



CHEMLOK® ADHESIVES

Selector Guide
India

A close-up, high-contrast photograph of a complex industrial engine component, likely a manifold or valve train, featuring multiple circular openings and metallic surfaces. A semi-transparent white rectangular box is overlaid on the left side of the image, containing two paragraphs of text. A solid orange horizontal bar is positioned in the top right corner of the frame.

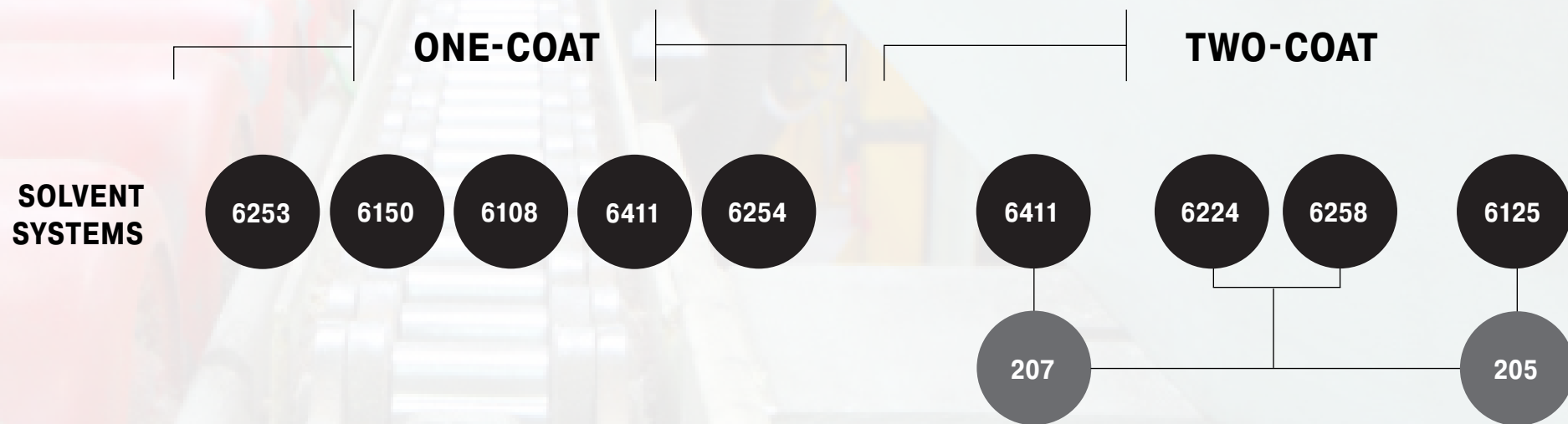
For over 70 years, Chemlok® Adhesives have been providing high performance rubber-to-metal bonds that reduce risk and improve processes in industries like automotive, power generation, civil engineering, oil and gas, and industrial applications. Whatever your challenge, we can help.

That's what makes Chemlok the ultimate in elastomer bonding. It's built on technology with generations of proven performance and delivered with uncompromising quality, service and performance.



GENERAL ELASTOMER SOLUTIONS

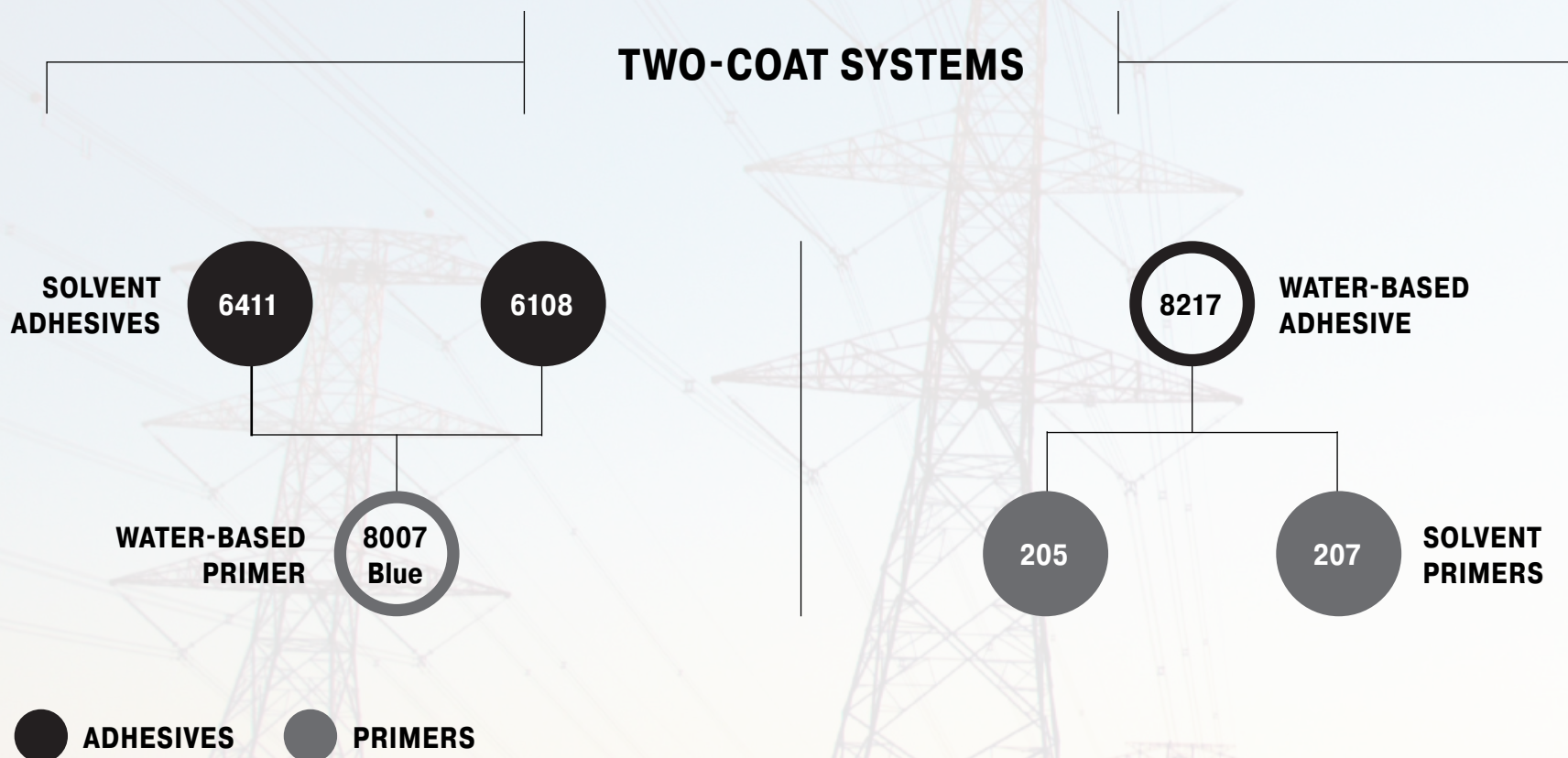
Typically the first choice for a bonding element is an elastomer. The type and details of its formulation will be based on the elastomer's intended function. Natural rubber and many synthetic elastomers make up the range of rubber polymers available. Things to consider when selecting an elastomer are performance requirements of the part, ease of mixing, processing and molding.



● ADHESIVES ● PRIMERS

GENERAL ELASTOMER HYBRID SOLUTIONS

When you need an environmentally preferred adhesive that will bond a variety of natural and synthetic elastomers to primed metal, but don't have the resources to switch over to a fully water-based system, look to our hybrid solutions. These environmentally preferred options will also bond cold-rolled steel, phosphatized steel, aluminum and other various substrates with the same level of performance that you have learned to trust.



SPECIALTY ELASTOMER SOLUTIONS

To address our customers' needs to bond specialty elastomers to different substrates, we provide a wide variety of options depending on our customers' processing parameters.



	SOLVENT SYSTEMS				WATER-BASED SYSTEMS	
FLUOROCARBON (FKM)	607	5150	5151	AP-133		8116-1
SILICONES (PEROXIDE CURED)	607	608	AP-133	Y-1540		8116-1
POLYURETHANES (MILLABLE & CAST)	213	218T	219	701		
POLYACRYLATE	607	TY-PLY BN	6150	AP-133		610
ETHYLENE ACRYLIC & EPICHLOROHYDRIN		607	6150			610
NBR/HNBR	TY-PLY BN	6150	6450-1	6125		8217
	205		Chemosil X 3960-21			



		APPLICATION METHODS		PERFORMANCE ATTRIBUTES									COMPATIBLE PRIMERS			
SOLVENT SOLUTIONS	CHEMLOK	SPRAY	DIP	MOLD FOUL	BOILING WATER	SALT SPRAY	PRE-BAKE	HEAT AGE	ELASTOMER ROBUSTNESS	LAYOVER	SWEEP	ONE-COAT	VOC FRIENDLY	205	207	8007 Blue
	6150	●	●	○	●	●	○	●	●	●	●	●	●	○	●	●
	6125	●	●	●	●	●	●	●	●	●	●	●	●	○	●	●
	6411	●	●	○	●	●	●	●	●	●	●	○	●	○	●	●
	6108	●	●	●	●	●	●	●	●	●	●	●	●	○	●	●
	6253	●	●	○	●	●	○	●	●	●	●	○	●	○	●	●
	6258	●	●	●	●	●	●	●	●	●	●	●	●	●	●	
	TY-PLY BN	●	●	●	●	●	●	●	●	●	●	●	●			
	607	●	●	●	●	○	●	●	●	●	●	●	●			
	8116-1	●	●	●	●	●	●	●	●	●	●	●	●	○	●	●
WATER-BASED SOLUTIONS	8217	●	●	●	●	●	●	○	●	●	●	●	●	●	●	●
	610	●	●	●		●	●	●	●	●	●	●	●			

● EXCELLENT ○ GOOD ● FAIR ● NOT RECOMMENDED

Note: Table reflects typical products and is not all encompassing.

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 Parker Lord Customer Support Center or your local distributor to assist you with selecting the appropriate adhesive for your application.

ELASTOMER BONDING GUIDE		ADHESIVE	
ELASTOMER	SOLVENT	WATER-BASED	
BUTYL (IIR)	6253, 6150, 6411*, 6108*		
CHLORINATED POLYETHYLENE (CPE)	6253, 6150, 6411*, 6108*		
CHLOROSULFONATED POLYETHYLENE (CSM)	6253, 6150, 6411*, 6108*		
ETHYLENE PROPYLENE DIENE MONOMER (EPDM)	6253, 6150, 238(NW)*, 6411*, 6108*	8116-1**, 8217	
EPOCHLOROHYDRIN (CO)	607, 6150, Ty-Ply BN		
ETHYLENE ACRYLIC	607, 6150, 6125*	610, 8800	
FLUOROCARBON (FKM)	607, 5150**, 5151, AP-133	8116-1**	
NATURAL RUBBER (NR)	6253, 6150, 6411*, 6108*, 6125*	8217	
NITRILE (NBR)	205, Ty-Ply BN, 6150, 6125*, X 3960-21	8116-1**, 8217	
HYDROGENATED NITRILE (HNBR)	6450-1, 6254	8116-1**	
POLYACRYLATE (ACM)	607, Ty-Ply BN, AP-133, 6150	610	
POLYBUTADIENE (BR)	6253, 6150, 6411*, 6108*	8217	
POLYCHLOROPRENE (CR)	6253, 6150, 6411*, 6108*	8217	
POLYISOPRENE (IR)	6253, 6150, 6411*, 6108*	8217	
POLYURETHANE (CAST AND MILLABLE)	218T, 213, 219, 701		
PVC	485/44, 489/456		
SILICONE (PEROXIDE CURE)	607, 608, AP-133, Y-1540	8116-1**	
STYRENE BUTADIENE (SBR)	6253, 6150, 6411*, 6108*	8217	
TPU	701		

* For solvent products, Chemlok 205 primer is recommended. For water-based products, Chemlok 8007 Blue primer is recommended.
** Peroxide cure elastomer

PRIMERS

PRODUCT	DESCRIPTION	COLOR	VISCOSITY, CPS (EXCEPT AS NOTED)	FLASH POINT °C (°F)	DILUENT	SHELF LIFE
144	Solvent-borne primer with UV tracer	Clear, Straw Yellow	1–8 centistokes	1 (35)	Urethane Grade Toluene, Methanol, Ethanol	1 year
205	General purpose primer/nitrile adhesive	Gray	85–165	14 (58)	MIBK, MEK, Xylene	1 year
205LH	Low-HAP Chemlok 205	Blue	10–550	13 (56)	MPK	6 months
207	Heat-resistant primer, improved environmental resistance	Gray	70–450	14 (58)	MIBK, MEK	9 months
207LH	Low-HAP Chemlok 207	Blue	50–800	19 (67)	MAK, MPK	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
8007 Blue	General purpose primer	Blue	15–250	≥93 (≥201)	Deionized Water	3 months
AP-131	Solvent-borne primer	Colorless to Slightly Yellow	0–5 centistokes	3 (37)	Toluene, Methanol, Ethanol	1 year
AP-134	Solvent-borne primer	Clear, Straw Yellow	0–8 centistokes	1 (35)	—	1 year
EP5080-11	Clear Chemlok 205 primer/nitrile adhesive	Hazy Amber	28–35 seconds Zahn #1	15 (59)	MEK, MIBK	1 year

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
218T	General purpose adhesive	Clear to Slightly Hazy Amber	750–1050	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
402X-HS	Adhesive for rubber to reinforced/nylon substrates	Black	600–1100	25 (77)	Xylene	6 months
485/44	Clear, two-part adhesive for bonding PVC	Clear to Amber / Transparent Brown	400–1000 / <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	1 year / 1 year
489/456	Fluorescing, two-part adhesive for bonding PVC	Clear to Amber / Light Amber	80–195 / <25	16 (61) / 27 (81)	Xylene, Toluene	1 year / 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	Water-based, specialty elastomer adhesive	Orange to Red	—	≥93 (≥201)	Deionized Water	2 years
701	Castable, urethane and TPU adhesive	Blue	50–80	-2 (28)	MEK, Cyclohexanone	1 year
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	Environmentally-preferred Chemlok 253	Black	35–100 seconds Zahn #3	27 (81)	Xylene, Toluene	1 year
6108	Environmentally-preferred Chemlok 252H	Black	300–1000	27 (81)	Xylene	1 year
6150	Adhesive for metal and plastics	Black	200–1000	28 (82)	Xylene	6 months
6250	Environmentally-preferred Chemlok 250	Black	100–550	27 (81)	Technical Grade Xylene, Toluene	6 months
6253	Environmentally-preferred Chemlok 253	Black	250–800	27 (81)	Xylene, Toluene	6 months
6254	Heat- and oil-resistant adhesive	Black	150–450	7 (44)	Xylene, Toluene	6 months
6260	Non-black Chemlok 6254	Brown	100–600	6 (44)	Xylene, Toluene	6 months
6411	Environmentally-preferred adhesive	Black	200–600	25 (77)	Xylene	1 year
6450-1	High-temperature adhesive for HNBR/NBR	Green-Black	0–100	0 (32)	MEK, Xylene	6 months
6451	High-temperature adhesive for HNBR/NBR	Green-Black	0–100	0 (32)	MEK, Xylene	6 months
8116-1	Water-based adhesive	Black	100–900	≥93 (≥201)	Deionized Water	9 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	9 (48)	Toluene, Xylene	6 months
TY-PLY BN	Adhesive for nitrile	Black	20–35 seconds FORD Cup #3	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
CHEMOSIL X 3960-21	Adhesive for nitrile	Grey	10–100	15 (59)	Ethanol	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
234X (NW)	General purpose adhesive	Black	400–1000	30 (86)	Xylene	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
238 ID	Butyl and EPDM specialty adhesive	Black	200–800	26 (79)	Xylene	1 year
286	Tacky tie cement for natural rubber	Black	450–1200	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
2332	General purpose adhesive	Black	100–300	27 (81)	Xylene	9 months
6100	Environmentally-preferred Chemlok 252X	Black	350–700	27 (81)	Xylene, Toluene	1 year
6108	Environmentally-preferred Chemlok 252H	Black	300–1000	27 (81)	Xylene, Toluene	1 year
6125	Improved heat-resistant Chemlok 220	Black	70–200	27 (81)	Xylene, Toluene	1 year
6220	Environmentally-preferred Chemlok 220	Black	100–300	27 (81)	Xylene, Toluene	1 year
6224	High performance adhesive	Black	100–300	27 (81)	Xylene	1 year
6225	Environmentally-preferred 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
6258	Environmentally-preferred, hard film Chemlok 252X	Black	25–45 seconds Zahn #3	5 (41)	Xylene, Toluene	1 year
6411	Environmentally-preferred adhesive	Black	200–600	25 (77)	Xylene	1 year
6411LH	Low-HAP Chemlok 6411	Black	100–700	14 (58)	N-Butyl Propionate, Dimethyl Carbonate, Isopar E	6 months
6450-1	High-temperature adhesive for HNBR/NBR	Green-Black	0–100	0 (32)	MEK, Xylene	6 months
6451	High-temperature adhesive for HNBR/NBR	Green-Black	0–100	0 (32)	MEK, Xylene	6 months
8217	Water-based adhesive	Black	10–200	>93 (>201)	Deionized Water	6 months



ISN'T NATURE BEAUTIFUL?

At Parker 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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