

# Chemlok® 8560D-1 Adhesive

## Technical Data Sheet

Chemlok® 8560D-1 adhesive is a general purpose, one-coat water-based adhesive that bonds a wide variety of vulcanized and unvulcanized rubber compounds to metal. It is suitable for dip applications and may be diluted for spraying.

When environmental conditions are severe, Chemlok 8560D-1 adhesive is recommended to be used over Chemlok 8007 Blue water-based primer.

### Features and Benefits:

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

**Convenient** – requires only a single coat for most applications, reducing labor, inventory and shipping costs.

**Environmentally Preferred** – uses water for dilution; has low VOC emissions.

### Elastomers:

- Natural Rubber (NR)
- Polychloroprene (CR)
- Polyisoprene (IR)
- Nitrile (NBR)
- Styrene-butadiene (SBR)
- Butyl (IIR)
- Polybutadiene (BR)
- EPDM Polymers
- Polyacrylate (ACM)
- Ethylene Acrylic (AEM)
- Polyepichlorohydrin (ECO)
- 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. Do not shake. To prevent foaming, mechanical mixing should not exceed 30 rpm. The addition of anti-foaming agents is not recommended.

If dilution is needed, use deionized water.

**Applying** – Apply adhesive by spray or dip methods. For best results, preheating the metal parts to 49-60°C (120-140°F) prior to adhesive application is recommended.

Regardless of application method, the dry film thickness of Chemlok 8560D-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.

**Drying** – Allow applied adhesive to air-dry for 30-60 minutes at room temperature. Oven drying at 49-71°C (120-160°F) in a recirculating forced air oven is recommended. Allow longer dry times during humid conditions.

### Typical Properties\*

Appearance	Black/Green Liquid
Viscosity, cps @ 25°C (77°F) Brookfield LVT Spindle 2, 30 rpm	100 - 500
Density kg/m <sup>3</sup> (lb/gal)	1186.3 - 1234.2 (9.9 - 10.3)
Solids Content by Weight, %	43 - 47
Flash Point (Seta), °C (°F)	>93 (>200)
Solvents	Deionized Water

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



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## Shelf Life/Storage:

Shelf life is three months from date of shipment when stored by the recipient 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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Parker LORD  
Engineered Materials Group

111 LORD Drive  
Cary, NC 27511-7923  
USA

[www.lord.com](http://www.lord.com)