

## Chemlok® 6220 Adhesive (fka Chemlok 220NL)

### Description

Chemlok® 6220 adhesive is a general-purpose covercoat designed for use over Chemlok 205 primer. This adhesive system will bond a variety of uncured elastomers such as SBR, natural, nitrile and neoprene to metal substrates during the vulcanization of the elastomer.

### Features and Benefits

**Versatility** – bonds a variety of elastomers and metals when used in combination with Chemlok 205 primer.

**High Temperature Resistance** – provides excellent heat resistance at exposure temperatures as high as 150°C (300°F).

**Environmental Resistance** – provides superior resistance to heat and salt spray.

**Low Lead** - reduces substantially the levels of heavy metals.

### Surface Preparation

Substrate surfaces must be free of debris and organic contaminants to ensure good adhesion. An effective and common cleaning method is grit blasting followed by solvent degreasing. Grit blasting removes coarse imperfections like scale and rust while vapor degreasing removes grease, oil, and other organic contaminants. Another effective and widely used surface treatment is zinc phosphatizing, a multi-step conversion coating process. Both of these surface preparation methods improve adhesion by increasing the surface area of the substrate as well as cleaning it. Handle clean metals with clean gloves to avoid contamination with skin oils.

### Typical Properties\* of Chemlok 6220 Adhesive

Composition	A mixture of polymers, organic compounds, and mineral fillers dissolved or dispersed in an organic solvent system.
Appearance	Black Liquid
Non-volatile Content by weight	25.5 - 29.5%
Density Kgs/m <sup>3</sup> lbs/gal	971 - 995 8.1 - 8.3
Viscosity, cps Brookfield LVT spindle #2, 30 rpm, 25°C (77°F)	100 - 300
GE Zahn #2 Cup	45 - 90 seconds
Flash Point (Seta)	26.7°C (80°F)
Solvents	Xylene, Ethyl Benzene
Shelf Life	Six months from date of shipment, unopened container, 21°C - 27°C (70°F - 80°F) storage temperature.

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

## Premixing

Allow the Chemlok 205 primer to thoroughly dry before applying Chemlok 6220 adhesive. For further details on the use of Chemlok 205, please consult the Chemlok 205 product bulletin.

Shake or stir Chemlok 6220 adhesive for at least 15 minutes before applying the adhesive over the Chemlok 205 primer. Chemlok 6220 adhesive can also be rolled overnight to ensure complete and thorough mixing of the ingredients.

## Application

Apply Chemlok 6220 adhesive by brushing, dipping, or spraying.

- *Brushing*  
Apply undiluted; avoid excessive brushout.
- *Dipping or spraying*  
Dilute Chemlok 6220 adhesive with xylene or toluene to a viscosity adequate for ensuring proper adhesive film thickness, 12.7 - 17.8 microns (0.5 - 0.7 mils).

For optimum adhesion and environmental resistance, use the following dry film thicknesses of Chemlok 205 primer and Chemlok 6220 adhesive:

Chemlok 205	7.6 - 12.7 microns (0.3 - 0.5 mils)
Chemlok 6220	12.7 - 17.8 microns (0.5 - 0.7 mils)

Values stated in this bulletin 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 Service Department.

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Avoid contamination of coated parts with dirt, oil, grease. Wear clean cotton gloves if direct contact with the coated surface is unavoidable.

## Curing

Chemlok 6220 adhesive can be used in injection, transfer, and compression molding applications. Ideal molding conditions involve a minimum amount of time between loading the adhesive coated parts and elastomer vulcanization. However, Chemlok 6220 adhesive will resist moderate prebake times without affecting bond performance.

Chemlok 6220 adhesive dries to a hard, non-tacky surface which allows for handling and storage. Accelerated solvent evaporation can be accomplished with elevated temperatures. Avoid temperatures in excess of 93°C (200°F).

## Clean Up

Use xylene, toluene, acetone or ketones for clean up.

## Packaging

- 5 Gallon Pail (19 Liter)
- 55 Gallon Drum (208 Liter)

## Storage

Store Chemlok 6220 adhesive away from heat and flames.

## Cautionary Information

Before using this or any Lord product, refer to the Material Safety Data Sheet (MSDS) and label for safe use and handling instructions. In the event of potential conflict, the information contained in the MSDS and label prevails over the information provided herein.

*For industrial/commercial use only.* Must be applied by trained personnel only. Not to be used in household applications. Not for consumer use.

For additional information, contact Lord Corporation at: 814/868-3611 extension 3211, FAX: 814/864-3452 or write: **Lord Corporation, Chemical Products, 2000 West Grandview Blvd., P.O. Box 10038, Erie, PA 16514-0038**

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