

Chemlok® 8216 Adhesive

Technical Data Sheet

Chemlok® 8216 adhesive is a water-based covercoat adhesive that bonds a variety of elastomers to primed metal. It is composed of a mixture of dispersed fillers, resins and latices in aqueous medium.

Chemlok 8216 adhesive is recommended for spray application over Chemlok 8008 or 8009 water-based primer.

Features and Benefits:

Versatile – when used in combination with Chemlok water-based primer, bonds a variety of natural and synthetic elastomers to primed metal; adhesive system also bonds cold rolled steel, phosphatized steel, aluminum and other various substrates.

Process Compatible – works well in injection and transfer molding applications; provides excellent prebake resistance.

Environmentally Preferred – uses water for cleanup while adhesive is still wet, eliminating the need for significant solvent inventory.

Environmentally Resistant – provides excellent resistance to hostile environments including salt water and heat.

Easy to Use – ready to use directly out of the container without dilution; not prone to hard settling; easily redispersed.

Elastomers:

- Natural Rubber (NR)
- Styrene-butadiene (SBR)
- Nitrile (NBR)
- Butyl (IIR)

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.

Allow primer to thoroughly dry before applying Chemlok 8216 adhesive.

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

Mixing – Thoroughly mix adhesive before using over the primer. To prevent foaming, mechanical mixing should not exceed 30 rpm. Take care during handling and transfer to avoid foaming. The addition of anti-foaming agents is not recommended.

In most cases, dilution is not required. Deionized water is suggested if dilution is necessary. Add water gradually while stirring either by hand or by using another low-shear mixing method.

Applying – Apply adhesive by spray methods. For best results, preheat the metal parts to 65°C ± 10°C (149°F ± 18°F) prior to spray application.

Dry film thickness of Chemlok 8216 adhesive should be 15.2-20.3 micron (0.6-0.8 mil).

Curing – Chemlok 8216 adhesive cures during the rubber vulcanization process.

Typical Properties*

Appearance	Brownish-green Liquid
Viscosity, cps @ 25°C (77°F) Brookfield LVT Spindle 2, 30 rpm	5-100
Density kg/m ³ (lb/gal)	1100-1150 (9.18-9.60)
Solids Content by Weight, %	30-34
Flash Point (Seta), °C (°F)	94 (201)
Solvents	Deionized Water

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



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Cleanup – Use warm soapy water to clean equipment or parts. Remove dried adhesive with solvents such as xylene or toluene.

Shelf Life/Storage:

Shelf life is six months from date of manufacture 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. Avoid prolonged storage in higher temperatures.

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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