

LORD® 7550 Urethane Adhesive

Description

LORD® 7550 adhesive is an equal-mix, two-component clear urethane adhesive system used to bond Lexan®, ABS, polycarbonate and other plastics. This adhesive will also bond primed metals.

Features and Benefits

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

Environmentally Friendly – does not contain ozone depleting chemicals.

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.

Self-Leveling – flows into hard-to-reach spaces; excellent for bonding parts with tight tolerances.

Application

Surface Preparation – Surfaces should be free of grease, dirt and other contaminants. For plastics, clean the surface with a dry rag wipe or a rag dampened with solvent. For metals, grit blast and solvent wash the surface, then prime for optimum bond performance.

Mixing – Mix resin with the curative at a 1:1 ratio, by volume. Handheld cartridges will automatically dispense the correct volumetric ratio of each component.

Applying – Apply adhesive using handheld cartridges. Assemble parts within working time of the adhesive.

Curing – LORD 7550 adhesive will cure to full strength in approximately 72 hours at room temperature.

Cleanup – Clean equipment and tools prior to the adhesive cure with organic solvents such as isopropyl 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.

Lexan is a trademark of SABIC Innovative Plastics.

Typical Properties*

| | 7550-A Resin | 7550-C Curative |
|-----------------------------------|--------------|-----------------|
| Appearance | Clear Liquid | Clear Liquid |
| Viscosity, cP @ 77°F (25°C) | 1800-4000 | 6000-12,500 |
| Density | | |
| lb/gal | 9.6-9.8 | 9.0-9.4 |
| (kg/m ³) | (1150-1174) | (1078-1126) |
| Flash Point (Closed Cup), °F (°C) | >200 (>93) | >200 (>93) |

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

LORD TECHNICAL DATA

Shelf Life/Storage

Shelf life is six months when stored in a clean, dry environment at 70-80°F (21-27°C) in original, unopened container.

After opening, protect adhesive from excessive exposure to moisture by installing desiccant cartridges and/or using dry nitrogen as an inert cover.

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.

Typical Properties* of Resin Mixed with Curative

| | |
|--|-----|
| Mix Ratio by Volume, Resin to Curative | 1:1 |
| Solids Content by Weight, % | 100 |
| Working Time, min @ 75°F (24°C) | 3-5 |
| Purge Time, min @ 75°F (24°C) | 2-3 |
| Time to Handling Strength, min @ 77°F (25°C) | 60 |

*Data is typical and not to be used for specification purposes. Given a 1/2" (12.5 mm) diameter bead.

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.

LORD and "Ask Us How" are trademarks of LORD Corporation or one of its subsidiaries.

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.

LORD Corporation World Headquarters

111 Lord Drive
Cary, NC 27511-7923
USA

Customer Support Center (in United States & Canada)

+1 877 ASK LORD (275 5673)

www.lord.com

For a listing of our worldwide locations, visit LORD.com.