



Chemlok® Adhesives

SELECTOR GUIDE

LORD
AskUsHow™



When you need a rubber-to-substrate adhesive, choose the ultimate in elastomer bonding – LORD Chemlok Adhesives – technology that has generations of proven performance. For more than 50 years, Chemlok Adhesives have performed in a broad spectrum of industries including: automotive, power generation, civil engineering, mining, aerospace, military, oil and gas, and industrial applications, to name a few. For uncompromising quality, service and performance ... Ask Us How.



Choose your adhesive by the type of elastomer to be bonded. Refer to the Elastomer Bonding Guide within this document to make the correct selection. Also consider surface preparation; cure cycles; required environmental and chemical resistance; part geometry; color and conductivity requirements; and application methods which also affect the primer and adhesive choice. This guide lists the most common primers and adhesives. Contact the LORD Customer Support Center at +1 877 ASK LORD (275 5673) or your local distributor to assist you with selecting the appropriate adhesive for your application.

ELASTOMER BONDING GUIDE

Elastomer	Traditional Solvent-Based, One-Coat	Traditional Solvent-Based, Two-Coat (Primer/Adhesive)	EPCA* Solvent-Based, One-Coat	EPCA* Solvent-Based, Two-Coat	Aqueous, One-Coat	Aqueous, Two-Coat (Primer/Adhesive)
BUTYL TYPES (BROMOBUTYL AND CHLOROBUTYL)	—	205/236A, 205/236X, 205/238(NW)	6250, 6253, 6254, 6016, EP6804-22	205/6250, 205/6100, 205/6108, 205/6253, 205/6254, 205/6411**, 205/EP6804-22	8560D, 8560S	8007/8560D, 8007/8560S
CHLORINATED POLYETHYLENE	—	205/2332, 205/234B(NW), 205/234X(NW)	6250, 6253, 6254, EP6804-22	205/6250, 205/6100, 205/6108, 205/6253, 205/6254, 205/EP6804-22	8560D, 8560S	8007/8560D, 8007/8560S
CHLOROSULFONATED POLYETHYLENE	—	205/2332, 205/234B(NW), 205/234X(NW)	6250, 6253, 6254	205/6250, 205/6100, 205/6108, 205/6253, 205/6254	8560D, 8560S	8007/8560D, 8007/8560S
EPDM	—	205/238(NW), 205/258XN, 207/259, 205/236A, 205/236X	6250, 6253, 6254, 6016, EP6804-22	205/6250, 205/6100, 205/6108, 205/6253, 205/6254, 205/6411**, 205/EP6804-22	8560D, 8560S	8007/8560D, 8007/8560S
EPICHLOROHYDRIN	607, Y-1520A, 5151, Ty-Ply BN	205/2332	6250, 607, Y-1520A, 5151	205/6250	610, 8560D, 8560S	8007/8560D, 8007/8560S
ETHYLENE ACRYLIC	205, 607, Y-4310, 5151, Ty-Ply BN	205/2332, 207/259	6250, 607, Y-4310, 5151	205/6125, 205/6220, 205/6250	610, 8560D, 8560S	8007/8560D, 8007/8560S
FLUOROCARBON	607, Y-4310, 5150, 5151, AP-133, Y-1520A	—	607, Y-4310, 5150, 5151, AP-133, Y-1520A	—	8116	8006/8116
NATURAL	—	205/2332, 205/234B(NW), 205/234X(NW), 207/259	6250, 6253, 6254, 6016, EP6804-22	205/6250, 205/6100, 205/6108, 205/6253, 205/6254, 205/6411**, 205/EP6804-22	8560D, 8560S	8006/8200, 8007/8210, 8007/8560D, 8007/8560S, 8008/8212
NITRILE	205, 217, Ty-Ply BN	205/2332, 205/234B(NW), 205/234X(NW), 207/259	6250, 6253, 6254, 6016, 6450, 6451, EP6804-22	205/6250, 205/6100, 205/6108, 205/6253, 205/6254, 205/6411**, 207/6450, 207/6451, 205/EP6804-22	610, 8110, 8560D, 8560S	8006/8200, 8007/8210, 8007/8560D, 8007/8560S, 8008/8212
POLYACRYLATE	217, 607, AP-133, Y-4310, Ty-Ply BN	205/217, 205/Ty-Ply BN	6250, 607, AP-133, Y-4310	205/6250	610	—
POLYBUTADIENE	—	205/2332, 205/234B(NW), 205/234X(NW)	6250, 6253, 6254, 6016, EP6804-22	205/6250, 205/6100, 205/6108, 205/6253, 205/6254, 205/6411**, 205/EP6804-22	—	—
POLYCHLOROPRENE	—	205/2332, 205/234B(NW), 205/234X(NW), 207/259	6250, 6253, 6254, 6016, EP6804-22	205/6250, 205/6100, 205/6108, 205/6253, 205/6254, 205/6411**, 205/EP6804-22	8560D, 8560S	8006/8200, 8007/8210, 8007/8560D, 8007/8560S, 8008/8212
POLYISOPRENE	—	205/2332, 205/234B(NW), 205/234X(NW), 205/236A, 207/259	6250, 6253, 6254, 6016, EP6804-22	205/6250, 205/6100, 205/6108, 205/6253, 205/6254, 205/6411**, 205/EP6804-22	8560D, 8560S	8006/8200, 8007/8210, 8007/8560D, 8007/8560S, 8008/8212
POLYURETHANE	213, 218, 219	—	—	—	8600	—
MILLABLE URETHANE	213, 218, 219	—	—	—	8600	—
PVC	485/Curative 44, 489/456	—	—	—	—	—
SILICONE (PEROXIDE CURE)	607, 608, AP-133, Y-4310, Y-1540	—	607, 608, AP-133, Y-4310, Y-1540	—	8116	—
STYRENE BUTADIENE	—	205/2332, 205/234B(NW), 205/234X(NW), 207/259	6250, 6253, 6254, 6016, EP6804-22	205/6125, 205/6220, 205/6250, 205/6100, 205/6108, 205/6253, 205/6254, 205/6411**, 205/EP6804-22	—	8009/8214

*EPCA stands for Environmentally Preferred Coatings and Adhesives.

**Low-HAP variations are available.

For high-temperature/harsh environments, substitute Chemlok 207 Primer for Chemlok 205 Primer. Exception: Chemlok 207 Primer cannot be used with Chemlok 217, 6125 or 6220 adhesive or Ty-Ply BN adhesive.

ONE-COAT SYSTEMS

Product	Description	Color	Viscosity, cps (except as noted)	Flash Point °C (°F)	Diluent	Shelf Life
213	Urethane-to-metal adhesive	Blue	100–300	5 (41)	Chemlok 248	1 year
217	Adhesive for polychloroprene and nitrile elastomers	Black	75–150	-2 (28)	MEK/Xylene Mix	1 year
218	General purpose adhesive	Clear to Slightly Hazy Amber	750–1,050	2 (36)	1:1 Isopropanol: Toluene Blend or Glycol Ether Solvents	1 year
219	Primer/castable urethane and TPU adhesive	Clear to Amber	50–110	14 (58)	MIBK, Denatured Ethanol	1 year
402	Rubber-to-textile adhesive	Black	100–350	>93 (>200)	Xylene, Toluene	6 months
402X-HS	All-xylene Chemlok 402	Black	600–1,100	25 (77)	Xylene	6 months
485/44	Clear, two-part adhesive for bonding PVC	Clear to Amber/ Transparent Brown	400–1,000/<10	-4 (24)/29 (85)	Xylene	1 year/1 year
487 A/B	Clear, two-part adhesive for bonding TPE	Clear to Yellow/ Clear to Cloudy	100–350/1–10	27 (81)/15 (60)	Xylene, Toluene	6 months/6 months
489/456	Fluorescing, two-part adhesive for bonding PVC	Clear to Amber/ Light Amber	80–195/<25	16 (61)/27 (81)	Xylene, Toluene	6 months/1 year
607	Adhesive for silicone/specialties	Clear to Slightly Yellow	—	9 (49)	Methanol, Ethanol	2 years
608	Adhesive for silicone	Clear to Hazy Yellow	—	3 (38)	Methanol	2 years
610	Aqueous, specialty elastomer adhesive	Orange to Red	—	>93 (>200)	Deionized Water	2 years
5150	Adhesive for bonding fluoroelastomers to metal	Colorless to Pale Yellow	≈ 2 centistokes	6 (43)	Methanol, Ethanol	1 year
5151	Adhesive for fluoroelastomers	Reddish-yellow	25–30 seconds Zahn #1	-5 (22)	MEK	6 months
6016	Low-lead Chemlok 253	Black	35–100 seconds Zahn #3	27 (81)	Xylene, Toluene	1 year
6250	Low-lead Chemlok 250	Black	100–500	27 (81)	Technical Grade Xylene, Toluene	6 months
6253	Low-lead Chemlok 253	Black	25–85 seconds Zahn #3	27 (81)	Xylene, Toluene	6 months
6254	Heat- and oil-resistant adhesive	Black	150–450	7 (44)	Xylene, Toluene	6 months
6256	Low-lead, hard film Chemlok 252X	Black	25–45 seconds Zahn #3	5 (41)	Xylene, Toluene	1 year
6260	Non-black Chemlok 6254	Brown	100–600	6 (44)	Xylene, Toluene	6 months
6450	High-temperature adhesive for HNBR/NBR	Green-Black	5–100	0 (32)	MEK, Xylene	6 months
6451	High-temperature adhesive for HNBR/NBR	Green-Black	5–100	-7 (18)	MEK, Xylene	6 months
8110	Aqueous adhesive for nitrile	Black	<100	>93 (>200)	Deionized Water	6 months
8116	Aqueous adhesive	Black	100–900	>93 (>200)	Deionized Water	6 months
8560D	General purpose, aqueous adhesive	Black/Green	100–500	>93 (>200)	Deionized Water	3 months
8560S	General purpose, aqueous adhesive	Black	50–250	>93 (>200)	Deionized Water	3 months
8600	Aqueous adhesive for castable urethane	White	200–600	>93 (>200)	Deionized Water	6 months
AP-133	Adhesive for silicone/specialties	Clear	≈ 5 centistokes	14 (57)	Toluene, Methanol, Ethanol	1 year
EP6804-22	Conductive, one-coat adhesive	Black	50–250	48 (89)	Toluene, Xylene	6 months
TY-PLY BN	Adhesive for nitrile	Black	20–35 seconds Zahn #2	5.5 (42)	MEK, MIBK, Dry Alcohols	1 year
Y-1540	Adhesive for silicone/specialties	Red	≈ 3	9.4 (49)	Methanol, Ethanol	6 months
Y-1520A	Adhesive for silicone/specialties	Clear	<10 centistokes	11 (52)	Methanol, Ethanol	1 year
TS701-43	Clear Chemlok 217	Translucent Amber	60–150	-2 (28)	MEK	1 year

ADDITIVES/SOLVENTS

Product	Description	Color	Viscosity, cps (except as noted)	Flash Point °C (°F)	Diluent	Shelf Life
248	Thinner for Chemlok 213	Blue	Water Thin	3 (37)	MEK, Xylene, Acetates	1 year
EP5081-40	Flourescing additive for clear Chemlok adhesives	Clear	—	11 (52)	—	1 year

TWO-COAT SYSTEMS

Product	Description	Color	Viscosity, cps (except as noted)	Flash Point °C (°F)	Diluent	Shelf Life
225X	General purpose adhesive	Black	50–200	27 (81)	Xylene, Toluene	6 months
234B (NW)	General purpose adhesive	Black	800–1,400	28 (83)	Xylene, Trichloroethylene	1 year
234X (NW)	General purpose adhesive	Black	400–1,000	27 (81)	Xylene	1 year
236A	General purpose adhesive	Black	300–700	22 (71)	Xylene, Toluene	1 year
236X	General purpose adhesive	Black	125–500	30 (86)	Xylene, Toluene	1 year
238 (NW)	Adhesive for butyl and EPDM	Black	150–800	33 (92)	Xylene	1 year
286	Tacky tie cement for natural rubber	Black	450–1,200	4 (40)	Xylene, Toluene	6 months
289	Primer for natural rubber lining	Green	200–450	6 (42)	MEK/Xylene Mix	1 year
290	Adhesive for natural rubber lining	Red	20–50	7 (44)	Xylene, Toluene	1 year
2100/2101	Low VOC tank lining primer/adhesive system	Blue/Black	150–450/175–500	1.1 (34)/7 (44)	Xylene, MEK/Toluene	6 months/ 6 months
2332	General purpose adhesive	Black	50–300	27 (81)	Xylene	9 months
6100	Low-lead Chemlok 252X	Black	350–700	27 (81)	Xylene, Toluene	1 year
6108	Low-lead Chemlok 252H	Black	300–1,000	27 (81)	Xylene, Toluene	1 year
6125	Improved heat-resistant Chemlok 220	Black	70–300	27 (81)	Xylene, Toluene	1 year
6220	Low-lead Chemlok 220	Black	100–300	27 (81)	Xylene, Toluene	1 year
6225	Low-lead Chemlok 225X	Black	25–80 seconds Zahn #2	27 (81)	Xylene, Toluene	1 year
6254	Heat- and oil-resistant adhesive	Black	150–450	7 (44)	Xylene, Toluene	6 months
6270	Low mold-fouling, general purpose adhesive	Black	350–750	27 (81)	Xylene	9 months
6411	Low-lead adhesive	Black	200–600	25 (77)	Xylene, Toluene	1 year
6411LH	Low-HAP Chemlok 6411	Black	100–700	14 (58)	N-Butyl Propionate, Dimethyl Carbonate, Isopar E	6 months
6450	High-temperature adhesive for HNBR/NBR	Green-Black	5–100	0 (32)	MEK, Xylene	6 months
6451	High-temperature adhesive for HNBR/NBR	Green-Black	5–100	-7 (18)	MEK, Xylene	6 months
6956	High performance adhesive	Black	300	16 (61)	Xylene	6 months
8210	Aqueous adhesive	Black	200–500	>93 (>200)	Deionized Water	6 months
8212	Aqueous adhesive	Black	5–100	>93 (>200)	Deionized Water	6 months

PRIMERS

Product	Description	Color	Viscosity, cps (except as noted)	Flash Point °C (°F)	Diluent	Shelf Life
144	Solvent-borne primer with UV tracer	Clear, Light Straw	1–8 centistokes	1.6 (35)	Urethane Grade Toluene, Methanol, Ethanol	1 year
205	General purpose primer/nitrile adhesive	Gray	85–165	14 (57)	MIBK, MEK, Xylene	1 year
205LH	Low-HAP Chemlok 205	Blue	10–550	13 (56)	MPK	6 months
206 Blue	General purpose primer/adhesive	Blue	25–250	19 (66)	MIBK, MEK, Xylene	3 months
207	Heat-resistant primer	Gray	70–450	14 (58)	MIBK, MEK	6 months
207LH	Low-HAP Chemlok 207	Blue	50–800	19 (67)	MAK, MPK	6 months
298	High performance primer	Gray	<800	16 (61)	MIBK	6 months
459M	Primer for TPE/TPO/EPDM with UV tracer	Dark Amber	25–30 seconds Zahn #1	9 (48)	—	6 months
459T	Primer for TPE/TPO/EPDM	Straw Yellow	1–15	9 (48)	—	6 months
459X	Primer for TPE/TPO/EPDM	Amber	≈ 10	27 (81)	—	6 months
7701	Solvent-based surface treatment	Clear to Cloudy	—	-4 (25)	—	6 months
8006	Environmentally resistant, aqueous primer	Gray	15–100	>93 (>200)	Deionized Water	6 months
8007 Blue	General purpose primer	Blue	20–250	>93 (>200)	Deionized Water	3 months
8009	Aqueous primer	Gray	10–100	>93 (>200)	Deionized Water	6 months
8009B	Aqueous primer	Blue	10–100	>93 (>200)	Deionized Water	6 months
AP-131	Solvent-borne primer	Colorless to Slightly Yellow	0–5 centistokes	2.8 (37)	Toluene, Methanol, Ethanol	1 year
AP-134	Solvent-borne primer	Clear Yellow to Amber	0–8 centistokes	1.6 (35)	—	1 year
EP5080-11	Clear Chemlok 205 primer/nitrile adhesive	Hazy Amber	28–35 seconds Zahn #1	15 (59)	MEK, MIBK	1 year

Isn't Nature Beautiful?

At LORD, we're constantly innovating new solutions to reduce our customers' carbon footprint. Our goal is to ensure our planet will be just as beautiful for future generations.

Not only are our Environmentally-Preferred Chemlok® Adhesives better for the environment, these adhesives perform at the same high quality you expect from the Chemlok brand. Whether your application requirements call for withstanding high temperatures or harsh environments – When it's critical ... it's Chemlok.

Change is the only constant. Our team of experts strive to push the technical boundaries in order to provide you with tomorrow's solutions today. Our solutions have been successfully deployed for years across a wide range of industries. From the cars you drive to the tractor harvesting crops to put food on your table, you can depend on Chemlok Adhesives.



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Values stated herein represent typical values as not all tests are run on each lot of material produced. For formalized product specifications or specific product end uses, contact the Customer Support Center.

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LORD provides valuable expertise in adhesives and coatings, vibration and motion control, and magnetically responsive technologies. Our people work in collaboration with our customers to help them increase the value of their products. Innovative and responsive in an ever-changing marketplace, we are focused on providing solutions for our customers worldwide ... Ask Us How.

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

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

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