

# Chemlok® 8200 Adhesive

## Description

LORD Chemlok® 8200 adhesive is an aqueous covercoat adhesive used to bond a variety of elastomers to primed metal surfaces during vulcanization. Chemlok 8200 adhesive is recommended for spray application over aqueous Chemlok primers.

## Features and Benefits

**Versatile** – bonds a variety of natural and synthetic elastomers to primed metal; well suited for use on soft NR compounds.

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

**Environmentally Preferred** – uses water for dilution and cleanup, eliminating the need for significant solvent inventory.

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

**Durable** – provides tough chip resistant film.

## 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.

- **Chemical Cleaning**  
Chemical treatments are readily adapted to automated metal treatment and adhesive application lines. Chemical treatments are also used on metal parts that would be distorted by blast cleaning or where tight tolerances must be maintained. Phosphatizing is a commonly used chemical treatment for steel, while conversion coatings are commonly used for aluminum.
- **Mechanical Cleaning**  
Grit blasting is the most widely used method of mechanical cleaning. However machining, grinding or wire brushing can be used. Use steel grit to blast clean steel, cast iron and other ferrous metals. Use aluminum oxide, sand or other nonferrous grit to blast clean stainless steel, aluminum, brass, zinc and other nonferrous metals.

## Typical Properties\*

Appearance	Black Liquid
Viscosity, cps @ 25°C (77°F) Brookfield LVT Spindle 2, 30 rpm	10-40
Density kg/m <sup>3</sup> (lb/gal)	1115-1162 (9.3-9.7)
Solids Content by Weight, %	35-39
Flash Point (Seta), °C (°F)	>51 (>124)
Solvents	Deionized Water, Ethyl Alcohol

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

# LORD TECHNICAL DATA

For further detailed information on surface preparation of specific substrates, refer to Chemlok Adhesives application guide. Handle clean metal surfaces with clean gloves to avoid contamination with skin oils.

Allow the Chemlok primer to thoroughly dry before applying Chemlok 8200 adhesive. For further details on the use of Chemlok aqueous primers, refer to the applicable data sheet.

**Mixing** – Thoroughly mix adhesive before applying over the primer. Chemlok 8200 adhesive can be applied at full strength or diluted up to 70 parts adhesive to 30 parts deionized water.

**Applying** – Apply Chemlok 8200 adhesive by spray methods. To expedite drying process, preheat the metal and primed metal inserts to 60-71°C (140-160°F) prior to spray application.

For optimum adhesion and environmental resistance, the dry film thickness of Chemlok 8200 adhesive should be 12.7-25.4 micron (0.5-1.0 mil).

**Curing** – Chemlok 8200 adhesive cures and bonds during the rubber vulcanization process. Wear clean gloves when handling coated parts and keep coated parts covered to prevent airborne materials from contaminating the surface.

## Shelf Life/Storage

Shelf life is six months from date of shipment when stored 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 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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### LORD Corporation World Headquarters

111 Lord Drive  
Cary, NC 27511-7923  
USA

### Customer Support Center (in United States & Canada)

+1 877 ASK LORD (275 5673)

[www.lord.com](http://www.lord.com)

For a listing of our worldwide locations, visit [LORD.com](http://LORD.com).

