

Chemlok® EP5809-34 Adhesive

Description

LORD Chemlok® EP5809-34 adhesive is a one-coat adhesive used to bond thermoplastic urethane to metal. Chemlok EP5809-34 adhesive may also be used in bonding castable and/or millable urethane to metal.

Features and Benefits

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

Easy to Use – ready to use directly out of container without dilution.

Excellent Appearance – dries to a clear and colorless coating; requires no dyes to be added.

Low Viscosity – requires no agitation; allows for easy application by spray, dip, wipe or brush methods.

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	Clear Liquid
Viscosity, cps @ 20°C (68°F)	3-7
Density	
kg/m ³	745-821
(lb/gal)	(6.55-6.85)
Solids Content by Weight, %	8.5-11.5
Flash Point (Seta), °C (°F)	21 (70)
Solvents	Isopropyl Alcohol (IPA)

*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.

Mixing – No agitation is required before or during use.

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

Drying/Curing – Allow coated parts to dry in moist air (50%-80% RH) for one hour prior to molding. Prebaking is generally not required but may assist in attaining the highest levels of resistance to in-service conditions. Prebake of 30 minutes at 121°C (250°F) is suggested.

Cleanup – Use mechanical methods to clean up adhesive.

Shelf Life/Storage

Shelf life is six months from date of shipment when stored in a dry, well ventilated area at 21-27°C (70-80°F) in original, unopened container.

After opening, protect adhesive from moisture contamination by installing a desiccant cartridge.

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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