



CHEMLOK[®]
Adhesives

When it's critical,
it's Chemlok.

CHEMLOK 6253

LORD Chemlok[®] 6253 adhesive is a one-coat 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 6253 adhesive provides excellent resistance to harsh environments while offering strong prebake resistance.

ADVANTAGES

Versatile – Bonds a variety of elastomers and can be used over Chemlok 205 or 207 primer for maximum protection or when environmental conditions are severe.

Easy to Apply – Applies easily by spray, dip or brush methods.

Convenient – Requires only a single coat for most applications, reducing labor, solvent usage, inventory and shipping costs; contains higher solids content, allowing for greater square footage coverage per gallon used.

Environmentally Resistant – Provides excellent resistance to various elements.

Process Compatible – Accommodates a wide range of processing conditions at moderate temperatures, including extended prebake.

PRODUCT INFORMATION*

Appearance	Black Liquid
Viscosity, cps @ 25°C (77°F) Brookfield LVT Spindle 2, 30 rpm	250–800
Density kg/m ³ (lb/gal)	1006.5–1054.5 (8.4–8.8)
Solid Content by Weight, %	28.5–32.5
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.

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 brush, spray, dip or any other method that gives a uniform coating and avoids excessive runs and tears.

When using Chemlok 6253 adhesive as a one-coat adhesive, the dry film thickness should be 20.3-25.4 micron (0.8-1.0 mil). When used as a covercoat over a primer, the dry film thickness of Chemlok 6253 adhesive should be 15.2-20.3 micron (0.6-0.8 mil).

Curing

Chemlok 6253 adhesive cures during the rubber vulcanization process.

SHELF LIFE/STORAGE

Shelf life is six months 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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