

Chemlok® 252H Adhesive

Technical Data Sheet

Chemlok® 252H adhesive is a high solids, one-coat adhesive that bonds rubber compounds to metal. It is composed of a mixture of polymers, organic compounds and mineral fillers dissolved or dispersed in an organic solvent system.

Features and Benefits:

Versatile – bonds a variety of elastomers to metals, including carbon and alloy steels, stainless steel, aluminum, magnesium, zinc, copper and copper alloys.

Convenient – requires only a single coat for most applications, reducing labor, solvent usage, inventory and shipping costs.

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

Non-Chlorinated Solvent System – suitable for solvent incineration, saving cost of recovery equipment.

Elastomers:

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

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.

Apply Chemlok 252H adhesive to stainless steel, aluminum, brass or other nonferrous substrates within one-half hour after cleaning. For ferrous substrates such as steel, a longer layover can be tolerated if no rust is formed.

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 toluene or xylene. Note proper dilution for the various application methods is best achieved by experience. Give careful attention to agitation since dilution will accelerate settling.

Applying – Apply adhesive by brush, dip or spray methods.

Regardless of application method, the dry film thickness of the Chemlok 252H adhesive should be 17.8-33.0 micron (0.7-1.3 mil).

Curing – Chemlok 252H adhesive cures during the rubber vulcanization process.

Typical Properties*

Appearance	Black Liquid
Viscosity cps @ 25°C (77°F) Brookfield LVT Spindle 2, 30 rpm seconds Zahn Cup #4	500 - 2000 40 - 110
Density kg/m ³ (lb/gal)	970.6 - 1018.5 (8.1 - 8.5)
Solids Content by Weight, %	26 - 30
Flash Point (Seta), °C (°F)	9 (48)
Solvents	Toluene, Xylene

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



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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 nine months from date of shipment when stored by the recipient 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 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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