

# Chemlok® 855-1 Adhesive

## Technical Data Sheet

Chemlok® 855-1 adhesive is a general purpose, one-coat water-based adhesive used to bond a wide variety of vulcanized and unvulcanized rubber compounds to metal.

### Features and Benefits:

**Versatile** – serves as a post vulcanization (cured rubber) bonding agent capable of bonding a wide variety of vulcanized rubber compounds.

**Convenient** – can be applied without dilution; requires only a single coat for most applications, reducing labor, inventory and shipping costs.

**Environmentally Recommended** – contains no volatile organic compounds (VOC), eliminating hazardous pollutants.

**Durable** – provides excellent dry film characteristics, resulting in a chip-resistant film.

### Elastomers:

- Natural Rubber (NR)
- Polychloroprene (CR)
- Polyisoprene (IR)
- Nitrile (NBR)
- Styrene-butadiene (SBR)
- EPDM Polymers
- Polybutadiene (BR)
- Chlorinated Polyethylene (CPE)
- Chlorosulfonated Polyethylene (CSM)

### 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.

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

**Mixing** – Thoroughly mix adhesive before use, and agitate sufficiently during use to keep dispersed solids uniformly suspended.

**Applying** – Apply adhesive by spray, dip or brush methods. For best results, preheat the metal parts to 49-71°C (120-160°F) in a recirculating forced air oven prior to application.

Regardless of application method, the dry film thickness of Chemlok 855-1 adhesive should be 12.7-25.4 micron (0.5-1.0 mil). Where minimum environmental resistance is required, film thickness in the lower range can be used on easy-to-bond rubber compounds. Thicker films within this range may be necessary on certain hard-to-bond rubber compounds where maximum environmental resistance is required or for post vulcanization bonding.

### Typical Properties\*

Appearance	Green/Black Liquid
Viscosity, cps @ 25°C (77°F) Brookfield LVT Spindle 2, 30 rpm	20 -200
Density kg/m <sup>3</sup> (lb/gal)	1150.3 - 1246.2 (9.6 - 10.4)
Solids Content by Weight, %	43 - 46
Flash Point (Seta), °C (°F)	>93 (>200)
Solvents	Deionized Water
pH	6 - 8

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

**Drying** – Allow applied adhesive to air-dry for approximately 30 minutes at room temperature. Allow longer dry times during humid conditions.

## Shelf Life/Storage:

Shelf life is six months from date of manufacture when stored by the recipient in a well ventilated area at 21-27°C (70-80°F) in original, unopened container. Do not freeze product.

## 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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