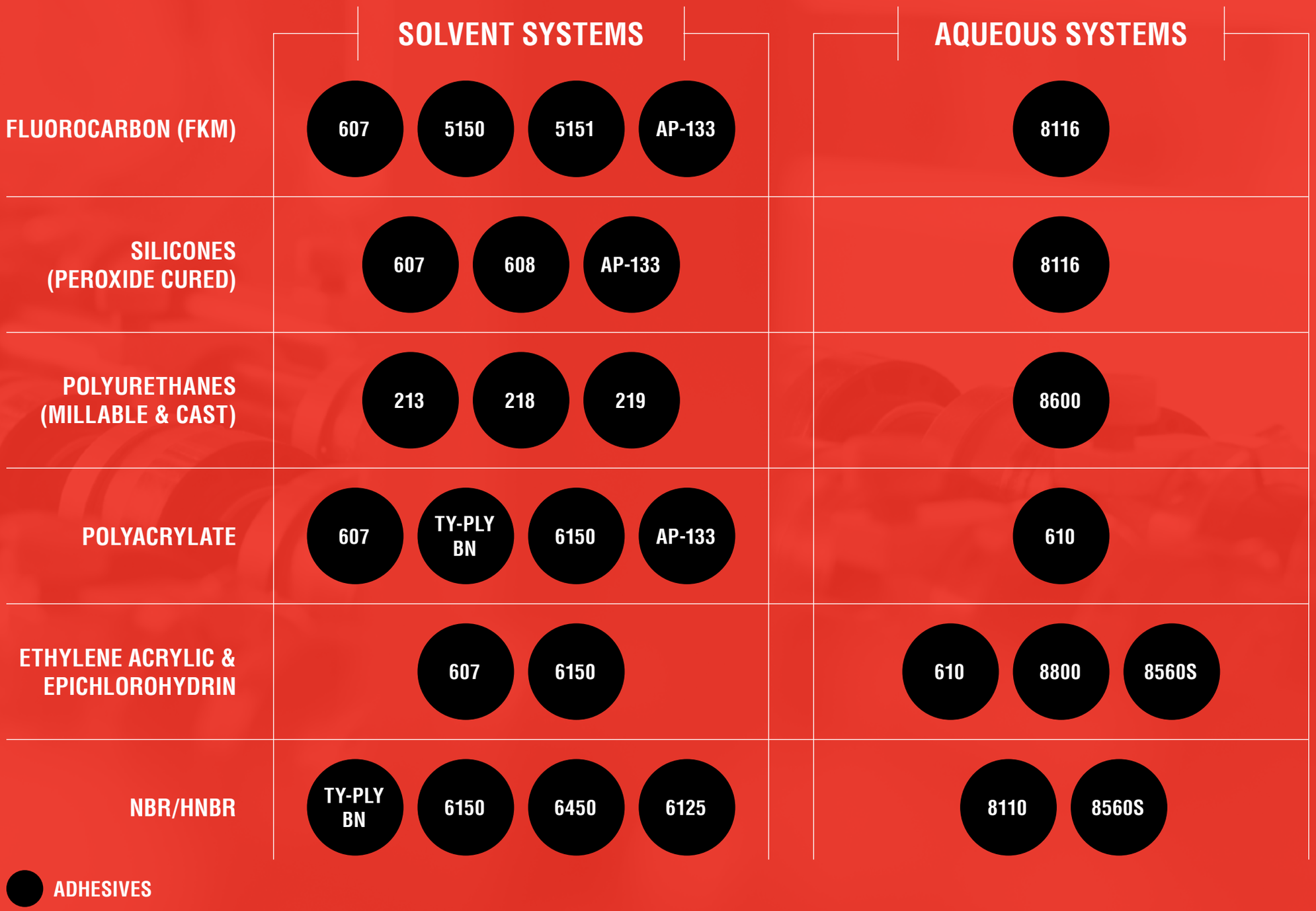
TWO-COAT SYSTEMS



SPECIALTY ELASTOMER SOLUTIONS

To address our customers' needs to bond specialty elastomers to different substrates, we provide a wide variety of options depending on our customers' processing parameters.




SOLVENT SYSTEMS
AQUEOUS SYSTEMS
FLUOROCARBON (FKM)
607
5150
5151
AP-133
8116
SILICONES (PEROXIDE CURED)
607
608
AP-133
8116
POLYURETHANES (MILLABLE & CAST)
213
218
219
8600
POLYACRYLATE
607
TY-PLY BN
6150
AP-133
610
ETHYLENE ACRYLIC & EPICHLOROHYDRIN
607
6150
610
8800
8560S
NBR/HNBR
TY-PLY BN
6150
6450
6125
8110
8560S
ADHESIVES

		APPLICATION METHODS		PERFORMANCE ATTRIBUTES									COMPATIBLE PRIMERS			
	CHEMLOK	SPRAY	DIP	MOLD FOUL	BOILING WATER	SALT SPRAY	PRE-BAKE	HEAT AGE	ELASTOMER ROBUSTNESS	LAYOVER	SWEEP	ONE-COAT	VOC FRIENDLY	205	207	8009	298
SOLVENT SOLUTIONS	6150	●	●	◉	●	●	◉	●	●	●	●	●	○	◉	●	●	●
	6125	●	●	●	●	●	◕	●	●	●	●	◕	○	◉	◕	●	◉
	6411	●	●	◉	●	●	●	●	●	●	●	◉	○	◉	●	●	●
	6108	●	●	◕	●	●	●	●	●	●	●	●	○	◉	●	●	●
	6253	●	●	◉	●	●	◉	●	●	●	●	◉	○	◉	●	●	◉
	6258	●	●	◕	●	●	●	●	●	●	●	○	◕	●	●		
	6956	●	◉	●	●	●	●	●	◉	●	●	◉	○	◉	●	●	●
	TY-PLY BN	●	●	●		●	●	●	◕	●	◕	●	○				
	607	●	●	●	◉	●	●	●	◕	◕	●	●	○				
AQUEOUS SOLUTIONS	8560S	●	◕	◉	●	●	●	●	●	●	●	●	●	◉	●	●	
	8560D	◕	●	◉	●	●	●	●	●	●	●	●	●	◉	●	●	
	8116	●	◕	●	●	●	●	●	◕	●	◕	●	●	◉	●	●	
	8110	●	◉	●	●	●	●	●	◕	●	●	●	●				
	610	●	●	●		●	●	●	◕	◕	●	●	●				

● EXCELLENT ◉ GOOD ◕ FAIR ○ NOT RECOMMENDED

Choose your adhesive by the type of elastomer to be bonded. Refer to the Elastomer Bonding Guide within this document to make the correct selection. Also consider surface preparation; cure cycles; required environmental and chemical resistance; part geometry; color and conductivity requirements; and application methods which also affect the primer and adhesive choice. This guide lists the most common primers and adhesives. Contact the LORD Customer Support Center at +1 877 ASK LORD (275 5673) or your local distributor to assist you with selecting the appropriate adhesive for your application.

ELASTOMER BONDING GUIDE

	ADHESIVE	
ELASTOMER	SOLVENT	AQUEOUS
BUTYL (IIR)	6253, 6150, 6411*, 6108*	8560S, 8210*, 8216*
CHLORINATED POLYETHYLENE (CPE)	6253, 6150, 6411*, 6108*	8560S
CHLOROSULFONATED POLYETHYLENE (CSM)	6253, 6150, 6411*, 6108*	8560S
ETHYLENE PROPYLENE DIENE MONOMER (EPDM)	6253, 6150, 238(NW)*, 6411*, 6108*	8560S, 8116**
EPICHLOROHYDRIN (CO)	607, 6150, Ty-Ply BN	8560S
ETHYLENE ACRYLIC	607, 6150, 6125*	610, 8800, 8560S
FLUOROCARBON (FKM)	607, 5150, AP-133	8116**
NATURAL RUBBER (NR)	6253, 6150, 6411*, 6108*, 6125*	8560S, 8210*, 8216*
NITRILE (NBR)	205, Ty-Ply BN, 6150, 6125*	8110, 8116**, 8210*
HYDROGENATED NITRILE (HNBR)	6450, 6254	8560S, 8116**
POLYACRYLATE (ACM)	607, Ty-Ply BN, AP-133, 6150	610
POLYBUTADIENE (BR)	6253, 6150, 6411*, 6108*	8560S
POLYCHROROPRENE (CR)	6253, 6150, 6411*, 6108*	8560S, 8210*, 8216*
POLYISOPRENE (IR)	6253, 6150, 6411*, 6108*	8560S, 8210*, 8216*
POLYURETHANE (CAST AND MILLABLE)	218, 213, 219	8600
PVC	485/44, 489/456	
SILICONE (PEROXIDE CURE)	607, 608, AP-133	8116**
STYRENE BUTADIENE (SBR)	6253, 6150, 6411*, 6108*	8560S, 8210*, 8216*

* For solvent products, Chemlok 205 primer is recommended. For aqueous products, Chemlok 8009B primer is recommended. ** Peroxide cure elastomer

PRIMERS

PRODUCT	DESCRIPTION	COLOR	VISCOSITY, CPS (EXCEPT AS NOTED)	FLASH POINT °C (°F)	DILUENT	SHELF LIFE
144	Solvent-borne primer with UV tracer	Clear, Straw Yellow	1–8 centistokes	1 (35)	Urethane Grade Toluene, Methanol, Ethanol	1 year
205	General purpose primer/nitrile adhesive	Gray	85–165	14 (57)	MIBK, MEK, Xylene	1 year
205LH	Low-HAP Chemlok 205	Blue	10–550	13 (56)	MPK	6 months
206 Blue	General purpose primer/adhesive	Blue	25–250	19 (66)	MIBK, MEK, Xylene	3 months
207	Heat-resistant primer	Gray	70–450	14 (58)	MIBK, MEK	6 months
207LH	Low-HAP Chemlok 207	Blue	50–800	19 (67)	MAK, MPK	6 months
298	High performance primer	Gray	<800	16 (61)	MIBK	6 months
459M	Primer for TPE/TPO/EPDM with UV tracer	Dark Amber	25–30 seconds Zahn #1	9 (48)	—	6 months
459T	Primer for TPE/TPO/EPDM	Straw Yellow	1–15	9 (48)	—	6 months
459X	Primer for TPE/TPO/EPDM	Amber	≈ 10	27 (81)	—	6 months
7701	Solvent-based surface treatment	Clear to Cloudy	—	-4 (25)	—	6 months
8006	Environmentally resistant, aqueous primer	Gray	15–100	>93 (>200)	Deionized Water	6 months
8007 Blue	General purpose primer	Blue	15–250	>93 (>200)	Deionized Water	3 months
8008	Aqueous primer	Green	10–150	>93 (>200)	Deionized Water	6 months
8009	Aqueous primer	Gray	10–100	>93 (>200)	Deionized Water	6 months
8009B	Aqueous primer	Blue	10–100	>93 (>200)	Deionized Water	6 months
AP-131	Solvent-borne primer	Colorless to Slightly Yellow	0–5 centistokes	2.8 (37)	Toluene, Methanol, Ethanol	1 year
AP-134	Solvent-borne primer	Clear, Straw Yellow	0–8 centistokes	1 (35)	—	1 year
EP5080-11	Clear Chemlok 205 primer/nitrile adhesive	Hazy Amber	28–35 seconds Zahn #1	15 (59)	MEK, MIBK	1 year

ONE-COAT SYSTEMS

PRODUCT	DESCRIPTION	COLOR	VISCOSITY, CPS (EXCEPT AS NOTED)	FLASH POINT °C (°F)	DILUENT	SHELF LIFE
213	Urethane-to-metal adhesive	Blue	100–300	5 (41)	Chemlok 248	1 year
217	Adhesive for polychloroprene and nitrile elastomers	Black	75–150	-2 (28)	MEK/Xylene Mix	1 year
218	General purpose adhesive	Clear to Slightly Hazy Amber	750–1050	2 (36)	1:1 Isopropanol: Toluene Blend or Glycol Ether Solvents	1 year
219	Primer/castable urethane and TPU adhesive	Clear to Amber	50–110	14 (58)	MIBK, Denatured Ethanol	1 year
402	Rubber-to-textile adhesive	Black	100–350	34.3 (93.7)	Xylene, Toluene	6 months
402X-HS	All-xylene Chemlok 402	Black	600–1100	25 (77)	Xylene	6 months
485/44	Clear, two-part adhesive for bonding PVC	Clear to Amber/ Transparent Brown	400–1000/<10	-4 (24)/29 (85)	Xylene	1 year/1 year
487 A/B	Clear, two-part adhesive for bonding TPE	Clear to Yellow/Clear to Cloudy	100–350/1–10	27 (81)/15 (60)	Xylene, Toluene	1 year/1 year
489/456	Fluorescing, two-part adhesive for bonding PVC	Clear to Amber/Light Amber	80–195/<25	16 (61)/27 (81)	Xylene, Toluene	1 year/1 year
607	Adhesive for silicone/specialties	Clear to Slightly Yellow	—	9 (49)	Methanol, Ethanol	2 years
608	Adhesive for silicone	Clear to Hazy Yellow	—	3 (38)	Methanol	2 years
610	Aqueous, specialty elastomer adhesive	Orange to Red	—	>93 (>200)	Deionized Water	2 years
5150	Adhesive for bonding fluoroelastomers to metal	Colorless to Pale Yellow	≈ 2 centistokes	6 (43)	Methanol, Ethanol	1 year
5151	Adhesive for fluoroelastomers	Reddish-yellow	25–30 seconds Zahn #1	-5 (22)	MEK	6 months
6016	Low-lead Chemlok 253	Black	35–100 seconds Zahn #3	27 (81)	Xylene, Toluene	1 year
6150	Adhesive for metal and plastics	Black	200–1000	27 (81)	Xylene	6 months
6250	Low-lead Chemlok 250	Black	100–550	27 (81)	Technical Grade Xylene, Toluene	6 months
6253	Low-lead Chemlok 253	Black	25–85 seconds Zahn #3	27 (81)	Xylene, Toluene	6 months
6254	Heat- and oil-resistant adhesive	Black	150–450	7 (44)	Xylene, Toluene	6 months
6260	Non-black Chemlok 6254	Brown	100–600	6 (44)	Xylene, Toluene	6 months
6450	High-temperature adhesive for HNBR/NBR	Green-Black	5–100	0 (32)	MEK, Xylene	6 months
6451	High-temperature adhesive for HNBR/NBR	Green-Black	5–100	-7 (18)	MEK, Xylene	6 months
8110	Aqueous adhesive for nitrile	Black	<100	>93 (>200)	Deionized Water	6 months
8116	Aqueous adhesive	Black	100–900	>93 (>200)	Deionized Water	6 months
8560D	General purpose, aqueous adhesive	Black/Green	100–500	>93 (>200)	Deionized Water	3 months
8560S	General purpose, aqueous adhesive	Black	50–250	>93 (>200)	Deionized Water	3 months
8600	Aqueous adhesive for castable urethane	White	200–600	>93 (>200)	Deionized Water	6 months
AP-133	Adhesive for silicone/specialties	Clear	≈ 5 centistokes	14 (57)	Toluene, Methanol, Ethanol	1 year
EP6804-22	Conductive, one-coat adhesive	Black	50–250	9 (48)	Toluene, Xylene	6 months
TY-PLY BN	Adhesive for nitrile	Black	20–35 seconds FORD Cup #3	5 (42)	MEK, MIBK, Dry Alcohols	1 year
Y-1540	Adhesive for silicone/specialities	Red	≈ 3	9.4 (49)	Methanol, Ethanol	6 months
Y-1520A	Adhesive for silicone/specialities	Clear	<10 centistokes	11 (52)	Methanol, Ethanol	1 year
TS701-43	Clear Chemlok 217	Translucent Amber	60–150	-2 (28)	MEK	1 year

ADDITIVES/SOLVENTS

PRODUCT	DESCRIPTION	COLOR	VISCOSITY, CPS (EXCEPT AS NOTED)	FLASH POINT °C (°F)	DILUENT	SHELF LIFE
248	Thinner for Chemlok 213	Blue	Water Thin	3 (37)	MEK, Xylene, Acetates	1 year
EP5081-40	Flourescing additive for clear Chemlok adhesives	Clear	—	11 (52)	—	1 year

TWO-COAT SYSTEMS

PRODUCT	DESCRIPTION	COLOR	VISCOSITY, CPS (EXCEPT AS NOTED)	FLASH POINT °C (°F)	DILUENT	SHELF LIFE
234B (NW)	General purpose adhesive	Black	700–1500	28 (83)	Xylene, Trichloroethylene	1 year
234X (NW)	General purpose adhesive	Black	400–1000	27 (81)	Xylene	1 year
236A	General purpose adhesive	Black	300–700	22 (71)	Xylene, Toluene	1 year
236X	General purpose adhesive	Black	125–500	30 (86)	Xylene, Toluene	1 year
238 (NW)	Adhesive for butyl and EPDM	Black	150–800	33 (92)	Xylene	1 year
286	Tacky tie cement for natural rubber	Black	450–1200	4 (40)	Xylene, Toluene	6 months
289	Primer for natural rubber lining	Green	200–450	6 (42)	MEK/Xylene Mix	1 year
290	Adhesive for natural rubber lining	Red	20–50	7 (44)	Xylene, Toluene	1 year
2100/2101	Low VOC tank lining primer/adhesive system	Blue/Black	150–450/175–500	1.1 (34)/7 (44)	Xylene, MEK/Toluene	6 months/6 months
2332	General purpose adhesive	Black	100–300	27 (81)	Xylene	9 months
6100	Low-lead Chemlok 252X	Black	350–700	27 (81)	Xylene, Toluene	1 year
6108	Low-lead Chemlok 252H	Black	300–1000	27 (81)	Xylene, Toluene	1 year
6125	Improved heat-resistant Chemlok 220	Black	70–200	27 (81)	Xylene, Toluene	1 year
6220	Low-lead Chemlok 220	Black	100–300	27 (81)	Xylene, Toluene	1 year
6224	High performance adhesive	Black	100–300	27 (81)	Xylene	1 year
6225	Low-lead Chemlok 225X	Black	25–80 seconds Zahn #2	27 (81)	Xylene, Toluene	1 year
6254	Heat- and oil-resistant adhesive	Black	150–450	7 (44)	Xylene, Toluene	6 months
6258	Low-lead, hard film Chemlok 252X	Black	25–45 seconds Zahn #3	5 (41)	Xylene, Toluene	1 year
6271	High performance adhesive	Black	350–600	27 (81)	Xylene	9 months
6411	Low-lead adhesive	Black	200–600	25 (77)	Xylene, Toluene	1 year
6411LH	Low-HAP Chemlok 6411	Black	100–700	14 (58)	N-Butyl Propionate, Dimethyl Carbonate, Isopar E	6 months
6450	High-temperature adhesive for HNBR/NBR	Green-Black	5–100	0 (32)	MEK, Xylene	6 months
6451	High-temperature adhesive for HNBR/NBR	Green-Black	5–100	-7 (18)	MEK, Xylene	6 months
6956	High performance adhesive	Black	300	16 (61)	Xylene	6 months
8210	Aqueous adhesive	Black	200–500	>93 (>200)	Deionized Water	6 months
8212	Aqueous adhesive	Black	5–100	>93 (>200)	Deionized Water	6 months

ISN'T NATURE BEAUTIFUL?

At LORD, we're constantly innovating new solutions to reduce our customers' carbon footprint. Our goal is to ensure our planet will be just as beautiful for future generations.

Not only are our Environmentally-Preferred Chemlok® Adhesives better for the environment, these adhesives perform at the same high quality you expect from the Chemlok brand. Whether your application requirements call for withstanding high temperatures or harsh environments — When it's critical, it's Chemlok.

Change is the only constant. Our team of experts strive to push the technical boundaries in order to provide you with tomorrow's solutions today. Our solutions have been successfully deployed for years across a wide range of industries. From the cars you drive to the tractor harvesting crops to put food on your table, you can depend on Chemlok Adhesives.

Values stated herein represent typical values as not all tests are run on each lot of material produced.
For formalized product specifications or 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.

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