Chemlok® 2332 Adhesive

Technical Data Sheet

Chemlok® 2332 adhesive is a covercoat adhesive that bonds a wide variety of unvulcanized or vulcanized rubber compounds to primed metals or other rigid substrates. Chemlok 2332 adhesive will also bond treated textiles to rubber during vulcanization process. It is composed of a mixture of polymers, organic compounds and mineral fillers dissolved or dispersed in an organic solvent system.

Chemlok 2332 adhesive is recommended for use over Chemlok 205 or Chemosil® 211 primer.

Features and Benefits:

Versatile – when used in combination with Chemlok 205 or Chemosil 211 primer, bonds a wide variety of cured and uncured elastomer compounds to rigid substrates; bonds treated textiles to rubber during vulcanization.

Improved Shelf Life – resists hard settling.

High Temperature Resistant – withstands temperatures, up to 149°C (300°F), often encountered during routine service of bonded assembly.

Environmentally Resistant – provides high strength systems capable of withstanding salt spray, heat and water when used in combination with Chemlok 205 or Chemosil 211 primer.

Easy to Apply – applies easily by spray, dip, brush or roll coat methods.

Elastomers:

- Natural Rubber (NR)
- Polyisoprene (IR)
- Styrene-butadiene (SBR)
- Polybutadiene (BR)
- Polychloroprene (CR)
- Hydrogenated Nitrile (HNBR)
- Polyepichlorohydrin (ECO)
- Nitrile (NBR)
- Butyl (IIR)
- Polyacrylate (ACM)
- Millable Urethane
- Hytrel TPE only

Application:

Surface Preparation – Thoroughly clean metal surfaces prior to 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.

Allow primer to thoroughly dry before applying Chemlok 2332 adhesive.

For further detailed information on surface preparation of specific substrates, refer to Chemlok Adhesives application guide.

Mixing – Thoroughly stir adhesive before use, and agitate sufficiently during use to keep dispersed solids uniformly suspended. If dilution is needed, use xylene or toluene. Note proper dilution for the various application methods is best achieved by experience. Give careful attention to agitation since dilution will accelerate settling.

Typical Properties*

Appearance	Black Liquid
Viscosity, cps @ 25°C (77°F) Brookfield LVT Spindle 2, 30 rpm	100 - 300
Density kg/m^3 (lb/gal)	 922.7 - 982.6 (7.7 - 8.2)
Solids Content by Weight, %	23 - 26
Flash Point (Seta), °C (°F)	27 (81)
Solvents	Xylene

*Data is typical and not to be used for specification purposes.

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

Regardless of application method, the dry film thickness of Chemlok 2332 adhesive should be 12.7-17.8 micron (0.5-0.7 mil). When bonding textile, increase recommended dry film thickness by 6-10%.

Drying/Curing – Allow applied adhesive to dry until visual examination of the film has shown that all solvent has evaporated. This will take approximately 30-60 minutes at room temperature. Drying time can be shortened by either preheating the metal inserts or oven drying after application. Metal parts can be preheated to a maximum of 65°C (150°F) prior to adhesive application. Maximum air flow at minimum temperatures will give the best results.

Cleanup – Use solvents such as xylene or MEK to remove adhesive before heat is applied. Remove cured adhesive by mechanical blasting methods.

Shelf Life/Storage:

Shelf life is nine months from date of manufacture when stored by the recipient below 25°C (77°F) in original, unopened container. Do not store or use near heat, sparks or open flame.

Chemlok 2332 adhesive is moisture sensitive. Minimize exposure to moisture by preparing only what is needed for several hours of use.

Cautionary Information:

Before using this or any Parker 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 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.

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