



CHEMLOK[®]
Adhesives

When it's critical,
it's Chemlok.

CHEMLOK 6220

LORD Chemlok[®] 6220 adhesive is a covercoat adhesive that bonds a wide variety of elastomers to metal substrates. It is composed of a mixture of polymers, organic compounds and mineral fillers dissolved or dispersed in an organic solvent system.

Chemlok 6220 adhesive provides excellent heat resistance while offering superior resistance to salt spray and corrosive atmospheres.

ADVANTAGES

Versatile – Bonds a variety of elastomers and metals when used in combination with Chemlok 205 primer.

High Temperature Resistant – Provides excellent heat resistance at exposure temperatures as high as 149°C (300°F).

Environmentally Resistant – Provides superior resistance to heat and salt spray.

PRODUCT INFORMATION*

Appearance	Black Liquid
Viscosity, cps @ 25°C (77°F) Brookfield LVT Spindle 2, 30 rpm	100–200
Viscosity, seconds Zahn Cup #2	45–90
Density kg/m ³ (lb/gal)	970.0–990.0 (8.1–8.3)
Solid Content by Weight, %	25.5–29.5
Flash Point (Seta), °C (°F)	27 (81)
Solvents	Xylene

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

ELASTOMERS

- Natural Rubber (NR)
- Styrene-butadiene (SBR)
- Polychloroprene (CR)
- Nitrile (NBR)

LORD

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.

Allow primer to thoroughly dry before applying Chemlok 6220 adhesive.

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. 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 Chemlok 6220 adhesive should be 12.7-17.8 micron (0.5-0.7 mil).

Curing

Chemlok 6220 adhesive cures during the rubber vulcanization process.

Cleanup

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

SHELF LIFE/STORAGE

Shelf life is one year 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 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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