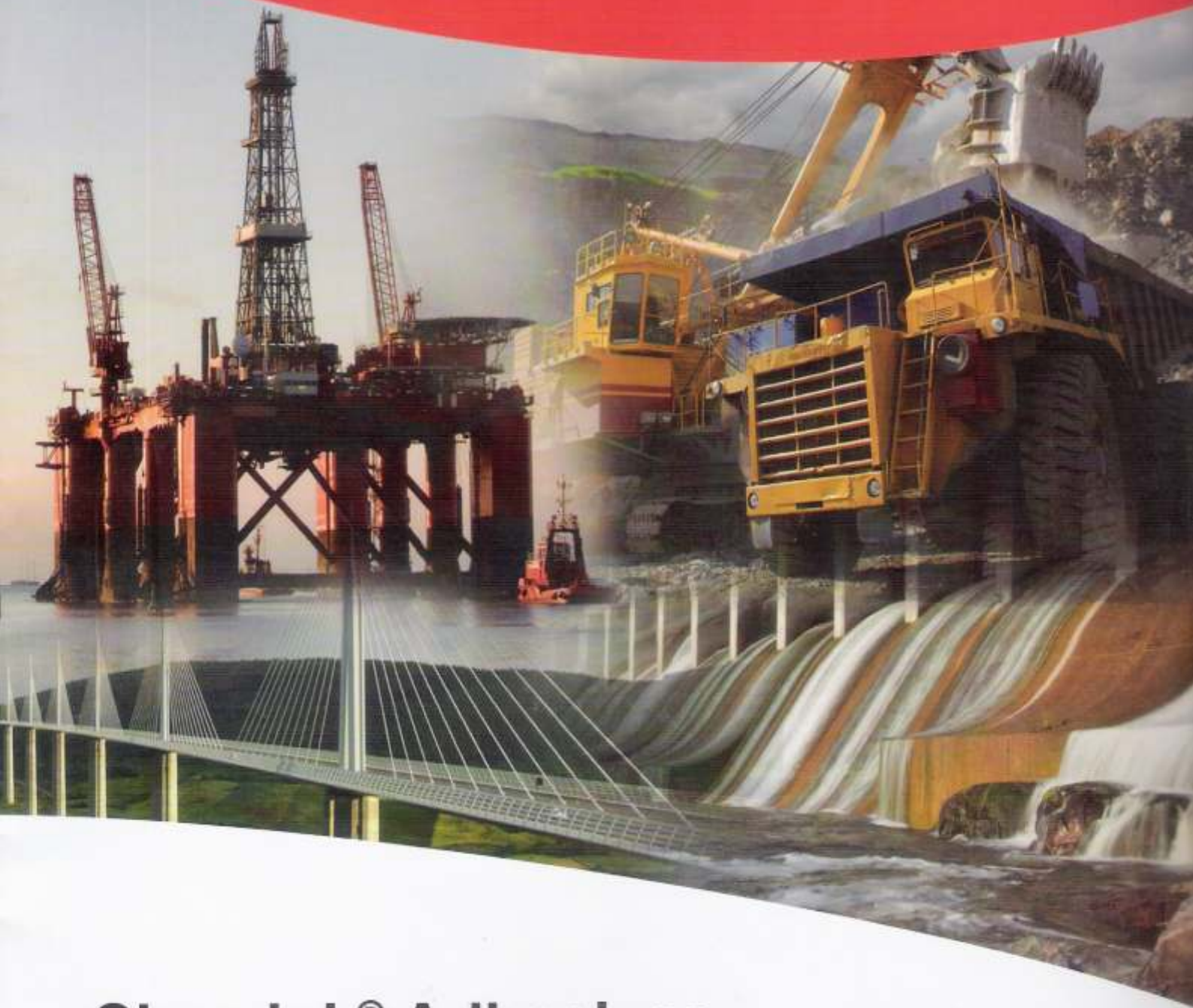
SELECTOR GUIDE



Chemlok® Adhesives

LORD

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The type of elastomer to be bonded is the basis to select which adhesive to use. Refer to the Elastomer Bonding Guide within this document to make the correct selection. Surface preparation, cure cycles, required environmental and chemical resistance, part geometry, color and conductivity requirements, and application methods will also affect the primer and adhesive choice. This guide lists the most common primers and adhesives. For additional information, contact the LORD Customer Support Center at +1 877 ASK LORD (275 5673) or your local distributor to assist you with the adhesive selection process.

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)	250, 250X, 252X, 253X, 258XN, 6254	205/236A, 205/236X, 205/238, 205/250, 205/250X, 205/252X, 205/258XN	6250, 6253, 6254, 6016, EP6804-22	205/6250, 205/6100, 205/6108, 205/6253, 205/6254, 205/6411**, 205/EP6804-22	8650D, 8560S	8007/8650D, 8007/8560S
Chlorinated Polyethylene	250, 250X, 252X	205/233X, 205/234B, 205/234X, 205/250, 205/250X, 205/252X	6250, 6253, 6254, EP6804-22	205/6250, 205/6100, 205/6108, 205/6253, 205/6254, 205/EP6804-22	8650D, 8560S	8007/8650D, 8007/8560S
Chlorosulfonated Polyethylene	250, 250X, 252X, 253X	205/233, 205/233X, 205/234B, 205/234X	6250, 6253, 6254	205/6250, 205/6100, 205/6108, 205/6253, 205/6254	8650D, 8560S	8007/8650D, 8007/8560S
EPDM	250, 250X, 252X, 253X, 258XN, 6254	205/238, 205/258XN, 207/259, 205/236A, 205/236X, 205/250, 205/250X, 205/252X	6250, 6253, 6254, 6016, EP6804-22	205/6250, 205/6100, 205/6108, 205/6253, 205/6254, 205/6411**, 205/EP6804-22	8650D, 8560S	8007/8650D, 8007/8560S
Epichlorohydrin	250, 250X, 607, Y-1520A, 5151, Ty-Ply BN	205/233, 205/233X, 205/250, 205/250X	6250, 607, Y-1520A, 5151	205/6250	610, 8560D, 8560S	8007/8650D, 8007/8560S
Ethylene Acrylic	205, 250, 250X, 252X, 607, Y-4310, 5151, Ty-Ply BN	205/220, 205/220X, 205/233, 205/233X, 207/259	6250, 607, Y-4310, 5151	205/6125, 205/6220, 205/6250	610, 8560D, 8560S	8007/8650D, 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	250, 250X, 252X, 253X, 258XN, 6254	205/220, 205/220X, 205/233, 205/233X, 205/234B, 205/234X, 207/259, 205/258XN	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, 250, 250X, 252X, 253X, 258XN, 6254, Ty-Ply BN	205/233, 205/233X, 205/234B, 205/234X, 205/258XN, 207/259	6250, 6253, 6254, 6016, EP6804-22	205/6250, 205/6100, 205/6108, 205/6253, 205/6254, 205/6411**, 205/EP6804-22	610, 8110, 8560D, 8560S	8006/8200, 8007/8210, 8007/8560D, 8007/8560S, 8008/8212
Polyacrylate	250, 217, 250X, 607, AP-133, Y-4310, Ty-Ply BN	205/250, 205/217, 205/250X, 205/Ty-Ply BN	6250, 607, AP-133, Y-4310	205/6250	610	--
Polybutadiene	250, 250X, 252X, 253X, 6254	205/233, 205/233X, 205/234B, 205/234X	6250, 6253, 6254, 6016, EP6804-22	205/6250, 205/6100, 205/6108, 205/6253, 205/6254, 205/6411**, 205/EP6804-22	--	--
Polychloroprene	250, 250X, 252X, 253X, 258XN, 6254	205/233, 205/233X, 205/234B, 205/234X, 205/258XN, 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	250, 250X, 252X, 253X, 6254	205/220, 205/220X, 205/233, 205/233X, 205/234B, 205/234X, 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
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	250, 250X, 252X, 258XN, 253X	205/220, 205/220X, 205/233, 205/233X, 205/234B, 205/234X, 205/250, 205/250X, 205/253X, 205/258XN, 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	--	--

* EPCA refers to 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, 220, 220X, 6125 or 6220 adhesive or Ty-Ply BN adhesive.

Typical Properties of Chemlok® 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
218	Urethane-to-metal 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	50-120	14 (58)	Denatured Ethanol	1 year
250	General purpose adhesive	Black	200-550	33 (92)	Xylene, Toluene	1 year
250X	General purpose adhesive	Black	100-550	28 (82)	Xylene, Toluene	6 months
252X	General purpose adhesive	Black	20-40 seconds Zahn #3	26 (79)	Xylene, Toluene	1 year
252H	General purpose adhesive	Black	500-2,000	9 (48)	Xylene, Toluene	6 months
253X	General purpose adhesive	Black	40-90 seconds Zahn #2	27 (80)	Xylene, Toluene	1 year
253H	General purpose adhesive	Black	300-2,000	9 (48)	Xylene, Toluene	6 months
256	General purpose adhesive	Black	100-350	7 (44)	Xylene, Toluene	1 year
258XN	Non-conductive general adhesive	Brown	150-600	28 (85)	Xylene, Toluene	6 months
402	Rubber-to-textile adhesive	Black	100-350	>93 (>200)	Xylene, Toluene	6 months
402X	Rubber-to-textile adhesive	Black	600-1,100	25 (77)	Xylene, Toluene	6 months
485/44	Clear, two-part for bonding PVC	Clear to Amber/ Transparent Brown	400-1,000/<10	-4 (24)/29 (85)	Xylene	1 year/1year
487 A/B	Clear, two-part 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/<8	16 (61)/27 (80)	Xylene, Toluene	6 months/ 1year
607	Adhesive for Silicone/specialties	Colorless	--	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
855	General purpose aqueous adhesive	Olive-green to Black	20-200	>93 (>200)	Deionized Water, Ethanol	3 months
5150	Adhesive for bonding Fluoroelastomers to metal	Colorless to Pale Yellow	= 2 centistokes	6 (43)	--	1 year
5151	Adhesive for Fluoroelastomers	Reddish-yellow	25-30 seconds Zahn #1	-5 (22)	MEK	6 months
6016	Low-lead Chemlok 253 type	Black	35-100 seconds Zahn #3	27 (80)	Xylene, Toluene	1 year
6250	Low-lead Chemlok 250 type	Black	100-550	27 (80)	Technical Grade Xylene, Toluene	--
6253	Low-lead Chemlok 253 type	Black	10-46 seconds Zahn #3	27 (80)	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 type	Black	25-45 seconds Zahn #3	5 (41)	Xylene, Toulene	1 year
6260	Non-black Chemlok 6254 type	Brown	100-600	6 (44)	Xylene, Toulene	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
TS3505-3	Butt splice adhesive for general purpose elastomers	Black	100,000-400,000	9 (48)	Toluene	1 year
Ty-Ply BN	Adhesive for Nitrile	Black	20-35 seconds	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	= 3 centistokes	11 (52)	Methanol, Ethanol	1 year
217	Adhesive for Polychloroprene and Nitrile elastomers	Black	75-150	-2 (28)	MEK/Xylene Mix	1 year
TS701-43	Clear version of Chemlok 217	Translucent Amber	60-150	-2 (28)	MEK	1 year

Typical Properties of Chemlok® Two-Coat Systems

Product	Description	Color	Viscosity, cps (except as noted)	Flash Point °C (°F)	Diluent	Shelf Life
220	General purpose adhesive	Black	135-300	28 (83)	Xylene, Toluene	2 years
220X	General purpose adhesive	Black	70-200	27 (81)	Xylene, Toluene	1 year
225X	General purpose adhesive	Black	50-200	27 (81)	Xylene, Toluene	6 months
233	General purpose adhesive	Black	100-300	33 (92)	Xylene, Toluene	1 year
233X	General purpose adhesive	Black	30-60 seconds Zahn #2	27 (81)	Xylene, Toluene	6 months
234B	General purpose adhesive	Black	450-900	28 (83)	Xylene, Toluene	1 year
234X	General purpose adhesive	Black	300-600	27 (81)	Xylene, Toluene	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	Adhesive for Butyl & EPDM	Black	200-800	33 (92)	Xylene, Toluene	1 year
259	General purpose adhesive	Green-Black	100-500	6.6 (44)	Xylene, Toluene	6 months
286	Tacky tie cement for Natural Rubber	Black	450-1,200	4 (40)	Xylene, Toluene	6 months
289	Primer for Natural Rubber lining	Green	20-450	6 (42)	--	1 year
290	Adhesive for Natural Rubber lining	Red	20-50	7 (44)	Xylene, Toluene	1 year
950	General purpose adhesive	Black	250-1,500	16 (61)	Xylene, Toluene, MIBK	6 months
6100	Low-lead Chemlok 252X type	Black	350-800	27 (81)	Xylene, Toluene	1 year
6108	Low-lead Chemlok 252H type	Black	30-74 seconds Zahn #4	27 (80)	Xylene, Toluene	1 year
6125	Improved heat-resistance Chemlok 220 type	Black	70-300	27 (81)	Xylene, Toluene	1 year
6220	Low-lead Chemlok 220 type	Black	100-300	27 (81)	Xylene, Toluene	1 year
6225	Low-lead Chemlok 225X type	Black	25-80 seconds Zahn #2	27 (80)	Xylene, Toluene	1 year
6411	Low-lead adhesive*	Black	200-600	25 (77)	--	1 year
6411LH	Low-HAP Chemlok 6411	Black	200-600	14 (58)	T-Butyl Acetate, Dimethyl Carbonate	6 months
8210	Aqueous adhesive	Black	200-500	>93 (>200)	Deionized Water	6 months
8212	Aqueous adhesive	Black	25-500	>93 (>200)	Deionized Water	6 months

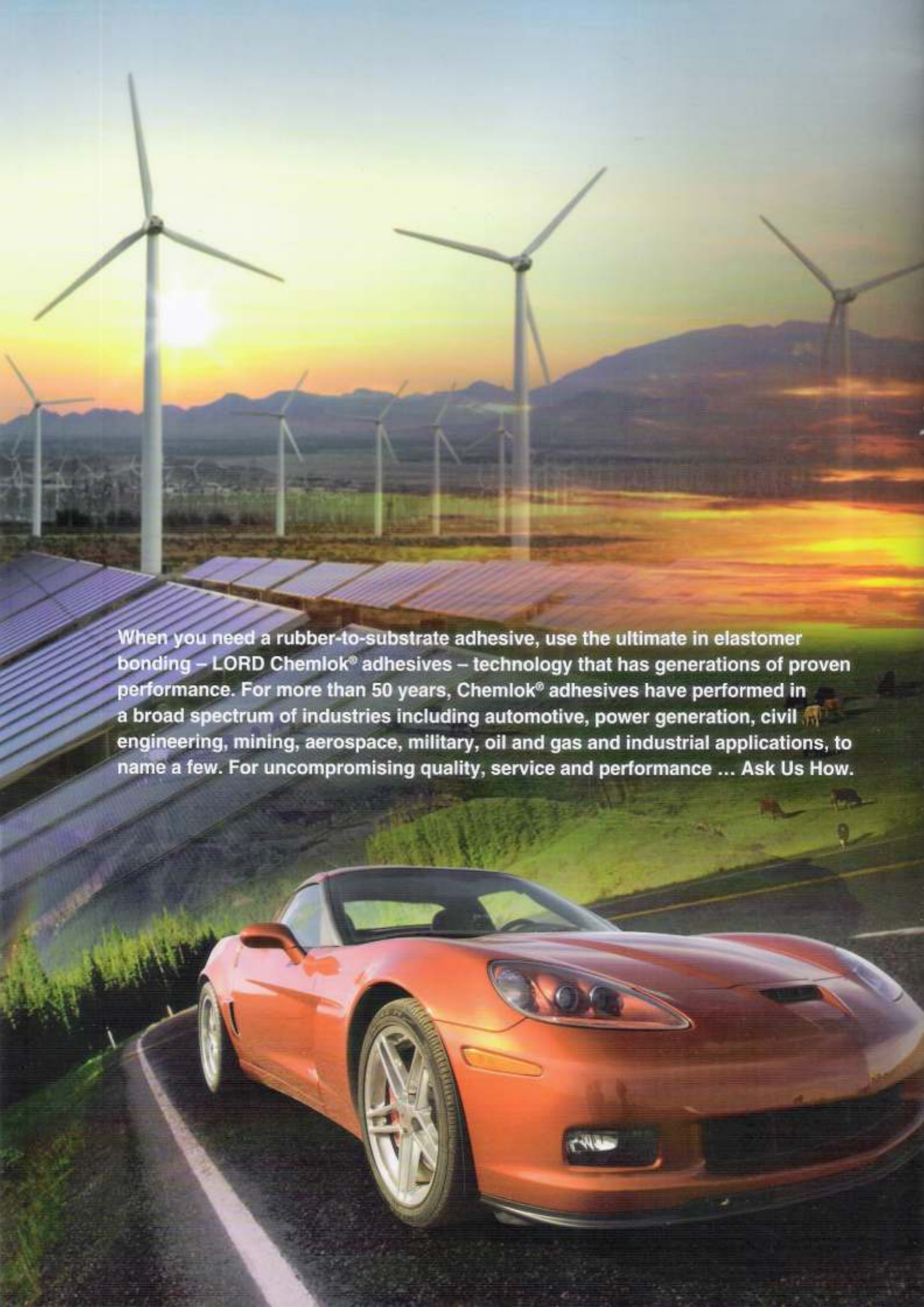
* While not intentionally formulated into the product, lead can sometimes be a trace contaminant in raw materials (e.g., mineral fillers) and may be detectable in random sampling at very low levels (generally less than 100 ppm).

Typical Properties of Chemlok® Primers

Product	Description	Color	Viscosity, cps (except as noted)	Flash Point °C (°F)	Diluent	Shelf Life
205	General purpose primer/ Nitrile adhesive	Gray	85-165	19 (66)	MIBK, MEK	1 year
205LH	Low-HAP Chemlok 205	Blue	10-550	13 (56)	MPK	6 months
207	Heat-resistant primer	Gray	70-450	14 (58)	MIBK, MEK	6 months
2000	General purpose primer/Nitrile adhesive	Blue	10-250	19 (66)	MIBK, MEK	6 months
207LH	Low-HAP Chemlok 207	Blue	50-800	19 (67)	MAK, MPK	6 months
901	Solvent-based primer for Chemlok 950	Gray	25-425	16 (61)	MIBK	6 months
8006	Environmentally-resistant aqueous primer	Gray	15-100	>93 (>200)	Deionized Water	6 months
8007	General purpose primer	Gray	20-250	>93 (>200)	Deionized Water	3 months
8008	Aqueous primer	Green	10-250	>93 (>200)	Deionized Water	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	--	--	--	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
144	Solvent-borne primer with UV tracer	Clear, Light Straw	1-8 centistokes	1.6 (35)	Technical Grade Toluene, Methanol, Ethanol	1 year
EP5080-11	Clear Chemlok 205 primer/Nitrile adhesive	Hazy Amber	28-35 seconds Zahn #1	15 (59)	MEK, MIBK	1 year

Typical Properties of Chemlok® Additives/Solvents

Product	Description	Color	Viscosity, cps (except as noted)	Flash Point °C (°F)	Diluent	Shelf Life
EP5081-40	Fluorescing additive for clear Chemlok adhesives	Clear	--	11 (52)	--	1 year
248	Thinner for Chemlok 213	Blue	Water Thin	3 (37)	--	1 year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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 for specific product end uses, contact the Customer Support Center.

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