

Chemlok® 320/310-B and 320/310-B Black Epoxy Adhesives

Description

LORD Chemlok® 320/310-B and 320/310-B Black adhesives are two-component epoxy adhesive systems used to bond cured rubber treated with Chemlok 7701 surface treatment. These adhesive systems also bond metals and plastics, both thermosets and thermoplastics.

Features and Benefits

Fast Cure – rapidly cures when heated at 93-162°C (200-325°F).

Durable – provides good impact resistance down to -40°C (-40°F).

Environmentally Friendly – contains no solvent, nonflammable and virtually odorless.

Environmentally Resistant – resists humidity, salt spray and temperature extremes.

High Temperature Resistant – resists postbakes up to 204°C (400°F).

Chemically Resistant – solvent resistant when cured; anti-corrosion processes including phosphatizing and ELPO (e-coat) coatings do not affect the adhesive or its bond strength.

Application

Surface Preparation – Remove soil, grease, oil, fingerprints, dust, mold release agents, rust and other contaminants from the surfaces to be bonded by solvent degreasing or alkaline cleaning.

On metal surfaces which are free of oxidation, use an isopropyl alcohol wipe. If necessary, use an abrasive material to remove tarnish. Always follow abrasion by a second cleaning to ensure removal of loose particles.

When bonding cured rubber, allow Chemlok 7701 surface treatment to flash off before applying Chemlok 320/310-B or 320/310-B Black adhesive. Prime glass and ceramic surfaces with Chemlok AP-134 primer to promote adhesion.

Handle prepared surfaces carefully to avoid contamination. Assemble as soon as possible.

Typical Properties*

	320 Resin	310-B Hardener	310-B Black Hardener
Appearance	Off-white Paste	Gray Paste	Black Paste
Viscosity, cps @ 25°C (77°F) Brookfield HBF Helipath, 5 rpm	300,000-1,000,000	230,000-690,000	200,000-700,000
Density kg/m ³ (lb/gal)	1498-1546 (12.5-12.9)	1198-1318 (10.0-11.0)	1234-1318 (10.3-11.0)
Solids Content by Weight, %	100	100	100
Flash Point (Seta), °C (°F)	>93 (>200)	>93 (>200)	>93 (>200)

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

LORD TECHNICAL DATA

Mixing – Mix Chemlok 320 resin with either Chemlok 310-B or 310-B Black hardener at a ratio of 1:1, by volume. Adhesive properties such as hardness and flexibility can be varied by changing the mix ratio.

Thoroughly mix the components until uniform in color and consistency. Be careful not to whip excessive air into the adhesive system. Handheld cartridges will automatically dispense the correct volumetric ratio of each component.

Heat buildup due to an exothermic reaction between the two components will shorten the working time of the adhesive. Mixing smaller quantities will minimize heat buildup. Do not use any adhesive that has begun to cure.

Applying – Apply the mixed adhesive in bead form. Use automatic meter/mix/dispense equipment for large applications. For small applications, use handheld cartridges or a disposable paper cone to apply the adhesive in a continuous bead. For general use, a film thickness of approximately 0.51-0.76 mm (0.02-0.03 inch) is recommended. To control bondline thickness, a small amount of solid glass beads can be added into the mixed adhesive.

Join the parts in such a way as to avoid entrapped air. Apply only enough pressure to ensure good wetting of the adhesive on both surfaces. Squeezing a little adhesive out at the edges is usually a sign of proper assembly. It is not necessary to clamp the assembly unless movement during adhesive cure is likely.

Maximum adhesion will occur only with parts which mate well without the need for excessive clamping pressure during cure. Excessive clamping may squeeze too much adhesive from the bond area which can result in a poor bond.

Curing – Handling strength is achieved after curing for 6-8 hours at room temperature. Chemlok 320/310-B and 320/310-B Black adhesive will cure to full strength in approximately 24 hours at room temperature.

Higher temperatures will provide faster cure times; however, the bondline temperature should not exceed 162°C (325°F). When heated at 66°C (150°F), full cure strength can be obtained in 2.5 hours; when heated at 93°C (200°F), full cure strength can be obtained in 25 minutes; when heated to 121°C (250°F), full cure strength can be obtained in 15 minutes. Elevated temperature cure produces the highest bond strengths and impact resistance. Firm recommendations of cure times and temperatures depend on material composition and heating methods.

Once the adhesive has cured, it can be filed, sanded, machined or otherwise handled in the same way as a light metal. Paint, lacquers, enamels and other coatings can be applied to cured adhesive.

Typical Properties* of Resin Mixed with Hardener

	320/310-B	320/310-B Black
Mix Ratio, Resin to Hardener		
by Volume	1:1	1:1
by Weight	1.2:1	1.2:1
Solids Content, %	100	100
Working Time, hr	0.5-1	0.5-1
Time to Handling Strength, hr	6-8	6-8
Mixed Appearance	Gray Paste	Black Paste
Cured Appearance	Gray	Black

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Cleanup – Clean excess adhesive on the bonded assembly, as well as the equipment, prior to the adhesive cure with hot water and detergent or an organic solvent such as ketones. Once adhesive has cured, heat the adhesive to 204°C (400°F) or above to soften the cured adhesive. This allows the parts to be separated and the adhesive to be more easily removed. Some success may be achieved with commercial epoxy strippers.

Shelf Life/Storage

Shelf life is one year from date of shipment when stored at 21-27°C (70-80°F) in original, unopened container.

Bond Performance

Substrates	Cold Rolled Steel to Cold Rolled Steel Lap Shear psi (MPa)	Aluminum to Aluminum Lap Shear psi (MPa)	SMC to SMC Lap Shear psi (MPa)	Natural Rubber to Cold Rolled Steel 45° Peel pli (N/mm)	SBR to SBR T-Peel pli (N/mm)
Test @ Room Temperature Failure Mode	3017 (20.8) C	2258 (15.6) C	583 (4.0) FT	45 (7.8) C	28 (4.9) A
Test @ Hot Strength, 82°C (180°F) Failure Mode	2252 (15.5) C	2213 (15.3) C	612 (4.2) FT	63 (11.1) SF	40 (7.0) SF/C
Test after 7 days in H ₂ O @ 54°C (130°F) Test after 24 hours Failure Mode	2759 (19.0) C	2811 (19.4) C	567 (3.9) FT	92 (16.2) SF	26 (4.5) A
Test after 14 days Salt Spray Exposure Test Immediately Failure Mode	2574 (17.7) C	2452 (16.9) C	555 (3.8) FT	39 (6.8) SF	31 (5.4) SF/A
Test after 14 days @ 38°C (100°F), 100% RH Test Immediately Failure Mode	3084 (21.3) C	2594 (17.9) C	542 (3.7) FT	42 (7.3) SF	30 (5.2) SF/A
Test @ -34°C (-30°F) Failure Mode	3225 (22.2) C	2093 (14.4) C	657 (4.5) FT	36 (6.3) SF	27 (4.7) A

Substrate

Cold Rolled Steel and Aluminum
Sheet Molded Compound (SMC)
Styrene Butadiene Rubber (SBR)
Natural Rubber

Surface Treatment

MEK Wipe, Grit Blast, MEK Wipe
320-grit Sandpaper, Dry Rag Wipe
Primed with Chemlok 7701 Surface Treatment
Primed with Chemlok 7701 Surface Treatment

Bonded Parameters

Metal Lap Shears
SMC Lap Shears
45° Peels
T-Peels

Bond Area

1.0"x3.5"
1.0"x3.5"
1.0"x1.0"
1.0"x3.0"

Film Thickness

0.010"
0.030"
0.020"
0.020"

Cure

72 hr @ RT
72 hr @ RT
72 hr @ RT
72 hr @ RT

Mix Ratio

1:1 by Volume
1:1 by Volume
1:1 by Volume
1:1 by Volume

Failure Mode Definition

Adhesive Failure
Cohesive Failure
Fiber Tear
Sub Failure

Abbreviation

A
C
FT
SF

LORD TECHNICAL DATA

Cautionary Information

Before using this or any LORD product, refer to the Material Safety Data Sheet (MSDS) 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.

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