



CHEMLOK[®]
Adhesives

When it's critical,
it's Chemlok.

CHEMLOK 6108

LORD Chemlok[®] 6108 adhesive is a covercoat adhesive used to bond a variety of elastomers to various metals. It is composed of a mixture of polymers, organic compounds and mineral fillers dissolved or dispersed in an organic solvent system.

Chemlok 6108 adhesive is a non-chlorinated solvent adhesive that provides strong resistance to harsh environments.

ADVANTAGES

Versatile – Bonds a variety of elastomers and metals when used in combination with Chemlok 205 or 207 primer.

Non-Chlorinated Solvent System – Suitable for solvent incineration.

Environmentally Resistant – Provides superior resistance to heat, oils and salt spray.

PRODUCT INFORMATION*

Appearance	Black Liquid
Viscosity, cps @ 25°C (77°F) Brookfield LVT Spindle 2, 30 rpm	300–1000
Density kg/m ³ (lb/gal)	950.0–1000.0 (7.9–8.3)
Solid Content by Weight, %	22–26
Flash Point (Seta), °C (°F)	27 (81)
Solvents	Xylene

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

ELASTOMERS

- Natural Rubber (NR)
- Polyisoprene (IR)
- Styrene-butadiene (SBR)
- Polybutadiene (BR)
- Polychloroprene (CR)
- Nitrile (NBR)
- Butyl (IIR)
- EPDM Polymers

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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.

Allow primer to thoroughly dry before applying Chemlok 6108 adhesive.

For further detailed information on surface preparation of specific substrates, refer to Chemlok Adhesives application guide.

Mixing

Thoroughly stir adhesive before use, and agitate sufficiently during use to keep dispersed solids uniformly suspended. If dilution is needed, use xylene or toluene.

Applying

Apply adhesive by spray, brush or dip methods.

Regardless of application method, the dry film thickness of Chemlok 6108 adhesive should be 17.8-25.4 micron (0.7-1.0 mil).

Curing

Chemlok 6108 adhesive cures during the rubber vulcanization process.

Cleanup

Use solvents such as xylene and MEK to remove adhesive before heat is applied. Once cured, removal by solvent is not possible.

SHELF LIFE/STORAGE

Shelf life is one year from date of shipment when stored 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.

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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