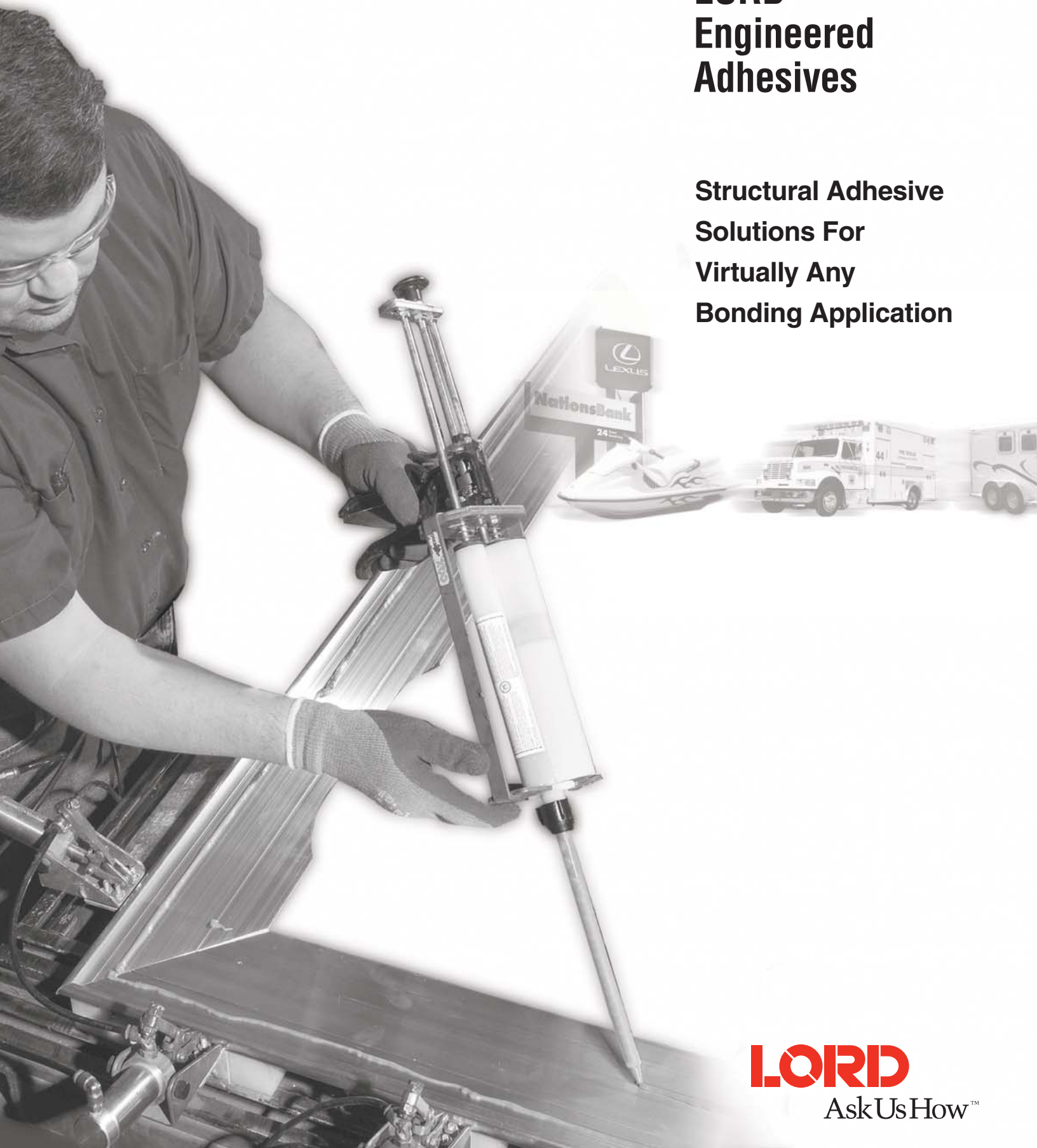


LORD® Engineered Adhesives

**Structural Adhesive
Solutions For
Virtually Any
Bonding Application**



We offer a full line of acrylic, epoxy and urethane adhesives.

We are your engineering partner, helping you achieve your design goals.

LORD® ENGINEERED ADHESIVES

Delivering solutions that improve our customers' products and processes by applying unique expertise in chemical/material sciences and mechanical dynamics, LORD develops, manufactures and markets innovative adhesive, coating and motion management solutions. With more than 40 years experience in developing and manufacturing engineered adhesives, our broad line of LORD acrylic, epoxy and urethane adhesives improve appearance, strength, durability and manufacturing costs.

DELIVERING EXCEPTIONAL PERFORMANCE

Unlike traditional fastening solutions such as welding or mechanical fasteners, LORD structural adhesives eliminate the time and cost associated with metal preparation and finishing operations, and are formulated to provide exceptional performance and tough, durable bonds to a wide variety of composite, metal and plastic assemblies. LORD structural adhesives offer design flexibility, improved aesthetics and total cost savings compared to traditional assembly methods, while bonding dissimilar materials, insulating against galvanic corrosion and offering excellent environmental resistance.



OFFERING NEW ASSEMBLY OPTIONS AND COST SAVINGS

LORD® Engineered Adhesives are a durable and attractive fastening solution replacing welds, rivets, screws, tape and other traditional fastening methods. Many of the major automotive, utility body, trailer, bus and heavy-duty truck companies are already in production or are at some level of specification/evaluation using LORD adhesives. The primary reasons these companies have changed to our adhesive systems include:

Significant Cost Reduction

- Reduction in total assembly cost
- Reduced labor time
- Reduced material costs
- Reduced post processing
- Reduced cycle times

Improvements in Aesthetics

- Replacement of mechanical fasteners and weld scars

Improvements in Durability

- A well-designed adhesive joint can exceed the service life of welds and mechanical fasteners

*LORD Engineered
Adhesives perform
in demanding
applications under
severe loads.*

*Greater design
freedom promotes
innovation and
improved aesthetics.*



PROVIDING A COMPETITIVE ADVANTAGE

LORD adhesives provide benefits in all critical areas of your operation.

Manufacturing Benefits

- Processing convenience
- Ease of use
- Minimal surface preparation
- More streamlined appearance — no refinishing
- Can reduce number of parts/ inventory items through redesign

Design Benefits

- Design freedom
- Easy joining of complicated shapes
- Ability to join dissimilar substrates
- Smooth seams — no rivets
- Multi-functional
 - Structural connection
 - Sealant
 - Insulator
 - Vibration dampener

Performance Benefits

- Very high strength
- Stress distribution minimizes stress concentrations
- Maximizes assembly stiffness for a given design
- Often improves assembly fatigue life

Additional Benefits

- Reduces corrosion
- Keeps coatings intact
- Can reduce weight

BACKED BY THE EXPERIENCE OF LORD

Working with you, our technicians identify the adhesive that best meets your product requirements and conforms to your demanding specifications.

	Bare Aluminum or Steel, including Stainless	Galvanized Steel	Prefinished Metal	FRP/GRP	SMC	Rubber (1)	Engineering Thermoplastics (polycarbonate, acrylic, ABS, PVC) (5)	Wood	Urethane Foam (2)	Ceramic/Stone	Thermoplastic, TPU, TPO, Nylon, Polypropylene (3)
Bare Aluminum or Steel, including Stainless	2XX 4XX 6XX 3XX (4,6)	2XX 4XX 6XX 3XX (4,6)	2XX 4XX 6XX 3XX (4,6)	2XX 4XX 6XX 3XX (4,6)	2XX 4XX 6XX 3XX (4,6)	3XX (1,4)	2XX 4XX 6XX 3XX (4) 75XX (2)	3XX (4) 75XX	6XX 3XX (4) 76XX	3XX (4) 75XX 76XX	2XX 4XX 3XX (4) 75XX
Galvanized Steel		2XX 4XX 606 (2)	2XX 4XX 606 (2)	2XX 4XX 606 (2)	2XX 4XX 606 (2)	2XX 606 (2)	2XX 4XX 606 (2)	606 (2)	606 (2)	3XX	2XX 4XX 606 (2)
Prefinished Metal			2XX 4XX 6XX 3XX 75XX 76XX	2XX 4XX 6XX 3XX 75XX (6) 76XX (6)	2XX 4XX 6XX 3XX 75XX 76XX	6XX (1,6) 3XX (1,6) 76XX (1,6)	2XX (6) 4XX (6) 6XX (6) 3XX (6) 75XX (6) 76XX (6)	3XX 75XX 76XX	6XX 3XX 75XX 76XX	2XX (1,6) 4XX (1,6) 6XX (1,6) 3XX (1,6) 76XX (1,6)	2XX 4XX 6XX 3XX 75XX 76XX
FRP/GRP				2XX 4XX 6XX 3XX (6) 75XX (6)	6XX 3XX (6) 75XX (6)	3XX (1) 75XX (1)	6XX 3XX 75XX (6)	606 3XX 75XX	6XX 3XX 75XX	6XX 3XX 75XX	6XX (1) 3XX (1) 75XX (1)
SMC					606 3XX 75XX	6XX 3XX (1) 75XX (1)	2XX 4XX 6XX 3XX 75XX	606 3XX 75XX	6XX 3XX 75XX	6XX 3XX 75XX	6XX (1) 3XX (1) 75XX (1)
Rubber (1)						3XX 75XX	3XX 75XX	3XX 75XX	3XX 75XX	3XX 75XX	3XX 75XX
Engineering Thermoplastics (polycarbonate, acrylic, ABS, PVC) (5)							2XX 4XX 3XX 75XX 76XX	606 3XX 75XX 76XX	2XX 4XX 6XX 3XX 75XX 76XX	2XX 4XX 3XX 75XX 76XX	2XX 4XX 3XX 75XX 76XX
Wood								3XX 75XX 76XX	3XX 75XX 76XX	3XX 75XX 76XX	3XX 75XX
Urethane Foam (2)									3XX 75XX 76XX	3XX 75XX 76XX	3XX 75XX 76XX
Ceramic/Stone										3XX 76XX	3XX 76XX
Thermoplastic, TPU, TPO, Nylon, Polypropylene (3)											606 3XX 76XX

Application Guide Colors:

- Acrylic Adhesives
- Epoxy Adhesives
- Urethane Adhesives

Notes:

- (1) Requires a primer or adhesion promoter.
 - (2) Variable results – Contact Customer Service for special instructions.
 - (3) Flame, corona, plasma treatment or a primer is required – Contact Customer Service.
 - (4) Epoxy used on bare metals requires a clean, solvent-wiped surface for best results.
 - (5) Acrylic adhesive should not be used to attach large thermoplastic parts to metal due to the differences in thermal expansion – Contact Customer Service.
 - (6) May require scuffing or abrading surfaces.
- XX - Represents numbers for the family of adhesives to be utilized – Contact Customer Service.

Selection Considerations

When selecting an adhesive, there are several important considerations at every application phase, including substrate type, surface preparation, temperature, application/cure time and other factors. Use the chart below to determine which LORD solution is best suited for your particular application.

Please note: These are general recommendations. For comprehensive product selection assistance, please contact LORD Technical Support at +1 877 ASK LORD (275 5673), in United States and Canada.

	Acrylic	Epoxy	Urethane
Pre-application Phase			
Components	2	2	1 or 2
Substrate	Metals Thermoplastics Thermosets Composite	Metals Rubber Thermosets Composite	Thermoplastics Rubber Thermosets Primed Metals Composite
Surface Preparation			
Metals	No	Yes	Yes
Thermosets	Yes	No	No
Thermoplastics	No	No	No
Physical State	Med. liquid to paste	Med. liquid to paste	Med. liquid to paste
Packaging	3 oz - 55 gal	3 oz - 55 gal	3 oz - 55 gal
Application Phase			
Cure Temperature	Room temp. or heat	Room temp. or heat	Room temp. or heat
Working Time (min)	1-30*	5-180	4-120**
Handling Time	2-60 min	2-12 hr	0.5-24 hr
Speed cure with:	Mild Heat/Catalyst	Heat	Heat/Catalyst
Flash Point °F (°C)	>50 to 200 (10-93)	>200 (93)	>200 (93)
Humidity Dependent	No	No	Yes, single-component
Mix Required	No***	Yes	Yes****
Post-application Phase			
Shear Strength	Very High	Very High	High
Peel Strength	Medium	Medium	High
Impact Strength	High	High	High
Resistance To:			
Moisture	Excellent	Very good	Very Good
Chemicals	Excellent	Very good	Very Good
UV light	Excellent	Excellent	Very Good
Service Temperature °F (°C)	-40 to 400 (-40 to 204)	-20 to 400 (-29 to 204)	-40 to 350 (-40 to 178)

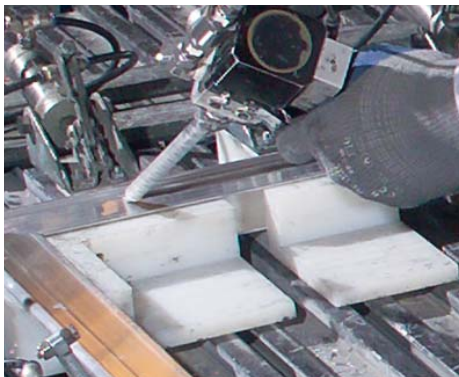
* Potlife for mix-in only; no-mix type has no potlife consideration.

** Potlife for two-component type only.

*** Both mix and no-mix systems are available.

**** Mix required for two-component systems only. Contact LORD Technical Service at +1 877 ASK LORD (275 5673) for specific recommendations.

The above data represents typical values and is not to be used for specification purposes.



The best way to describe LORD® Acrylic Adhesives is “versatile.” These adhesives are ideal for use with a wide range of materials, including minimally prepared or unprepared metal surfaces. LORD 200 and 400 Series Acrylic Adhesives carry the distinction of bonding the largest variety of metals in the world.

LORD Acrylic Adhesives are toughened to provide increased durability and impact strength. They are not limited to metal applications; they also bond plastics and ceramics, thermoplastics like polycarbonate and ABS, and thermosets like Sheet Molded Compounds (SMCs) and Fiberglass Reinforced Plastics (FRPs).

LORD Acrylic Adhesives are two-part systems that use accelerators to cure. The adhesives are available in these series:

LORD Acrylic Adhesive Selection Guide

Adhesive	Description	Appearance	Work Time (min)	Handling Time (min)	Cure Time (hr)	Typical Viscosity (cP)	Density Range	
							(lb/gal)	(kg/m³)
LORD 200 Series Acrylic Adhesives bond minimally prepared or unprepared surfaces with very high strength. They offer excellent adhesion to unprepared metals, ceramic magnets and plastics. Viscosities range from liquid to paste. Handling times range from 2 to 60 minutes.								
201	Medium working time; medium viscosity	Off-white liquid	5-8	12-16	24*	15,000-55,000	8.5-8.7	(1019-1042)
202	Short working time; medium viscosity	Off-white liquid	1-2	2-4	24*	8,000-32,000	9.6-10.35	(1150-1240)
204	Medium working time; high viscosity	Off-white paste	6-8	12-16	24*	100,000-300,000	8.7-9.3	(1042-1114)
206	Long working time; medium viscosity	Off-white liquid	12-14	45-60	24	20,000-80,000	8.5-8.7	(1019-1042)
LORD 400 Series Acrylic Adhesives offer extremely high impact and peel strength. They bond minimally prepared metals and plastics and achieve high shear strengths. They also provide excellent environmental and chemical resistance. Handling times range from 4 to 120 minutes.								
403	Short working time; high viscosity	Off-white to tan paste	2-4	4-6	24*	100,000-280,000	9.25-9.55	(1108-1144)
406	Medium working time; high viscosity	Off-white to tan paste	6-10	12-17	24	100,000-300,000	9.1-9.7	(1090-1162)
410	Long working time; high viscosity	Off-white to tan paste	20-45	60-120	24	100,000-350,000	9.15-9.65	(1096-1156)
LORD 506 Acrylic Adhesive is semi-flexible and heat resistant. This general purpose adhesive bonds a wide variety of thermoplastics and thermoset plastics. Handling times range from 8 to 12 minutes.								
506	Medium cure; medium viscosity; semi-flexible	Translucent liquid	4-6	8-12	24	20,000-70,000	8.25-8.65	(989-1036)
LORD 600 Series Acrylic Adhesives bond with minimal surface preparation. These non-sag adhesives cross-bond FRPs to many metals and are specifically formulated to produce the highest impact and peel strengths available in room temperature curing adhesives. Handling times range from 15 to 60 minutes.								
606	Medium working time; high viscosity	Off-white to white paste	6-10	16-24	24	100,000-300,000	8.7-9.7	(1042-1162)
661	Medium working time; high viscosity	White/off-white/ blue tint paste	11-19**	45-55**	24**	125,000-350,000	8.8-9.8	(1055-1174)
662	Long working time; high viscosity	White/off-white/ blue tint paste	22-38**	70-90**	24**	125,000-350,000	8.8-9.8	(1055-1174)
663	Extended long working time; high viscosity; designed for large beads	White/off-white/ blue tint paste	45-75**	130-160**	48**	125,000-350,000	8.8-9.8	(1055-1174)

* Reaches 90% of ultimate strength after 2 hours.

** Given a 1-inch diameter bead @ 90°F (32°C).

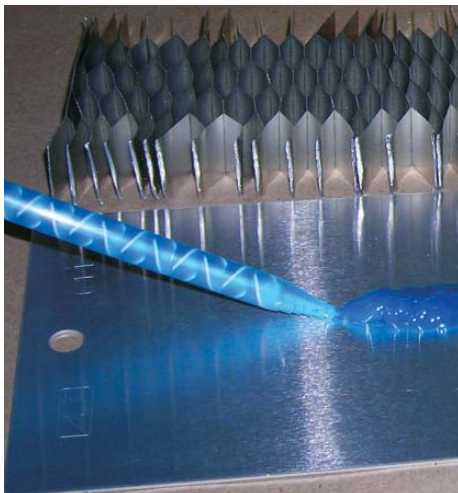
Key Benefits of LORD Acrylic Adhesives are:

- Resist severe environmental conditions.
- Bond with minimal surface preparation.
- Bond oily metal alloys with little preparation.
- Offer fast cure at room temperature.
- Are easy to use and offer a convenient, no-mix feature.
- Have 100% reactive formulations to meet VOC regulations.

LORD Acrylic Adhesive Accelerators

Accelerator	Description	For Use With	Appearance	Typical Viscosity (cP)	Density Range		
					(lb/gal)	(kg/m ³)	(g/cm ³)
4	No-mix accelerator; use with bondline thicknesses of 20 mils or less	200 & 500 Series	Clear amber to white liquid	<10	1.22-1.28	—	(10.2-10.7)
5	Mix-in accelerator; mix at 20:1 ratio	200, 400 & 500 Series	Off-white liquid	1,500-7,000	1.12-1.19	(9.3-9.9)	—
6 & 6GB*	Mix-in accelerator; 10:1 mix ratio; GB version offers bondline control	600 Series	Gray paste	200,000-500,000	12.3-12.9	(1474-1546)	—
				210,000-350,000	12.3-13.0	(1474-1558)	—
17	Mix-in accelerator; 10:1 mix ratio	200, 400, 500 & 600 Series	Off-white liquid	10,000-100,000	9.6-10.4	(1150-1246)	—
19	Mix-in accelerator; 2:1 or 4:1 mix ratio	200, 400 & 500 Series	Off-white paste	150,000-450,000	11.9-12.9	(1426-1546)	—
19 Black	Mix-in accelerator; 2:1 or 4:1 mix ratio	200, 400 & 500 Series	Black paste	100,000-400,000	12.0-13.1	(1438-1570)	—
19GB*	Mix-in accelerator; 2:1 or 4:1 mix ratio	200, 400 & 500 Series	Off-white paste	100,000-400,000	12.6-13.5	(1510-1618)	—
19GB* Red			Red paste		12.4-13.15	(1486-1576)	—
19GB* Gray			Gray paste		12.95-13.7	(1552-1642)	—
26	No-mix accelerator; use with bondline thicknesses of 20 mils or less; no chlorinated solvents	200 & 500 Series	Clear amber to white liquid	<10	7.5-8.5	—	(0.9-1.0)

* GB products contain 0.010" diameter glass beads for bondline thickness control.



Key benefits of LORD Epoxy Adhesives are:

- **High-strength bonds:** Their load-bearing properties are equal to, or exceed, many of the substrates that they bond.
- **Excellent environmental and chemical resistance:** They resist the effects of dilute acids, alkalines, solvents, greases, oils, moisture, sunlight and weathering. LORD Epoxy Adhesives provide optimal performance in service temperatures up to 400°F (204°C).
- **Improved aesthetics for bonded assemblies:** LORD Epoxy Adhesives eliminate the distortion, discoloration and surface marring common to mechanical fastening methods such as screw heads, bolts and welds.
- **Uniform contact between substrates:** They fill irregular contours, ensuring uniform contact where substrate surfaces do not mate — critical to many combinations of wood, fabric, rubber, ceramic, glass and foams.
- **Flexible cure rates:** They cure at room temperature or elevated temperatures (which provide the highest possible bond strength and impact resistance).
- **Full strength is achieved within 24 to 72 hours.**
- **Low shrinkage and good creep properties.**
- **100% solids formulation to meet VOC regulations.**

LORD® Epoxy Adhesives are two-component, room temperature cure formulations and create superior bonds for rubber, SMCs, plastics and metals. Our epoxy adhesives are widely used in the automotive industry — millions of cars and light- and heavy-duty trucks feature body panels bonded with LORD Epoxy Adhesives.

LORD Epoxy Adhesive Selection Guide

Adhesive	Description	Appearance	Work Time*
304-1/304-2	General purpose; high viscosity	Gray paste	1-2 hr
305-1/305-2	General purpose; medium viscosity	Blue liquid	1-2 hr
306-1/306-2	General purpose and for dampening tiles to steel per ML-1-24456; high viscosity	Gray paste	1-2 hr
309-1D/309-2D	General purpose; non-sag; thixotropic; high viscosity	Blue-green paste	1.5-2 hr
309-1DGB/309-2D	General purpose; non-sag; thixotropic; contains 0.010" diameter glass beads for bondline thickness control	Blue-green paste	1.5-2 hr
310-A/310-B	General purpose and composites; high strength; resists temperatures up to 400°F (204°C); high viscosity	Gray paste	0.5-1 hr
310-A/310-B Black	General purpose and composites; high strength; resists temperatures up to 400°F (204°C); high viscosity	Black Paste	0.5-1 hr
312-A/312-B	General purpose; low viscosity	Yellow liquid	1.5-2.5 hr
320/310-B Black	General purpose and composites; toughened with high peel strength; high viscosity	Black paste	0.5-1 hr
320/322	General purpose and composites; wide temperature range; high viscosity	Gray paste	20-40 min
360-A/360-B	Composites, wood and other plastics; minimal sag; fast setting; sandable and paintable	Tan paste	2-4 min
363-A/363-B	General purpose; fast setting	Lt. amber liquid	3-5 min
370-A/370-B	General purpose; safe for painted surfaces	Black paste	20-30 min
3170-A/3170-B	For cryogenic applications; high strength in cold environments	Lt. amber paste	2 hr

* Can be accelerated with heat.

Handling Time*	Cure Time*	Mix Ratio by Vol.	Component	Typical Viscosity (cP)	Density Range	
					(lb/gal)	(kg/m³)
8-16 hr	24-48 hr	1:1.3	304-1 Resin	4MM-40MM	11.5-12.3	(1378-1474)
			304-2 Hardener	2MM-10MM	8.4-9.0	(1007-1078)
8-16 hr	24-48 hr	1:1	305-1 Resin	10,000-18,000	9.4-10	(1126-1198)
			305-2 Hardener	20,000-45,000	7.75-8.35	(928-1001)
8-16 hr	24-48 hr	1:1.3	306-1 Resin	4MM-40MM	11.5-12.3	(1378-1474)
			306-2 Hardener	2MM-10MM	8.4-9.0	(1007-1078)
8-16 hr	24 hr	1:1	309-1D Resin	300,000-1.1MM	10.5-10.8	(1258-1294)
			309-2D Hardener	300,000-1MM	8.25-8.65	(989-1036)
8-16 hr	24 hr	0.635:1	309-1DGB Resin	300,000-1.1MM	10.5-10.9	(1258-1306)
			309-2D Hardener	300,000-1MM	8.25-8.65	(989-1036)
6-8 hr	24 hr	1:1	310-A Resin	400,000-820,000	11.7-12.85	(1402-1540)
			310-B Hardener	230,000-690,000	10.0-11.0	(1198-1318)
6-8 hr	24 hr	1:1	310-A Resin	400,000-820,000	11.7-12.85	(1402-1540)
			310-B Black Hardener	200,000-700,000	10.3-11.0	(1234-1318)
8-16 hr	24-48 hr	1.75:1	312-A Resin	650-1,950	9.3-9.45	(1114-1132)
			312-B Hardener	750-2,500	8.1-8.3	(970-995)
6-8 hr	24 hr	1:1	320 Resin	300,000-1MM	12.5-12.9	(1498-1546)
			310-B Black Hardener	200,000-700,000	10.3-11.0	(1234-1318)
2-4 hr	24 hr	1:1	320 Resin	300,000-1MM	12.5-12.9	(1498-1546)
			322 Hardener	450,000-2MM	10.33-10.54	(1238-1263)
5-10 min	24 hr	1:1	360-A Resin	90,000-180,000	12.0-13.5	(1438-1618)
			360-B Hardener	40,000-180,000	8.5-9.5	(1019-1138)
15-30 min	4-6 hr	1:1	363-A Resin	7,000-16,000	9.4-10.0	(1126-1198)
			363-B Hardener	8,000-20,000	9.3-9.6	(1114-1150)
8 hr	24 hr	1:2	370-A Resin	125,000-240,000	10.5-11.5	(1258-1378)
			370-B Hardener	125,000-350,000	8.7-9.4	(1042-1126)
24 hr	4 days	1:1	3170-A Resin	30,000-70,000	9.5	(1138)
			3170-B Hardener	90,000-170,000	8.1	(971)



LORD Urethane Adhesives are available in several formulations:

- Two-component 100% solids
- Single-component 100% solids
- Single-component high solids

Key benefits of LORD Urethane Adhesives are:

- *Cure at room temperature:* Single-component systems can be accelerated with a catalyst. Two-component systems can be accelerated with heat.
- *Strong, flexible bonds:* They bring excellent structural integrity to assemblies made of plastic, metal, foams and elastomers.
- *Outstanding hot strength to 250°F (121°C).*
- *Ideal for meter/mix/dispense equipment.*
- *Environmentally friendly, 100% solids systems.*

LORD® Urethane Adhesives, available in single- and two-component formulations, provide superior bonds with minimal surface preparation for today's high-performance thermosets and thermoplastics. They offer primerless adhesion for SMCs and are ideal for thermoset and thermoplastic materials, prepared metals, rubber and FRPs.

LORD Urethane Adhesive Selection Guide

Adhesive	Description	Appearance	Work Time*
7100	Two-component; high strength; for cloth, paper, foams, plastics, etc.; room temperature or heat cure	Black liquid Black liquid	5-10 min
7150	Two-component; high strength; for cloth, paper, foams, plastics, etc.; room temperature or heat cure	Blue liquid White liquid	5-10 min
7542	Two-component; for FRP, SMC and other plastics with little surface preparation; can be gravity-fed through dispensing equipment	Dk. brown liquid Tan liquid Tan liquid Tan liquid	4-7 min 11-15 min 20-30 min 50-60 min
7545	Two-component; equal mix; non-sag; for FRP, SMC and other plastics with little surface preparation	Brown paste Off-white or black paste Off-white paste Off-white paste Off-white paste Black paste	3-5 min 6-8 min 11-18 min 22-38 min 45-65 min 1.5 min
7546	Two-component; non-sag; for FRP, SMC and other plastics with little surface preparation; long working times at elevated temperatures	Dk. brown liquid White liquid	52-68 min**
7550	Two-component; equal mix; self-leveling; clear; non-yellowing	Clear liquid Clear liquid	3-5 min
7555	Two-component; non-sag; bright white; non-yellowing	Translucent paste White paste	3-5 min
7556	Two-component; equal mix; non-sag; clear; non-yellowing	Translucent paste Translucent paste Clear liquid	3-5 min 4-6 min
7602	Single-component; moisture cure	Off-white paste	10-20 min
7610EZ	Single-component; for plastic, wood, fabrics and metals; moisture cure	White paste	25-35 min
7650	Single-component; high-tack; moisture cure; low viscosity	Honey liquid	15-30 min

* Can be accelerated with heat.

** Given a 1-inch diameter bead @ 90°F (32°C).

Handling Time*	Cure Time*	Mix Ratio by Vol.	Component	Typical Viscosity (cP)	Density Range	
					(lb/gal)	(kg/m³)
2-3 hr	24 hr	1:2	7100-A Resin	3,000-16,000	12.4-12.7	(1486-1522)
			7100-B Curative	45,000-72,000	10.9-11.4	(1306-1366)
2-3 hr	24 hr	1:2	7150-A Resin	3,000-16,000	12.4-12.7	(1486-1522)
			7150-B Curative	41,500-65,500	10.9-11.4	(1306-1366)
1-2 hr 2 hr 3 hr 4 hr	24 hr	1:1	7542-A Resin	1,500-4,500	11.45-11.75	(1372-1408)
			7542-B Curative	7,000-14,000	10.3-10.6	(1234-1270)
			7542-C Curative	7,000-14,000	10.3-10.6	(1234-1270)
			7542-D Curative	5,000-14,000	10.3-10.6	(1234-1270)
			7542-E Curative	5,000-18,000	10.3-10.6	(1234-1270)
30 min 60 min 1-1.5 hr 2-3 hr 4-5 hr 10 min	24 hr	1:1	7545-A Resin	25,000-70,000	12.5-12.8	(1498-1534)
			7545-B Curative	230,000-650,000	10.8-11.2	(1294-1342)
			7545-C Curative	230,000-650,000	10.8-11.2	(1270-1318)
			7545-D Curative	230,000-650,000	10.6-11.0	(1270-1318)
			7545-E Curative	230,000-650,000	10.6-11.0	(1270-1318)
5-8 hr**	24-48 hr	1:1	7545-F Curative	230,000-650,000	10.5-11.1	(1258-1330)
			7545-G Curative	230,000-650,000	10.8-11.2	(1294-1342)
1 hr	24-72 hr	1:1	7546-A Resin	1,500-4,500	11.45-11.75	(1320-1408)
			7546-C Curative	3,000-12,000	10.0-11.0	(1198-1318)
1 hr	24 hr	1:1	7550-A Resin	1,800-4,000	9.6-9.8	(1150-1174)
			7550-C Curative	6,000-12,500	9.0-9.4	(1078-1126)
1 hr	24 hr	1:1	7555-A Resin	45,000-160,000	9.64-10.04	(1155-1203)
			7555-C Curative	130,000-230,000	9.9-10.2	(1186-1222)
1 hr	24 hr	1:1	7556-A Resin	45,000-160,000	9.64-10.04	(1155-1203)
			7556-B Curative	95,000-300,000	9.2-9.6	(1102-1150)
1.5-2.3 hr			7556-C Curative	80,000-300,000	9.2-9.6	(1102-1150)
24 hr	24-72 hr	N/A	7602	50,000-250,000	8.0-9.0	(959-1078)
6-12 hr	1-5 days	N/A	7610EZ	N/A	10.0	(1198)
24 hr	24-72 hr	N/A	7650	400-2,000	7.8-8.4	(935-1007)



To meet the unique bonding demands that accompany use of difficult-to-bond materials, we offer a full line of adhesion enhancers/surface modifiers. These products are also referred to as primers. LORD® Adhesion Enhancers/Surface Modifiers improve adhesion on virtually any hard-to-bond surface — whether you're joining metals, plastics, ceramics or elastomers. These charts will help you decide which LORD Adhesion Enhancer/Surface Modifier is right for your application.

LORD Adhesion Enhancer/Surface Modifier Selection Guide

Product	Description	Appearance	Solvents	Solids Content By Wt. (%)	Typical Viscosity (cP)	Density Range	
						(lb/gal)	(kg/m³)
AP-134	Single-component; low viscosity; reactive polymer primer; recommended for e-coated metals, glass, ceramic tile, concrete and some plastics	Clear yellow to amber liquid	Toluene, n-Butanol, Ethanol	4.8-6.2	0-8	7.2-7.5	(863-899)
459X	Single-component primer in xylene solvent; diluted for direct application; recommended for elastomers such as natural rubber, thermoplastic elastomers (TPEs), polyolefins (TPOs) and EPDM	Amber liquid	Xylene	2.7-4.1	~10	7.15-7.35	(857-881)
459T	Single-component primer in toluene solvent: for direct application; recommended for elastomers such as natural rubber, thermoplastic elastomers (TPEs), polyolefins (TPOs) and EPDM	Straw yellow liquid	Toluene	4.0-5.25	1-15	7.2-7.35	(863-881)
7701	Single-component; solvent-based surface treatment for various vulcanized, thermoplastic polymeric materials; recommended for elastomers such as natural rubber, thermoplastic elastomers (TPEs), polyolefins (TPOs) and EPDM	Clear to cloudy liquid	Ethyl Acetate	2.0-3.6	10	7.6	(911)
7713	Single-component; room temperature curing primer; for adhesive bonding of glass reinforced polyester substrates	Purple liquid	Trichloroethylene, Methylene Chloride	11.9-14.45	20	11.25-11.55	(1348-1384)

LORD® Acrylic Adhesives Convenience Packaging Guide

LORD part numbers listed in parenthesis.

	LORD-Pak™ System	Ratio	Manual Dispensing Gun		Pneumatic Dispensing Gun	Mixing Tip	
			Dispensing Gun	Plunger		Pkg of 12	Pkg of 144
LORD 201 Acrylic Adhesive							
LORD 201/Accelerator 19 Acrylic Adhesive (3003498)	LORD-Pak 50	2:1	LORD-Pak 50 (3001112)	—	—	0.25x6x21" (3004476)	0.25x6x21" (3009534)
LORD 201/Accelerator 17 Acrylic Adhesive (3003496)	LORD-Pack CX	10:1	LORD-Pak CX (3004483)	—	LORD-Pak CX (3001128)	0.375x9.5x24" (3001179)	0.25x7.5x24" (3004481)
LORD 201/Accelerator 19 Acrylic Adhesive (3003497)	LORD-Pak 225 mL Cartridges	2:1	—	—	LORD-Pak 225 mL Cartridge (3001149)	0.375x9x24" (3004657)	—
LORD 202 Acrylic Adhesive							
LORD 202/Accelerator 18 Acrylic Adhesive (3003501)	LORD-Pak 50	2:1	LORD-Pak 50 (3001112)	—	—	0.25x6x21" (3004476)	0.25x6x21" (3009534)
LORD 204 Acrylic Adhesive							
LORD 204/Accelerator 19 Acrylic Adhesive (3003511)	LORD-Pak 200	2:1	LORD-Pak 200 (3004273)	—	LORD-Pak 200 (3004274)	0.375x11x24" (3001178)	—
LORD 204/Accelerator 19 Acrylic Adhesive (3003512)	LORD-Pak 50	2:1	LORD-Pak 50 (3001112)	—	—	0.25x6x21" (3004476)	0.25x6x21" (3009534)
LORD 204/Accelerator 17 Acrylic Adhesive (3008597)	LORD-Pak 200	10:1	LORD-Pak 200 (3004275)	—	—	—	—
LORD 204/Accelerator 19 Acrylic Adhesive (3003513)	LORD-Pak 450 mL Cartridges	2:1	—	—	LORD-Pak 600 mL Cartridge (3004856)	0.375x9x24" (3004657)	—
LORD 206 Acrylic Adhesive							
LORD 206/Accelerator 19 Acrylic Adhesive (3003520)	LORD-Pak 50	2:1	LORD-Pak 50 (3001112)	—	—	0.25x6x21" (3004476)	0.25x6x21" (3009534)
LORD 206/Accelerator 19 Acrylic Adhesive (3003519)	LORD-Pak 450 mL Cartridges	2:1	—	—	LORD-Pak 600 mL Cartridge (3004856)	0.375x9x24" (3004657)	—
LORD 403 Acrylic Adhesive							
LORD 403/Accelerator 19 Acrylic Adhesive (3003665)	LORD-Pak 50	4:1	LORD-Pak 50 (3001112)	LORD-Pak 50 4:1 Plunger (3004479)	—	0.25x6x21" (3004476)	0.25x6x21" (3009534)
LORD 403/Accelerator 17 Acrylic Adhesive (3003664)	LORD-Pack CX	10:1	LORD-Pak CX (3004483)	—	LORD-Pak CX (3001128)	0.375x9.5x24" (3001179)	0.25x7.5x24" (3004481)
LORD 403/Accelerator 19 Acrylic Adhesive (3003666)	LORD-Pack CX	4:1	LORD-Pak CX (3004487)	—	LORD-Pak CX (3001128)	0.375x9.5x24" (3001179)	0.25x7.5x24" (3004481)
LORD 403/Accelerator 19 Black Acrylic Adhesive (3003667)	LORD-Pak 375 mL Cartridges	4:1	LORD-Pak 375 mL Cartridge (3004857)	—	LORD-Pak 375 mL Cartridge (3004856)	0.375x9x24" (3004657)	—
LORD 403/Accelerator 19GB Black Acrylic Adhesive (3003668)	LORD-Pak 375 mL Cartridges	4:1	LORD-Pak 375 mL Cartridge (3004857)	—	LORD-Pak 375 mL Cartridge (3004856)	0.375x9x24" (3004657)	—

LORD® Acrylic Adhesives Convenience Packaging Guide (cont'd)

LORD part numbers listed in parenthesis.

LORD part numbers listed in parenthesis.

	LORD-Pak™ System	Ratio	Manual Dispensing Gun		Pneumatic Dispensing Gun	Mixing Tip		
			Dispensing Gun	Plunger		Pkg of 12	Pkg of 144	
LORD 403 Acrylic Adhesive (cont'd)								
LORD 403/Accelerator 19GB Red Acrylic Adhesive (3012638)	LORD-Pak 375 mL Cartridges	4:1	LORD-Pak 375 mL Cartridge (3004857)	—	LORD-Pak 375 mL Cartridge (3004856)	0.375x9x24" (3004657)	—	
LORD 403/Accelerator 19GB Gray Acrylic Adhesive (3016076)	LORD-Pak 375 mL Cartridges	4:1	LORD-Pak 375 mL Cartridge (3004857)	—	LORD-Pak 375 mL Cartridge (3004856)	0.375x9x24" (3004657)	—	
LORD 406 Acrylic Adhesive								
LORD 406/Accelerator 17 Acrylic Adhesive (3003674)	LORD-Pak CX	10:1	LORD-Pak CX (3004483)	—	LORD-Pak CX (3001128)	0.375x9.5x24" (3001179)	0.25x7.5x24" (3004481)	
LORD 406/Accelerator 19 Acrylic Adhesive (3003676)	LORD-Pak CX	4:1	LORD-Pak CX (3004487)	—	LORD-Pak CX (3001128)	0.375x9.5x24" (3001179)	0.25x7.5x24" (3004481)	
LORD 406/Accelerator 17 Acrylic Adhesive (3003675)	LORD-Pak 200	10:1	LORD-Pak 200 (3004275)	—	—	0.375x10.87x24" (3004467)	—	
LORD 406/Accelerator 19 Acrylic Adhesive (3003680)	LORD-Pak 50	4:1	LORD-Pak 50 (3001112)	LORD-Pak 50 4:1 Plunger (3004479)	—	0.25x6x21" (3004476)	0.25x6x21" (3009534)	
LORD 406/Accelerator 19GB Acrylic Adhesive (3003682)	LORD-Pak 375 mL Cartridges	4:1	LORD-Pak 375 mL Cartridge (3004857)	—	LORD-Pak 375 mL Cartridge (3004856)	0.375x9x24" (3004657)	—	
LORD 406/Accelerator 19 Black Acrylic Adhesive (3003678)	LORD-Pak 375 mL Cartridges	4:1	LORD-Pak 375 mL Cartridge (3004857)	—	LORD-Pak 375 mL Cartridge (3004856)	0.375x9x24" (3004657)	—	
LORD 406/Accelerator 19GB Acrylic Adhesive (3003681)	LORD-Pak 50	4:1	LORD-Pak 50 (3001112)	LORD-Pak 50 4:1 Plunger (3004479)	—	0.25x6x21" (3004476)	0.25x6x21" (3009534)	
LORD 406/Accelerator 19GB Red Acrylic Adhesive (3012326)	LORD-Pak 375 mL Cartridges	4:1	LORD-Pak 375 mL Cartridge (3004857)	—	LORD-Pak 375 mL Cartridge (3004856)	0.375x9x24" (3004657)	—	
LORD 406/Accelerator 19GB Gray Acrylic Adhesive (3017514)	LORD-Pak 50	4:1	LORD-Pak 50 (3001112)	LORD-Pak 50 4:1 Plunger (3004479)	—	0.25x6x21" (3004476)	0.25x6x21" (3009534)	
LORD 406/Accelerator 19GB Gray Acrylic Adhesive (3016078)	LORD-Pak 375 mL Cartridges	4:1	LORD-Pak 375 mL Cartridge (3004857)	—	LORD-Pak 375 mL Cartridge (3004856)	0.375x9x24" (3004657)	—	
LORD 406/Accelerator 19GB Red Acrylic Adhesive (3012325)	LORD-Pak 50	4:1	LORD-Pak 50 (3001112)	LORD-Pak 50 4:1 Plunger (3004479)	—	0.25x6x21" (3004476)	0.25x6x21" (3009534)	
LORD 406/Accelerator 19GB Gray Acrylic Adhesive (3018326)	LORD-Pak 400	4:1	LORD-Pak 400 mL Cartridge (3004276)	—	LORD-Pak 400 mL Cartridge (3004279)	0.375x11x24" (3001178)	—	

LORD® Acrylic Adhesives Convenience Packaging Guide (cont'd)

LORD part numbers listed in parenthesis.

			Manual Dispensing Gun			Mixing Tip	
	LORD-Pak™ System	Ratio	Dispensing Gun	Plunger	Pneumatic Dispensing Gun	Pkg of 12	Pkg of 144
LORD 410 Acrylic Adhesive							
LORD 410/Accelerator 17 Acrylic Adhesive (3003690)	LORD-Pak CX	10:1	LORD-Pak CX (3004483)	—	LORD-Pak CX (3001128)	0.375x9.5x24" (3001179)	0.25x7.5x24" (3004481)
LORD 410/Accelerator 19 Acrylic Adhesive (3003692)	LORD-Pak CX	4:1	LORD-Pak CX (3004487)	—	LORD-Pak CX (3001128)	0.375x9.5x24" (3001179)	0.25x7.5x24" (3004481)
LORD 410/Accelerator 19GB Acrylic Adhesive (3003693)	LORD-Pak 375 mL Cartridges	4:1	LORD-Pak 375 mL Cartridge (3004857)	—	LORD-Pak 375 mL Cartridge (3004856)	0.375x9x24" (3004657)	—
LORD 410/Accelerator 19GB Gray Acrylic Adhesive (3016077)	LORD-Pak 375 mL Cartridges	4:1	LORD-Pak 375 mL Cartridge (3004857)	—	LORD-Pak 375 mL Cartridge (3004856)	0.375x9x24" (3004657)	—
LORD 410/Accelerator 19GB Red Acrylic Adhesive (3011119)	LORD-Pak 375 mL Cartridges	4:1	LORD-Pak 375 mL Cartridge (3004857)	—	LORD-Pak 375 mL Cartridge (3004856)	0.375x9x24" (3004657)	—
LORD 506 Acrylic Adhesive							
LORD 506/Accelerator 17 Acrylic Adhesive (3003762)	LORD-Pak CX	10:1	LORD-Pak CX (3004483)	—	LORD-Pak CX (3001128)	0.375x9.5x24" (3001179)	0.25x7.5x24" (3004481)
LORD 506/Accelerator 19 Acrylic Adhesive (3003765)	LORD-Pak 50	2:1	LORD-Pak 50 (3001112))	—	—	0.25x6x21" (3004476)	0.25x6x21" (3009534)
LORD 606 Acrylic Adhesive							
LORD 606/Accelerator 6GB Acrylic Adhesive (3008768)	LORD-Pak 400	10:1	LORD-Pak 400 mL Cartridge (3004276)	—	LORD-Pak 400 mL Cartridge (3004279)	0.375x10x24" (3012582)	—
LORD 661 Acrylic Adhesive							
LORD 661/Accelerator 6GB Acrylic Adhesive (3015363)	LORD-Pak 400	10:1	LORD-Pak 400 mL Cartridge (3004276)	—	LORD-Pak 400 mL Cartridge (3004279)	0.375x10x24" (3012582)	—
LORD 661/Accelerator 6GB Acrylic Adhesive (3003802)	LORD-Pak 50	10:1	LORD-Pak 50 (3001112)	LORD-Pak 50 10:1 Plunger (3004477)	—	0.25x6x21" (3004476)	0.25x6x21" (3009534)
LORD 662 Acrylic Adhesive							
LORD 662/Accelerator 6 Acrylic Adhesive (3003806)	LORD-Pak 50	10:1	LORD-Pak 50 (3001112)	LORD-Pak 50 10:1 Plunger (3004477)	—	0.25x6x21" (3004476)	0.25x6x21" (3009534)
LORD 662/Accelerator 6 Acrylic Adhesive (3005465)	LORD-Pak 400	10:1	LORD-Pak 400 mL Cartridge (3004276)	—	LORD-Pak 400 mL Cartridge (3004279)	0.375x10x24" (3012582)	—
LORD 663 Acrylic Adhesive							
LORD 663/Accelerator 6 Acrylic Adhesive (3005466)	LORD-Pak 400	10:1	LORD-Pak 400 mL Cartridge (3004276)	—	LORD-Pak 400 mL Cartridge (3004279)	0.375x10x24" (3012582)	—

LORD® Epoxy Adhesives Convenience Packaging Guide

LORD part numbers listed in parenthesis.

	LORD-Pak™ System	Ratio	Manual Dispensing Gun		Pneumatic Dispensing Gun	Mixing Tip		
			Dispensing Gun	Plunger		Pkg of 12	Pkg of 144	
LORD 305-1/305-2 Epoxy Adhesive								
LORD 305-1/305-2 Epoxy Adhesive (3003559)	LORD-Pak 50	1:1	LORD-Pak 50 (3001112)	—	—	0.25x6x21" (3004476)	0.25x6x21" (3009534)	
LORD 305-1/305-2 Epoxy Adhesive (3003558)	LORD-Pak 200	1:1	LORD-Pak 200 (3004273)	—	LORD-Pak 200 (3004274)	0.375x11x24" (3001178)	—	
LORD 310-A/310-B Epoxy Adhesive								
LORD 310-A/310-B Epoxy Adhesive (3003578)	LORD-Pak 50	1:1	LORD-Pak 50 (3001112)	—	—	0.25x6x21" (3004476)	0.25x6x21" (3009534)	
LORD 310-A/310-B Epoxy Adhesive (3003580)	LORD-Pak CX	1:1	LORD-Pak CX (3004482)	—	LORD-Pak CX (3001128)	0.375x9.5x24" (3001179)	0.25x7.5x24" (3004481)	
LORD 310-A/310-B Epoxy Adhesive (3003581)	LORD-Pak 600	1:1	—	—	LORD-Pak 600 (3004856)	—	0.5x9x18" (3001223)	
LORD 320/310-B Black Epoxy Adhesive								
LORD 320/310-B Black Epoxy Adhesive (3003630)	LORD-Pak 50	1:1	LORD-Pak 50 (3001112)	—	—	0.25x6x21" (3004476)	0.25x6x21" (3009534)	
LORD 320/310-B Black Epoxy Adhesive (3016092)	LORD-Pak 200	1:1	LORD-Pak 200 (3004273)	—	LORD-Pak 200 (3004274)	0.375x11x24" (3001178)	—	
LORD 320/322 Epoxy Adhesive								
LORD 320/322 Epoxy Adhesive (3003632)	LORD-Pak 50	1:1	LORD-Pak 50 (3001112)	—	—	0.25x6x21" (3004476)	0.25x6x21" (3009534)	
LORD 320/322 Epoxy Adhesive (3003633)	LORD-Pack CX	1:1	LORD-Pak CX (3004482)	—	LORD-Pak CX (3001128)	0.375x9.5x24" (3001179)	0.25x7.5x24" (3004481)	
LORD 320/322 Epoxy Adhesive (3003631)	LORD-Pak 200	1:1	LORD-Pak 200 (3004273)	—	LORD-Pak 200 (3004274)	0.375x11x24" (3001178)	—	
LORD 360-A/360-B Epoxy Adhesive								
LORD 360-A/360-B Epoxy Adhesive (3003643)	LORD-Pak 50	1:1	LORD-Pak 50 (3001112)	—	—	0.25x6x21" (3004476)	0.25x6x21" (3009534)	
LORD 363-A/363-B Epoxy Adhesive								
LORD 363-A/363-B Epoxy Adhesive (3003647)	LORD-Pak 50	1:1	LORD-Pak 50 (3001112)	—	—	0.25x6x21" (3004476)	0.25x6x21" (3009534)	
LORD 370-A/370-B Epoxy Adhesive								
LORD 370-A/370-B Epoxy Adhesive (3003652)	LORD-Pak 50	1:2	LORD-Pak 50 (3001112)	—	—	0.25x6x21" (3004476)	0.25x6x21" (3009534)	
LORD 3170-A/3170-B Epoxy Adhesive								
LORD 3170-A/3170-B Epoxy Adhesive (3003619)	LORD-Pak 200	1:1	LORD-Pak 200 (3004273)	—	LORD-Pak 200 (3004274)	0.375x11x24" (3001178)	—	

LORD® Urethane Adhesives Convenience Packaging Guide

LORD part numbers listed in parenthesis.

	LORD-Pak™ System	Ratio	Manual Dispensing Gun		Pneumatic Dispensing Gun	Mixing Tip	
			Dispensing Gun	Plunger		Pkg of 12	Pkg of 144
LORD 7100 Urethane Adhesive							
LORD 7100-A/7100-B Adhesive (3012640)	LORD-Pak 50	2:1	LORD-Pak 50 (3001112)	—	—	0.25x6x21" (3004476)	0.25x6x21" (3009534)
LORD 7100-A/7100-B Adhesive (3013630)	LORD-Pak 200	2:1	LORD-Pak 200 (3004273)	—	LORD-Pak 200 (3004274)	0.375x11x24" (3001178)	—
LORD 7150 Urethane Adhesive							
LORD 7150-A/7150-B Urethane Adhesive (3012639)	LORD-Pak 50	2:1	LORD-Pak 50 (3001112)	—	—	0.25x6x21" (3004476)	0.25x6x21" (3009534)
LORD 7150-A/7150-B Urethane Adhesive (3013629)	LORD-Pak 200	2:1	LORD-Pak 200 (3004273)	—	LORD-Pak 200 (3004274)	0.375x11x24" (3001178)	—
LORD 7542 Urethane Adhesive							
LORD 7542-A/7542-B Urethane Adhesive (3003884)	LORD-Pak 50	1:1	LORD-Pak 50 (3001112)	—	—	0.25x6x21" (3004476)	0.25x6x21" (3009534)
LORD 7542-A/7542-B Urethane Adhesive (3003883)	LORD-Pak 200	1:1	LORD-Pak 200 (3004273)	—	LORD-Pak 200 (3004274)	0.375x11x24" (3001178)	—
LORD 7542-A/7542-C Urethane Adhesive (3003885)	LORD-Pak 200	1:1	LORD-Pak 200 (3004273)	—	LORD-Pak 200 (3004274)	0.375x11x24" (3001178)	—
LORD 7542-A/7542-D Urethane Adhesive (3003886)	LORD-Pack 200	1:1	LORD-Pak 200 (3004273)	—	LORD-Pak 200 (3004274)	0.375x11x24" (3001178)	—
LORD 7542-A/7542-E Urethane Adhesive (3003889)	LORD-Pak 200	1:1	LORD-Pak 200 (3004273)	—	LORD-Pak 200 (3004274)	0.375x11x24" (3001178)	—
LORD 7542-A/7542-B Urethane Adhesive (3003882)	LORD-Pak 600	1:1	—	—	LORD-Pak 600 mL Cartridge (3004856)	0.5x11.5x24" (3001175)	—
LORD 7542-A/7542-D Urethane Adhesive (3003887)	LORD-Pak 600	1:1	—	—	LORD-Pak 600 mL Cartridge (3004856)	0.5x11.5x24" (3001175)	—
LORD 7545 Urethane Adhesive							
LORD 7545-A/7545-B Urethane Adhesive (3003923)	LORD-Pak 50	1:1	LORD-Pak 50 (3001112)	—	—	0.25x6x21" (3004476)	0.25x6x21" (3009534)
LORD 7545-A/7545-B Urethane Adhesive (3003922)	LORD-Pak 200	1:1	LORD-Pak 200 (3004273)	—	LORD-Pak 200 (3004274)	0.375x11x24" (3001178)	—
LORD 7545-A/7545-C Urethane Adhesive (3003915)	LORD-Pak 200	1:1	LORD-Pak 200 (3004273)	—	LORD-Pak 200 (3004274)	0.375x11x24" (3001178)	—
LORD 7545-A/7545-D Urethane Adhesive (3003925)	LORD-Pak 200	1:1	LORD-Pak 200 (3004273)	—	LORD-Pak 200 (3004274)	0.375x11x24" (3001178)	—
LORD 7545-A/7545-C Urethane Adhesive (3003924)	LORD-Pak 50	1:1	LORD-Pak 50 (3001112)	—	—	0.25x6x21" (3004476)	0.25x6x21" (3009534)
LORD 7545-A/7545-E Urethane Adhesive (3003917)	LORD-Pak 200	1:1	LORD-Pak 200 (3004273)	—	LORD-Pak 200 (3004274)	0.375x11x24" (3001178)	—
LORD 7545-A/7545-E Urethane Adhesive (3003927)	LORD-Pak 50	1:1	LORD-Pak 50 (3001112)	—	—	0.25x6x21" (3004476)	0.25x6x21" (3009534)

LORD® Urethane Adhesives Convenience Packaging Guide (cont'd)

LORD part numbers listed in parenthesis.

			Manual Dispensing Gun		Pneumatic Dispensing Gun	Mixing Tip	
	LORD-Pak™ System	Ratio	Dispensing Gun	Plunger		Pkg of 12	Pkg of 144
LORD 7545 Urethane Adhesive (cont'd)							
LORD 7545-A/7545-F Urethane Adhesive (3003930)	LORD-Pak 600	1:1	LORD-Pak 600 mL Cartridge (3004857)	—	LORD-Pak 600 mL Cartridge (3001149)	0.5x11.5x24" (3001175)	—
LORD 7545-A/7545-G Urethane Adhesive (3008743)	LORD-Pak 50	1:1	LORD-Pak 50 (3001112)	—	—	0.25x6x21" (3004476)	0.25x6x21" (3009534)
LORD 7545-A/7545-F Urethane Adhesive (3003929)	LORD-Pak 50	1:1	LORD-Pak 50 (3001112)	—	—	0.25x6x21" (3004476)	0.25x6x21" (3009534)
LORD 7545-A/7545-C Urethane Adhesive (3003916)	LORD-Pak 600	1:1	—	—	LORD-Pak 600 mL Cartridge (3004856)	0.5x11.5x24" (3001175)	—
LORD 7545-A/7545-F Urethane Adhesive (3003930)	LORD-Pak 600	1:1	—	—	LORD-Pak 600 mL Cartridge (3004856)	0.5x11.5x24" (3001175)	—
LORD 7545-A/7545-D Urethane Adhesive (3009257)	LORD-Pak 600	1:1	—	—	LORD-Pak 600 mL Cartridge (3004856)	0.5x11.5x24" (3001175)	—
LORD 7546 Urethane Adhesive							
LORD 7546-A/7546-C Urethane Adhesive (3003945)	LORD-Pak 600	1:1	—	—	LORD-Pak 600 (3004856)	0.5x11.5x24" (3001175)	—
LORD 7550 Urethane Adhesive							
LORD 7550-A/7550-C Urethane Adhesive (3003953)	LORD-Pak 50	1:1	LORD-Pak 50 (3001112)	—	—	0.25x6x21" (3004476)	0.25x6x21" (3009534)
LORD 7555 Urethane Adhesive							
LORD 7555-A/7555-C Urethane Adhesive (3003960)	LORD-Pak 50	1:1	LORD-Pak 50 (3001112)	—	—	0.25x6x21" (3004476)	0.25x6x21" (3009534)
LORD 7555-A/7555-B Urethane Adhesive (3003963)	LORD-Pak 400	1:1	LORD-Pak 400 mL Cartridge (3004277)	—	LORD-Pak 400 mL Cartridge (3004278)	0.375x11x24" (3001178)	—
LORD 7555-A/7555-C Urethane Adhesive (3003961)	LORD-Pak 400	1:1	LORD-Pak 400 mL Cartridge (3004277)	—	LORD-Pak 400 mL Cartridge (3004278)	0.375x11x24" (3001178)	—
LORD 7556 Urethane Adhesive							
LORD 7556-A/7556-B Urethane Adhesive (3003962)	LORD-Pak 50	1:1	LORD-Pak 50 (3001112)	—	—	0.25x6x21" (3004476)	0.25x6x21" (3009534)

We provide adhesives in convenient two-component cartridges for easy and accurate dispensing. Several configurations are available to suit every need.

LORD-Pak™ 50

A handheld, manual dispensing system for small jobs.

Volume of mixed adhesive per cartridge varies with the mix ratio:

1:1	50 mL
2:1	50 mL
4:1	40 mL
10:1	35 mL



LORD-Pak 200/400 and 485 mL Cartridges

A larger dispensing system with both manual guns and pneumatic guns for field repairs or production applications. Volume of mixed adhesive per cartridge is approximately 200 mL or 400 mL, but varies with the mix ratio.



LORD-Pak CX

Pneumatic and manual dispensing systems utilizing a coaxial cartridge containing the two adhesive parts.

Volume of mixed adhesive per cartridge is approximately 400 mL, but varies with the mix ratio.



375 mL Cartridges

These are economical, side-by-side, snap-together cartridge systems containing higher volumes of adhesive.

Bead Diameter Estimator – inches (cm)

Required Bead Diameter: Use the table below to determine the required bead diameter from the dimensions of the adhesive joint.

		Beadline Width - in (cm)					
Beadline Thickness in (mm)		0.25 (0.60)	0.50 (1.80)	1.00 (2.50)	2.00 (5.10)	4.00 (10.20)	8.00 (20.30)
	0.01 (0.25)	0.06 (0.14)	0.08 (0.20)	0.11 (0.29)	0.16 (0.41)	0.23 (0.57)	0.32 (0.81)
	0.02 (0.50)	0.08 (0.20)	0.11 (0.29)	0.16 (0.41)	0.23 (0.57)	0.32 (0.81)	0.45 (1.15)
	0.04 (1.00)	0.11 (0.29)	0.16 (0.41)	0.23 (0.57)	0.32 (0.81)	0.45 (1.15)	0.64 (1.62)
	0.08 (2.00)	0.16 (0.41)	0.23 (0.57)	0.32 (0.81)	0.45 (1.15)	0.64 (1.62)	0.90 (2.29)

Bead Length Estimator – feet (m)

Linear Coverage: Use the table below to determine the length of adhesive bead that can be obtained from a cartridge of adhesives.

		Bead Diameter - in (cm)					
Cartridge Volume mL		0.125 (0.30)	0.188 (0.48)	0.250 (0.60)	0.313 (0.80)	0.375 (0.95)	0.500 (1.30)
	40	17 (5.00)	7.4 (2.20)	4.1 (1.30)	2.7 (0.80)	1.8 (0.60)	1.0 (0.30)
	50	21 (6.30)	9.2 (2.80)	5.2 (1.60)	3.3 (1.00)	2.3 (0.70)	1.3 (0.40)
	200	83 (25.20)	37 (11.20)	21 (6.30)	13 (4.00)	9 (2.80)	5.2 (1.60)
	375	155 (47.20)	69 (21.00)	39 (11.80)	25 (7.60)	17 (5.20)	10 (3.10)
	400	166 (50.40)	74 (22.40)	41 (12.60)	27 (8.10)	18 (5.60)	10 (3.10)
	485	201 (61.10)	89 (27.20)	50 (15.30)	32 (9.80)	22 (6.80)	13 (3.80)
	600	249 (75.60)	111 (33.60)	62 (18.70)	40 (12.10)	28 (8.40)	16 (4.70)

Surface Preparation

Remove soils, greases, oils, dust, mold release agents, rust and other contaminants from substrate surface with the use of a vapor-free solvent, such as MEK, acetone or IPA.

Plastics: Clean the surface with a dry rag or a dampened solvent rag.

Metals: Prime, paint or grit blast, followed by a solvent wash for optimum bond performance.

Cautionary Information

Before using 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.

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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 ... Ask Us How.

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