Chemlok® CB203 Cold-Bonding Adhesive

Description

LORD Chemlok® CB203 adhesive is a two-component, cold-bonding adhesive system designed for bonding textile-reinforced rubbers and primed metals used in belting, lagging, and rubber repair operations. Chemlok CB203 adhesive cures at ambient temperatures without a vulcanization press, rapidly restoring belt splices and edges back to operation.

Note: Belt configurations, along with elastomers and reinforcing agents used, can vary greatly. LORD recommends testing Chemlok CB203 adhesive with your belt configuration to determine fitness for use. For those unable to produce quantitative data at your facilities, LORD Corporation can assist with side-by-side testing of conventionally-repaired substrates to substrates repaired with Chemlok CB203 adhesive.

Features and Benefits

Room Temperature Cure - cures at ambient temperature with minimal pressure, requiring zero vulcanization equipment for belt splices and repairs; develops handling strength in 3 hours, with full cure in 24 hours or less.

Environmentally Compliant – contains no solvent; formulated with no VOCs.

Non-Flammable – does not require explosion-proof equipment.

Environmentally Resistant – resists sunlight, weathering, humidity and salt spray.

Chemically Resistant – solvent resistant when cured. Painting and most cleaning processes do not affect bond strength.

Application

Surface Preparation – Surfaces should be free of grease, dirt and other contaminants.

For rubber-to-metal repairs, ensure that all metals are prepared to NACE 1 “white-metal’ status, cleaned, and primed.

For belting repair, choose the appropriate splice for the belt being repaired (skive, finger, clipper). Prepare belt splice in the same manner as it would prepared if doing a vulcanized repair.

Note: Difficult-to-bond rubber substrates may benefit from treatment with Chemlok CB203CS adhesion enhancer/surface modifier.

Typical Mixed Properties*

Mix Ratio, by Volume	1:1
Solids Content, %	100, zero VOC
Working Time, min @ 24°C (75°F)	20-30
Time to Handling Strength, hr @ 24°C (75°F)	3
Flash Point, °C (°F)	>93 (>201)

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

Mixing – The adhesive system has a 1:1 mix ratio, by volume. Dispensing through handheld cartridges is required to ensure correct volumetric ratio of each component.

Applying – Apply adhesive to splice or belt repair.

1. Load the cartridge into the applicator gun and remove the end caps.
2. Level the plungers by expelling a small amount of adhesive on waste paper to ensure both sides are level.
3. Attach mixing tip and expel a mixer's length of adhesive on waste paper.
4. Apply adhesive to one side of the splice/repair joint. Apply enough adhesive that it can be spread across the entirety of the belt/repair joint.
5. Spread the dispensed adhesive with a brush, spatula, level, or mixing stick until it is uniformly applied across the surface of the splice. A correctly applied layer of adhesive will be uniform and 0.75-1.5 mm (0.03-0.06 inches) thick.
6. Mate parts within the working time of the adhesive. Apply moderate weight/pressure on the belt joint until adhesive reaches handling strength.

Curing – Adhesive will reach 80% of its strength within 3 hours, and full cure strength in 24 hours or less, when cured at 24°C (75°F).

Cleanup – Clean equipment and tools prior to the adhesive cure with organic solvents such as acetone or methyl ethyl ketone (MEK). Do not use alcohol. Once adhesive is cured, heat the adhesive to 300°F (149°C) or above to soften the adhesive. This allows the parts to be separated and the adhesive to be more easily removed. Some success may be achieved with commercial adhesive strippers.

Shelf Life/Storage

Shelf life is one year when stored at 65-85°F (18-30°C) in original, unopened foil package. Prolonged exposure to temperatures below 50°F (10°C) during shipping or storage may cause variations in cured properties and/or significant reduction in shelf life.

After dispensing product, protect adhesive from excessive exposure to moisture by removing the mixing tip and installing supplied cartridge plugs.

Cautionary Information

Before using this or any 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 technical data sheet 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.

Information provided herein is based upon tests believed to be reliable. In as much as LORD Corporation has no control over the manner in which others may use this information, it does not guarantee the results to be obtained. In addition, LORD Corporation does not guarantee the performance of the product or the results obtained from the use of the product or this information where the product has been repackaged by any third party, including but not limited to any product end-user. Nor does the company make any express or implied warranty of merchantability or fitness for a particular purpose concerning the effects or results of such use.

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LORD provides valuable expertise in adhesives and coatings, vibration and motion control, and magnetically responsive technologies. Our people work in collaboration with our customers to help them increase the value of their products. Innovative and responsive in an ever-changing marketplace, we are focused on providing solutions for our customers worldwide.

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