

# Chemlok® 8110 Adhesive

## Technical Data Sheet

Chemlok® 8110 adhesive is a one-coat, water-based adhesive that bonds nitrile (NBR) elastomers to metal during vulcanization. It is composed of a mixture of dispersed mineral fillers, organic compounds, resins and polymer latexes in an aqueous medium.

With good resistance to hot oils and transmission fluids, Chemlok 8110 adhesive is suitable for use in the manufacture of gaskets and seals such as shaft seals. It can also be used to bond polyacrylic elastomers to metal.

### Features and Benefits:

**Versatile** – bonds a variety of NBR compounds and polyacrylic elastomers.

**Environmentally Preferred** – uses water for dilution; provides reduced VOC emissions.

**Environmentally Resistant** – provides good resistance to high temperature fluid environments; excellent for use in gaskets or seals.

### Elastomers:

- Nitrile (NBR)
- Polyacrylate (ACM)

### Application:

**Surface Preparation** – Thoroughly clean metal surfaces prior to 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 mix adhesive before use. Do not shake. To prevent foaming, mechanical mixing should not exceed 30 rpm. The addition of anti-foaming agents is not recommended.

If dilution needed, use deionized water at a ratio of 1:1, by volume. More dilute solutions can be used if necessary. Slowly add water while mixing.

**Applying** – Apply adhesive by dip or spray methods. For best results, preheat the metal parts to 49-60°C (120-140°F) prior to spray application.

Regardless of application method, the dry film thickness of Chemlok 8110 adhesive should be 5.1-10.2 micron (0.2-0.4 mil).

### Typical Properties\*

Appearance	Black Liquid
Viscosity, cps @ 25°C (77°F) Brookfield LVT Spindle 1, 60 rpm	< 100
Density kg/m <sup>3</sup> (lb/gal)	1114.4-1174.3 (9.3-9.8)
Solids Content by Weight, %	32-36.5
Flash Point (Seta), °C (°F)	>93 (>200)
Solvents	Deionized Water
pH	6-7

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



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**Drying/Curing** – Allow coated parts to air-dry for at least 60 minutes at room temperature prior to bonding. Drying can be accelerated by oven drying at 49-71°C (120-160°F).

Chemlok 8110 adhesive cures during the rubber vulcanization process.

**Cleanup** – Use soap and water to remove wet adhesive. Remove dried adhesive with solvents such as acetone, MEK or isopropyl alcohol.

## Shelf Life/Storage:

Shelf life is six months from date of shipment when stored by the recipient in a well ventilated area at 21-27°C (70-80°F) in original, unopened container. Do not freeze product.

## Cautionary Information:

Before using this or any Parker 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 document 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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