




# WEATHERSTRIP & GLASS Coatings and Adhesives

# SELECTOR GUIDE

US & Canada



ENGINEERING YOUR SUCCESS.



With over half a century of experience in developing and manufacturing high-performance solutions, Parker LORD is a global leader in Weatherstrip & Glass coatings and adhesives technology for the automotive and general industries. Our products cover a wide range of applications, material substrates and manufacturing processes, serving the most demanding environments. Not only are our products offered globally, but we bring world-class technical support to every region of the world.

Our relentless focus on research and innovation brings cutting-edge technology and long-term value to our customers. We understand the critical aspects of their business and accompany them throughout each step of the product selection and implementation process.

# SIPIOL® WEATHERSTRIP COATINGS

Sipiol® weatherstrip coatings significantly improve the performance and lifetime of automotive sealings on passenger and commercial vehicles. We collaborate with our customers and partners to develop coatings that meet the demanding specifications of the automotive industry.

Our coating solutions are designed to offer excellent noise reduction performance and increased passenger comfort. They are particularly suited for applications on electric vehicles. These coatings provide abrasion resistance and are formulated to withstand the harshest environments including extreme temperatures, UV rays, water, ice and cleaning chemicals. Our products are mostly water-based and do not contain any toxic classified substances, meeting the industry's increased demand for sustainable solutions.

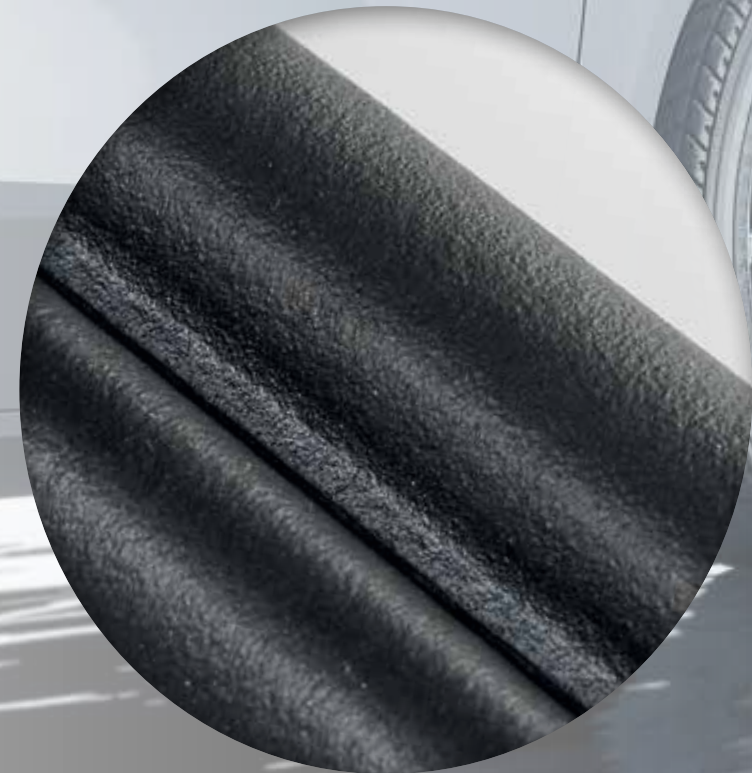
Sipiol weatherstrip coatings are approved by the leading global car manufacturers. See full product listing for primers, cross-linkers, thickeners and setting aides.















## Features & Benefits

- Excellent noise reduction
- High abrasion resistance
- High resistance to UV exposure
- One-component and two-component systems
- Water-based systems
- Spray and brush application
- Coatings can be over-painted

## Primers

- Solvent- and water-based systems
- Suitable for a variety of elastomers
- Different activation temperatures
- Spray and brush application



APPLICATION	SMOOTH COATINGS	PARTICULATED COATINGS
<b>PRIMARY DOOR SEALING, TRUNK-BONNET, HOOD SEALING</b>	   	
<b>SECONDARY DOOR SEALING, FRAMELESS DOORS, CONVERTIBLES</b>		  
<b>GLASS RUN CHANNELS</b>		  
<b>SUN ROOFS</b>		 

1K 2K

See Selector Guide insert for technical data.

# FLOCKLOK® & FLOCKSIL® FLOCK ADHESIVES

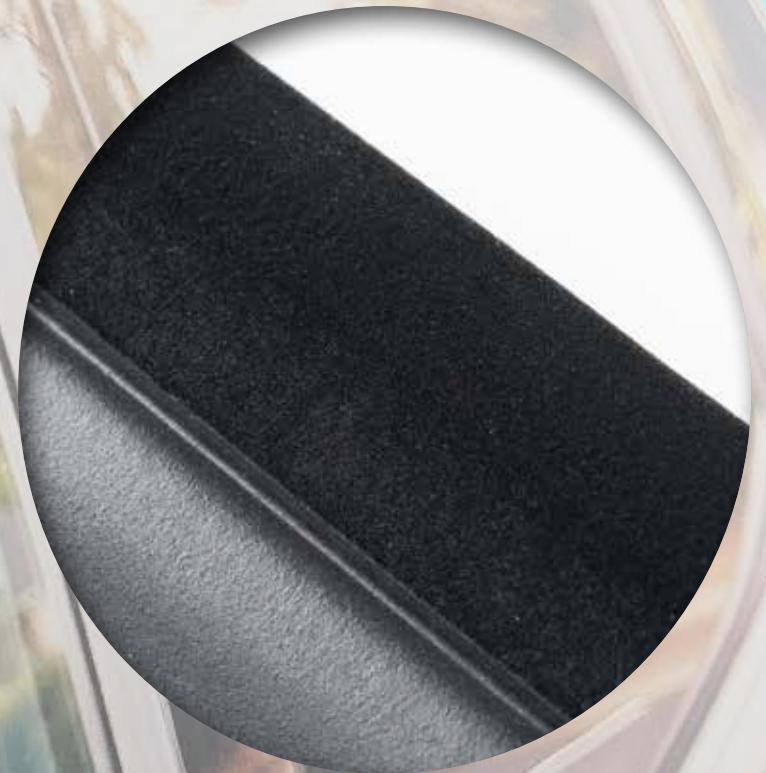
Flocklok® and Flocksil® flock adhesives are designed to adhere polyester or nylon flock fibers to a variety of elastomers (including EPDM, NR, CR, SBR) and thermoplastic elastomers (TPE). The flocked elastomer forms an insulating weather seal around windows, protecting passenger cars and commercial vehicles from dust and dirt entering the cabin. Our flock adhesives provide excellent durability, abrasion resistance and adhesion. They protect the rubber sealing from wear, facilitate glass sliding and contribute to noise reduction and increased passenger comfort.


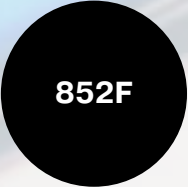
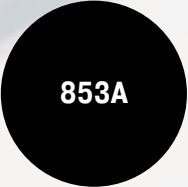





## Features & Benefits

- One-component and two-component systems
- Different solvent compositions and curing times
- Excellent adhesion to a variety of substrates and types of flock
- Process compatibility – can be applied online and offline

## Catalysts

- Customizable to specific customer processes
- High efficiency
- DTBL-free versions available



<b>SUBSTRATES</b>			
<b>COLOR</b>	<b>EPDM, NR, CR, SBR</b>	<b>TPO</b>	<b>PVC, ALCRYIN (MPR), NYLON, ABS</b>
<b>BROWN</b>	   		
<b>BLACK</b>			
<b>CLEAR OR YELLOW</b>			

1K 2K

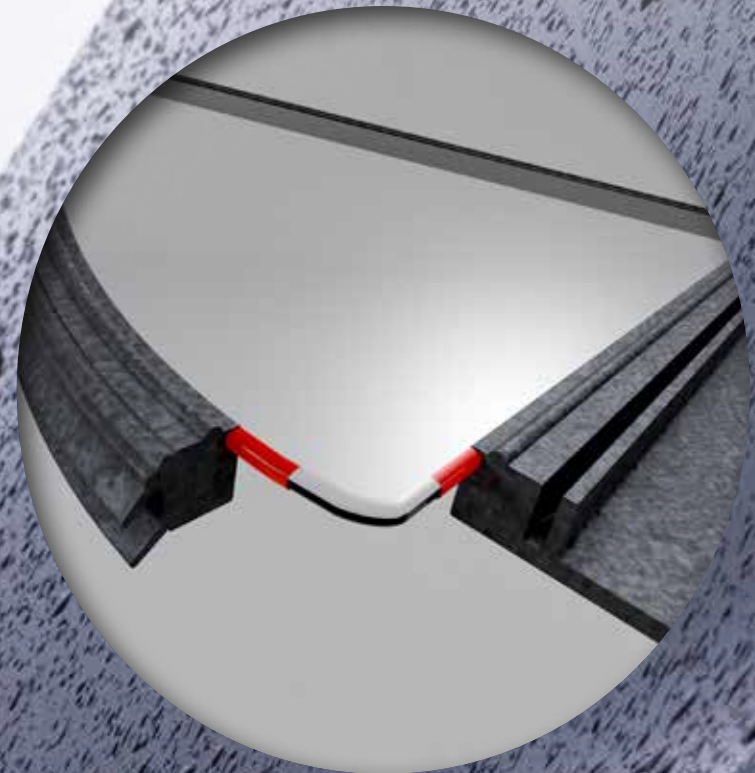
See Selector Guide insert for technical data.






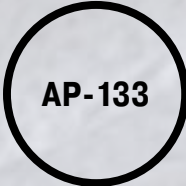








# CHEMLOK® GLASS ENCAPSULATION ADHESIVES



Chemlok® glass encapsulation adhesives are designed for the production of automotive windshields, side windows (modular windows) and rear windows. They form a strong bond between the polymer and the window glass during the encapsulation process. We recommend different adhesive systems to bond the glass, depending on the polymer used.

## Features & Benefits

- Product solutions for all common polymers (PVC, RIM PU, TPE, EPDM)
- Long history of proven product performance
- Easy application
- Integrated UV tracers
- Selection of available primers



INJECTED POLYMER	GLASS, METAL AND PLASTICS ONLY	STEEL, ALUMINUM, E-COATED METAL, GLASS, FABRIC, ARCHITECTURAL AND AUTOMOTIVE GLASS, CONCRETE AND SOME PLASTICS
PVC	 489/456	
TPE	 144  487 A/B	 144  487 A/B
SILICONE RUBBER, FKM, PA, PET	 AP-133	 AP-133
RIM-PU	 AP-134  144	 AP-134  144
EPDM	 144  6150  8560S	

 **Primer**     **Adhesive**

See Selector Guide insert for technical data.



# AUTOMOTIVE WEATHERSTRIP APPLICATIONS

**Glass Run Channel**



**Engine Hood Sealing**



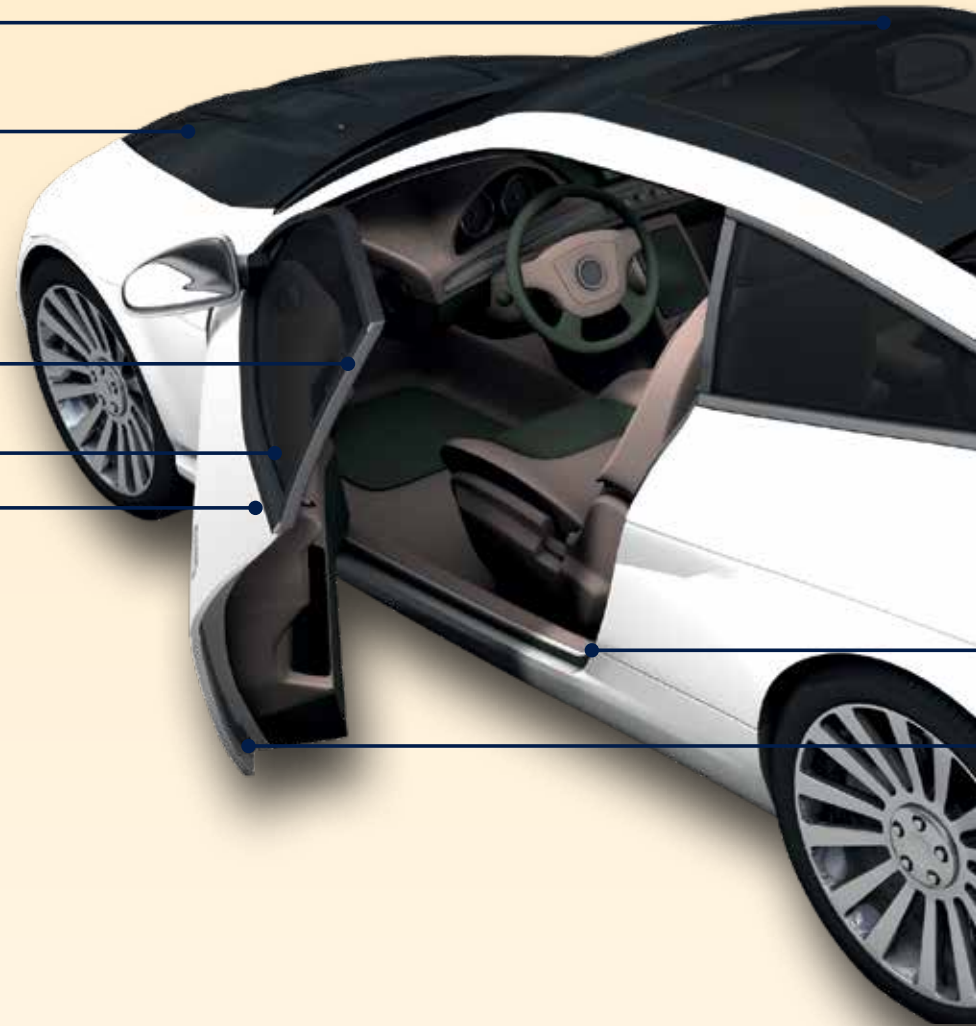
**Sun Roof Sealing**

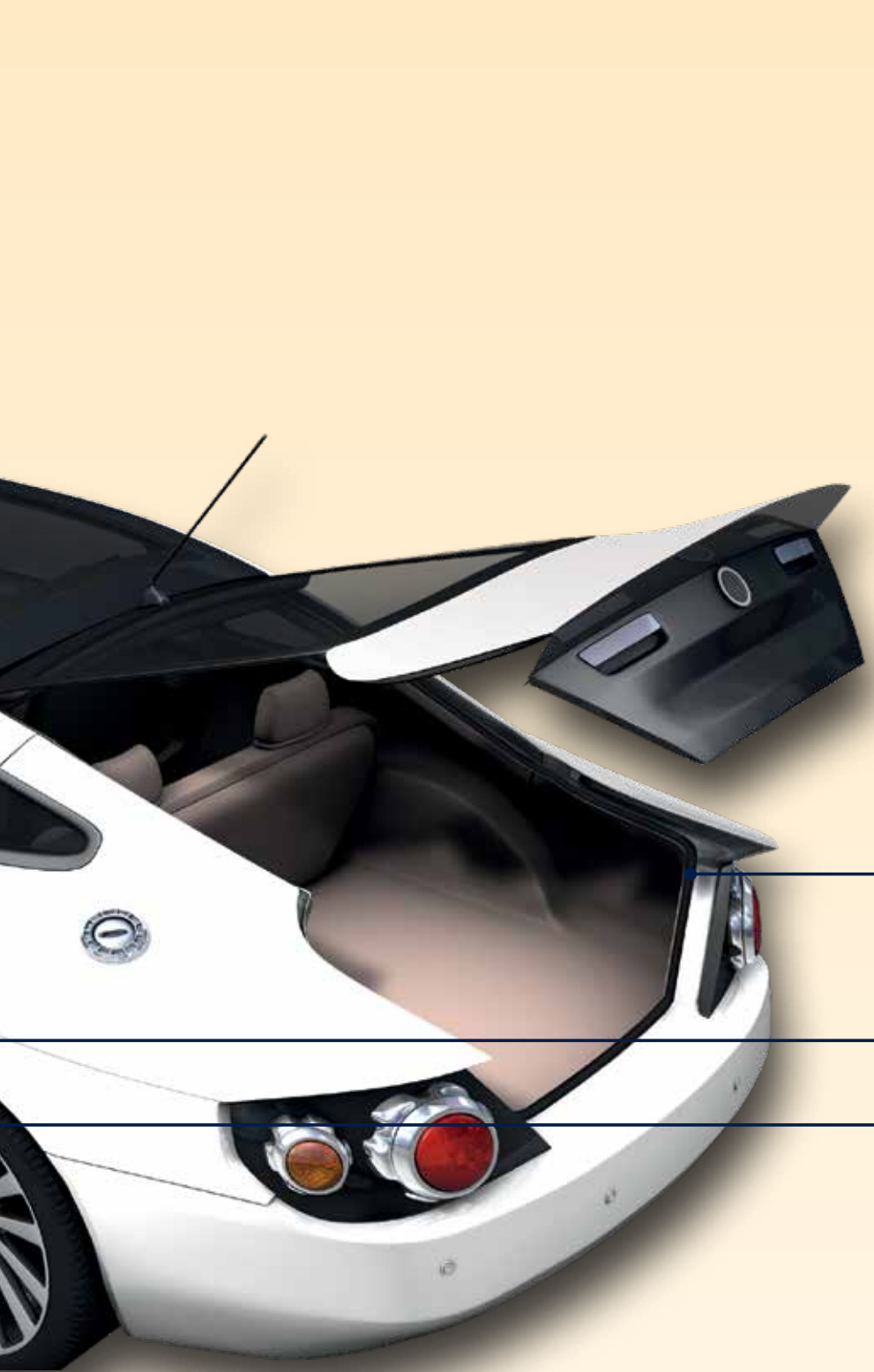


**Inner Window Guide**



**Outer Window Guide**





***For Convertibles :***

**Trunk Sealing**



**Windshield Header Sealing**



**Top Case Cover Sealing**



**Primary Door Sealing**



**Secondary Door Sealing**

## WEATHERSTRIP COATINGS

PRODUCT	MAIN APPLICATION	MAIN SUBSTRATE	1K/2K	BASE	PARTICLE SIZE, $\mu\text{m}$	COLOR	SOLIDS, %	VISCOSITY $\text{mPa}\cdot\text{s}$ / cps except as noted	NOISE REDUCTION	ABRASION RESISTANCE	WEATHERING	COEFFICIENT OF FRICTION
<b>Sipiol® WL 1120-21</b>	Door sealing, trunk-bonnet, hood sealing	EPDM, Sponge	1K	Aqueous	No Particles	Black	30.0-34.5	10-100	++	++	+++	0.3
<b>Sipiol WL 1120-23</b>	Door sealing, trunk-bonnet, hood sealing, o-rings	EPDM, Sponge	1K	Aqueous	No Particles	Black	31-36	10-150	++	+++	+++	0.3
<b>Sipiol WL 2010-23</b>	Door sealing, trunk-bonnet, hood sealing	EPDM, TPO, Sponge	2K (WV 21)	Aqueous	No Particles	Black	31-36	400-600	++	+++	+++	0.26
<b>Sipiol WL 2010-24</b>	Door sealing, trunk-bonnet, hood sealing	EPDM, TPO, Sponge	2K (WV 21)	Aqueous	No Particles	Black	31-35	50-150	++	+++	+++	0.26
<b>Sipiol WL 2015-22P</b>	Secondary door sealing, frameless doors, convertibles	EPDM, TPO, Sponge	2K (WV 21)	Aqueous	60	Black	34-39	150-300	+++	+++	+++	0.16
<b>Sipiol WL 1025-21</b>	Secondary door sealing, frameless doors, convertibles	EPDM, Sponge	1K	Aqueous	60	Black	36.5-40.5	40-100	+++	+++	+++	0.16
<b>Sipiol WL 1026-21</b>	Secondary door sealing, frameless doors, convertibles, sun roof, electric vehicles	EPDM, Sponge	1K	Aqueous	30	Black	36-40	50-150	+++	+++	++++	0.16
<b>Sipiol WL 1620-21 G</b>	Anti-friction coatings for o-rings	EPDM	1K	Aqueous	No Particles	Matte or Glossy Transparent	31-36, 36-40	10-150, 50-250	++	++	N/A	N/A
<b>Autoseal® RC-3007S</b>	Door sealing, trunk-bonnet, hood sealing	Sponge	2K (AS-3463B)	Aqueous	No Particles	Black	28.5-32.5	200-1000	++++	++	+++	++

+ meets expectations  
 ++ good  
 +++ very good  
 ++++ excellent





## CROSS-LINKERS / ADHESION PROMOTERS / THICKENERS / SETTING AIDES

PRODUCT	MAIN APPLICATION	SUBSTRATE	PROPOSED % IN WEIGHT	CURING REQUIREMENT, °C	POT LIFE
<b>Sipiol WV 21</b>	Curative for 2K rubber coating	EPDM, TPE	3	25-200	8 hr at 25°C
<b>Sipiol WV 22</b>	Curative for 2K rubber coating	EPDM	1K = 1-3 2K = 8	130-200	No pot life limitation
<b>Autoseal 3463B</b>	Cross-linker for 2K rubber coating	EPDM	2.50	25-182	24-48 hr
<b>Sipiol HV 3</b>	Adhesion Promoter	EPDM, TPE	5-10 for all systems	N/A	Infinite pot life; can be used as a primer on TPE
<b>Sipiol TH1</b>	Thickener	EPDM, TPE	0.2-2	-	No pot life limitation
<b>Sipiol WM 2</b>	Setting aide	all substrates	-	25-180	No pot life limitation
<b>Autoseal RC-1500</b>	Adhesion Promoter	EPDM, Sponge	10	180	No pot life limitation
<b>Autoseal RC-804B</b>	Cross-linker for 2K rubber coating	EPDM, Sponge	2-5	149-288	8-10 hr

## PRIMER FOR COATINGS

PRODUCT	MAIN SUBSTRATE	SOLVENT	COLOR	SOLIDS, %	MAIN APPLICATION
<b>Chemlok® 459X</b>	TPE, TPO, EPDM	Xylene	Amber	2.7-4.1	Primer for coatings and flock adhesive
<b>Autoseal RC-1017</b>	TPO or cured EPDM	Toluene	Clear/Tan	3.0-5.0	Primer for double layer tapes
<b>Autoseal 459D</b>	TPE, TPO, EPDM	Cyclohexane, MPK	Clear, Straw Yellow	2.8-4.4	Primer for coatings and flock adhesives
<b>Autoseal RC-1028K</b>	EPDM, TPO, PP	Methylcyclohexane, Butyl acetate, Ethanol, 2-Propanol	Light Yellow to Brown	3.3-4.3	Primer for coatings and flock adhesives
<b>Autoseal RC-1019</b>	TPO, PP, EPDM	Toluene, Isopropyl Alcohol, Cyclohexane	Clear/Tan	2.7-3.7	Primer for coatings and flock adhesives
<b>Autoseal RC-1023</b>	PVC, PBT, PET	Toluene, MEK, Cyclohexane, 2-Propanol	Yellow to Brown	4.8-6.8	Primer for coatings and flock adhesives
<b>Sipiol WP 8555</b>	NR, HNBR and EPDMs	Water	Opaque Yellow	7.0-9.0	Primer for coatings and flock adhesives
<b>Sipiol WP 8556</b>	NR, HNBR and EPDMs	Water	Opaque Yellow	7.0-10.0	Primer for coatings and flock adhesives
<b>Cuvertin® X 8536</b>	EPDM	Xylene	Clear to Yellow	1.8-2.2	Primer for coatings and flock adhesives

## FLOCK ADHESIVES

PRODUCT	MAIN APPLICATION	1K/2K	MAIN SUBSTRATE	SOLVENT	COLOR	SOLIDS, %	VISCOSITY mPa·s / cps except as noted	CURING, MIN	ADHESION	ABRASION	HUMIDITY STABILITY	SPECIFIC PROPERTIES
<b>Flocksil® 1501 SF</b>	Brush or spray	1K	EPDM, NR, CR, SBR	MIBK Ethylacetate	Brown	45-49	20-100	5 @ 180°C	+++	+++	+++	Slow curing
<b>Flocksil 1503 D G</b>	Brush or spray	1K	EPDM, NR, CR, SBR	Xylene, MIBK, Ethylacetate	Black	40-44	40-100	1.5 @ 180°C	++++	++++	++++	Fast curing
<b>Flocksil 1506 G 1</b>	Brush or spray	1K	EPDM, NR, CR, SBR	Xylene, Ethyl Acetate, Methoxyisopropyl Acetate	Black	40-44	40-100	2.5 @ 180°C	++++	++++	++++	Low temperature cure
<b>Flocklok® 852F</b>	Inline or offline	1K	EPDM, NR, CR, SBR	Xylene, Ethyl Benzene, Acetone	Brown	52-56	50-100 seconds (Zahn #2)	2 @ 204°C	+++	+++	+++	Fast curing
<b>Flocklok 853A</b>	Brush or spray	1K	EPDM, NR, CR, SBR	Toluene, Xylene, MIBK, Acetates, Aromatic petroleum desillate, Acetone	Brown	46.5-50.5	80-200	3 @ 204°C	+++	+++	+++	Long open time
<b>Flocklok 550P</b>	Brush or spray	1K	EPDM, NR, CR, SBR	n-Butyl Propionate	Brown	70-74	125-500	1-3 @ 204-260°C	+++	+++	+++	High solid adhesive
<b>Flocklok 7000/7204</b>	Brush or spray	2K	PVC, Alcryin®, Sunprene®, nylon, ABS, etc.	7000: MEK 7204: Xylene, Acetates	Clear, Amber- colored	7000: 29-31 7204: 13.5-16.5	7000: 970-2500 7204: 15	3 @ 135°C	+++	+++	+++	For specific substrates
<b>Autoseal RC-3902H</b>	Inline, drop or roll	2K	TPO	Water	Light Yellow	28.5-32.5	400-1000	5-10 @ 150°C	+++	+++	+++	Water borne adhesive

+ meets expectations  
 ++ good  
 +++ very good  
 ++++ excellent

## CUVERTIN® CATALYSTS

PRODUCT	MAIN APPLICATION	SUBSTRATE	PROPOSED % IN WEIGHT	POT LIFE
<b>Cuvertin K 4</b>	Catalyst for flock adhesive	EPDM, TPO	1-3	7 hr



## CHEMLOK® GLASS ENCAPUSLATION ADHESIVES

PRODUCT	MAIN APPLICATION	1K/2K	SOLVENT	COLOR	SOLIDS, %	VISCOSITY mPa·s / cps
<b>Chemlok 487 A/B</b>	Bond thermoplastic elastomers (TPE) to glass, metal and plastics during injection molding	2K	A: Xylene B: MIBK	Clear	A: 12.6-15 B: 1-2	A: 100-350 B: 1-10
<b>Chemlok 489/456</b>	Bond PVC to glass, metals and plastics during injection molding	2K	489: MIBK/Xylene 456: Xylene	Amber	489: 9-11 456: 49-51	489: 80-195 456: <25
<b>Chemlok AP-133</b>	Bond unvulcanized silicone rubber to glass, metals, plastics and textiles	1K	Methanol, Ethanol, Toluene	Clear	4.8-6.2	0-5
<b>Chemlok 6150, Chemlok 8560S</b>	Bond EPDM to glass during injection molding	1K	6150: Xylene 8560S: Water	Black	6150: 21-25 8560S: 38-42	6150: 200-1000 8560S: 50-250

## CHEMLOK® PRIMERS

PRODUCT	MAIN SUBSTRATE	SOLVENT	COLOR	SOLIDS, %	MAIN APPLICATION
<b>Chemlok 144</b>	Glass fabric, steel, aluminum, brass, e-coated metal, architectural and automotive glass, concrete and some plastics	Toluene, n-Butanol, Ethanol	Clear, Straw Yellow	4.8-6.2	Injection Molding
<b>Chemlok AP-134</b>	Architectural and automotive glass, glass fabric, steel, aluminum, brass, e-coated metal, concrete and some plastics	Toluene, n-Butanol, Ethanol	Clear, Straw Yellow	4.8-6.2	Injection Molding

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.

Information provided herein is based upon tests believed to be reliable. In as much as Parker LORD has no control over the manner in which others may use this information, it does not guarantee the results to be obtained. In addition, Parker LORD does not guarantee the performance of the product or the results obtained from the use of the product or this information where the product has been repackaged by any third party, including but not limited to any product end-user. Nor does the company make any express or implied warranty of merchantability or fitness for a particular purpose concerning the effects or results of such use.

WARNING — USER RESPONSIBILITY. FAILURE OR IMPROPER SELECTION OR IMPROPER USE OF THE PRODUCTS DESCRIBED HEREIN OR RELATED ITEMS CAN CAUSE DEATH, PERSONAL INJURY AND PROPERTY DAMAGE.

This document and other information from Parker-Hannifin Corporation, its subsidiaries and authorized distributors provide product or system options for further investigation by users having technical expertise.

The user, through its own analysis and testing, is solely responsible for making the final selection of the system and components and assuring that all performance, endurance, maintenance, safety and warning requirements of the application are met. The user must analyze all aspects of the application, follow applicable industry standards, and follow the information concerning the product in the current product catalog and in any other materials provided from Parker or its subsidiaries or authorized distributors.

To the extent that Parker or its subsidiaries or authorized distributors provide component or system options based upon data or specifications provided by the user, the user is responsible for determining that such data and specifications are suitable and sufficient for all applications and reasonably foreseeable uses of the components or systems.

©2022 Parker Hannifin

Information and specifications subject to change without notice and without liability therefore.  
Trademarks used herein are the property of their respective owners.

Parker LORD  
**Engineered Materials Group**  
 111 LORD Drive  
 Cary, NC 27511-7923 USA

phone +1 877 ASK LORD (275 5673)

www.lord.com

For a listing of our worldwide  
 locations, visit LORD.com

OD SG1042 06/22 Rev.4



ENGINEERING YOUR SUCCESS.