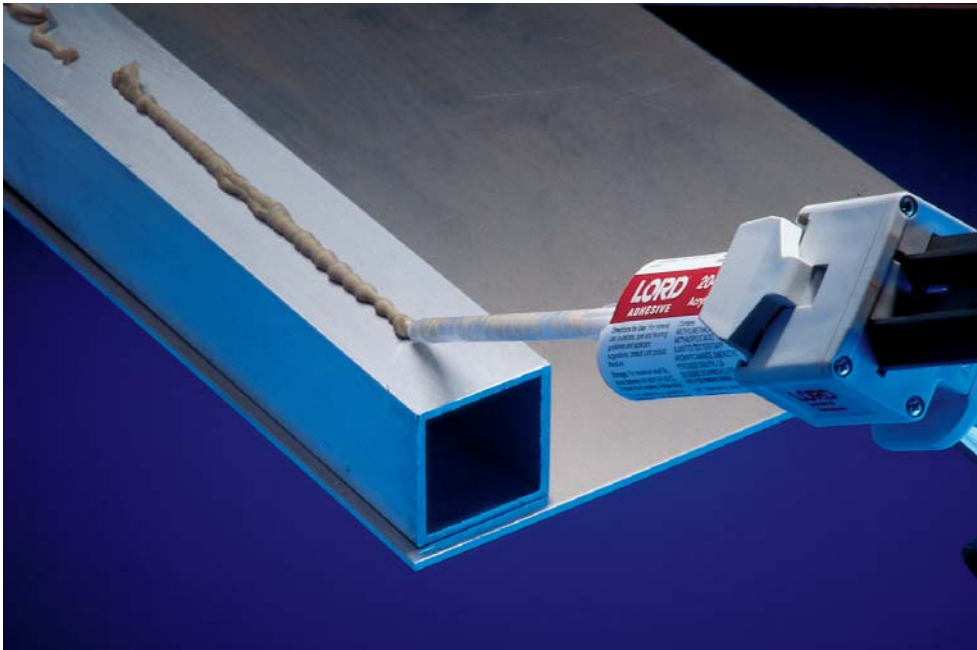


LORD ADHESIVES

LORD® ACRYLIC ADHESIVES



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.

Lord 500 Series Acrylic Adhesives bond plastics and prepared metals; they offer excellent adhesion to both thermoplastics and thermoset plastics. They are available with varying handling characteristics and cure times.

Lord 660 Acrylic Adhesive bonds FRP (fiber-reinforced plastics) with minimal surface preparation. Lord 660 can cross-bond FRP to many metals. This adhesive is specifically formulated to produce the highest impact and peel strengths available in a room temperature curing adhesive.

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 not limited to metal applications; they also bond plastics and ceramics, thermoplastics like polypropylene and ABS, and thermosets like fiberglass, sheet molded compounds (SMC) and fiber reinforced plastics (FRP).

Lord Acrylic Adhesives:

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

Lord 200 Series Acrylic Adhesives bond minimally prepared or unprepared surfaces. They offer excellent adhesion to unprepared metals, ceramic magnets and plastics. Viscosities range from paste to liquid. Cure times range from 2 to 35 minutes.

There are also a number of no-mix and mix-in Lord Accelerators:

Lord Accelerator 4 A no-mix accelerator for Lord 200 and 500 Series Acrylic Adhesives. Brush, wipe, spray or dip on one or both surfaces to be bonded. For use with bond thicknesses of 40 mils or less.

Lord Accelerator 5 Mix-in accelerator for Lord 200, 400 and 500 Series Acrylic Adhesives. Use at 20:1 ratio.

Lord Accelerator 17 Mix-in accelerator for Lord 200, 400 and 500 Series Acrylic Adhesives. Use at 10:1 ratio.

Lord Accelerator 18 Black mix-in accelerator for use with all Lord Acrylic Adhesives. May be used at ratios from 2:1 thru 10:1.

Lord Accelerator 19 Mix-in accelerator. Use at 2:1 or 4:1 ratio for Lord 200, 400 and 500 Series Acrylic Adhesives. Well-suited for meter/mix/dispense equipment.

Lord Accelerator 19 Black is a black pigmented version of Lord Accelerator 19.

Lord Accelerator 22 is a red mix-in accelerator for use with all Lord Acrylic Adhesives. Use at 2:1 and 4:1 ratios for Lord 200, 400 and 500 Series Acrylic Adhesives. Well-suited for meter/mix/dispense equipment.

LORD® ACRYLIC ADHESIVES

LORD ADHESIVES

LORD® ACRYLIC ADHESIVE SELECTION GUIDE

Adhesive	Description	Appearance	Working Time (min.)	Handling Time (min.)	Full Strength (hrs.)	Typical Viscosity (cps)	Density lbs/gal	Flash Point °F (°C)	Sizes
201	Semi-flexible. Medium cure. Medium viscosity.	Off-white	5-8	12-16	2	15,000-55,000	8.5-8.7	66 (18)	3oz, 1/10 Gal 1/2 Pt, Pail Drum
202	Semi-flexible. Fast cure. Medium viscosity.	Off-white	1-2	2-4	1	10,000-26,000	9.8-10.2	56 (13)	3oz, 1/10 Gal 1/2 Pt, Pail Drum
204	Semi-flexible. Medium cure. High viscosity.	Off-white	6-8	12-16	2	100,000-300,000	8.5-8.7	66 (18)	3oz, 1/10 Gal 1/2 Pt, Pail Drums
206	Long working time.	Off-white	20-22	45-60	2	20,000-80,000	8.6-9.0	75 (24)	1/2 Pt, Pail Drums
403	Flexible. High impact and peel resistance. Fast cure.	Off-white	2-4	4-6	2	100,000-350,000	9.1-9.6	60 (16)	1/2 Pt, Pail Drum
406	Flexible. High impact and peel resistance. Medium working time.	Off-white	6-10	12-17	2	100,000-300,000	9.1-9.6	59 (15)	1/2 Pt, Pail Drum
410	Flexible. High impact and peel resistance. Long working time.	Off-white	20-45	60-120	10	100,000-350,000	9.1-9.6	60 (16)	1/2 Pt, Pail Drum
506	Semi-flexible. Medium cure. Medium viscosity.	Translucent paste	4-6	8-12	24	40,000-60,000	8.3-8.8	53 (12)	3oz, 1/10 Gal 1/2 Pt, Pail Drum
510	Fast cure.	Off-white paste	3-4	5-9	24	70,000-200,000	8.3-8.8	55 (13)	1/2 Pt, Pail Drum
513	Fast cure. Non-sagging.	Grey paste	3-4	7-8	24	150,000-300,000	8.3-8.5	48 (9)	1/2 Pt, Pail
521	Medium viscosity. Slow cure.	Amber syrup	20-30	40-50	24	25,000-75,000	8.1-8.6	37 (3)	1/2 Pt, Pail Drum
551	Very low viscosity. For thinning other adhesives. Medium cure.	Clear to hazy amber liquid	2-4	7-11	24	15-35	8.0-8.4 (13)	55	1/2 Pt, Pail Drum
648	Low odor/low flammability, non-sag, acrylic adhesive for metal.	Off-white	8-12	12-17	2	180,000-300,000	9.3	115 (46)	5 Gal Pail
660	White, non-sag, fast-set acrylic adhesive for FRP.	White paste	20-40	60-120	24	660-A 100,000-300,000 660-B 10,000-80,000	8.1-8.5 12.0-12.5	59 (15) >200 (93)	1/2 Pt, Pail Drum

LORD® ACRYLIC ADHESIVE ACCELERATORS

Accelerator	Description	Appearance	Typical Viscosity (cps)	Density lbs/gal	Flash Point °F (°C)	Sizes
4	No-mix accelerator for 200 Series and 500 Series.	Slightly hazy to clear amber color	< 10	10.2-10.7	>200 (93)	1oz Bottle, 8oz Spray Qt, Gal, Drum
5	Mix-in accelerator for 200, 400 or 500 Series (20:1 mix ratio by weight).	Off-white to yellow liquid	1,500-7,000	9.3-9.9	>200 (93)	1/2Pt, Qt, Gal Pail, Drum
17	Mix-in accelerator for 200, 400, 500 Series (10:1 ratio by weight or volume).	Off-white to yellow liquid	1,000-10,000	9.7-10.1	>200 (93)	3oz, 1/2 Pt Qt, Gal, Pail
18	Mix-in accelerator for use with all Lord acrylic adhesives (from 10:1 to 2:1 ratio by volume).	Black paste	10,000-15,000	8.5-9.5	>200 (93)	1/2Pt, Gal, Pail
19	Mix-in accelerator for 200, 400 and 500 Series (2:1 ratio or 4:1 ratio by volume).	Off-white paste	150,000-450,000	11.6-12.6	>200 (93)	3oz, 1/2 Pt, Qt, Gal, Pail, Drum
19 Black	Mix-in black accelerator for 200, 400 and 500 Series (2:1 ratio or 4:1 ratio by volume).	Black paste	150,000-450,000	11.6-12.6	>200 (93)	1/2Pt, Pail, Drum
22	Mix-in red accelerator for 200, 400 and 500 Series (2:1 ratio or 4:1 ratio by volume).	Red paste	150,000-450,000	11.6-12.6	>200 (93)	Pail
26	No-mix accelerator for 200 and 500 Series. Contains no chlorinated solvents	Clear amber to white liquid	<10	7.5-8.5	>109 (43)	1/2 Pt, Qt, Drum

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

LORD ADHESIVES

LORD® EPOXY ADHESIVES



Lord® Epoxy Adhesives create superior bonds for rubber, SMC, plastics and metals. Our epoxy adhesives are widely used in the automotive industry—over 10 million cars and light- and heavy-duty trucks feature body panels bonded with Lord Epoxy Adhesives.

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, alkalies, 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.

LORD® EPOXY ADHESIVE SELECTION GUIDE

Product	Description	Mixed Appearance	Working Time*	Handling Time**	Sizes
304	General purpose, high viscosity epoxy adhesive.	Gray paste	1-2 hrs.	8 hrs.	1/2Pt, Qt, Gal, Pail
305	General purpose, medium viscosity epoxy adhesive.	Blue syrup	1-2 hrs.	8 hrs.	1/2Pt, Qt, Gal, Pail, Drum
306	High viscosity, epoxy adhesive formulated for MIL-A-24456 (ships).	Gray paste	1-2 hrs.	8 hrs.	1/2Pt, Gal,
307	General purpose, medium viscosity hardener for use with Lord 305-1.	Clear syrup	1-2 hrs.	8 hrs.	1/2Pt, Gal, Pail
309	General purpose, non-sag, thixotropic, epoxy adhesive.	Blue paste	1.5-2 hrs.	8 hrs.	1/2Pt, Gal, Pail, Drum
310	High-strength epoxy adhesive for SMC, FRP and general purpose bonding.	Gray paste	30-60 min.	8 hrs.	1/2Pt, Qt, Gal, Pail
312	General purpose, low viscosity epoxy adhesive.	Yellow to amber liquid	1.5-2.5 hrs.	8-16 hrs.	1/2Pt, Gal, Drum
320	Toughened, high viscosity, epoxy adhesive for SMC, FRP and general purpose bonding.	Gray paste	10-20 min.	4 hrs.	1/2Pt, Qt, Gal, Pail, Drum
360	Sag-resistant, high-performance, 5-min adhesive. Sandable and paintable when cured.	Gray paste	2-4 min.	15-30 min.	1/2Pt, Gal, Pail
363	Two-component, fast-set, modified epoxy adhesive.	Clear amber	2-3 min.	5-10 min.	1/2Pt, Gal, Pail
370	Two-component adhesive. Safe for painted surfaces.	Black paste	20-30 min.	8 hrs.	Qt, Pail
3170	Two-component adhesive for cryogenic applications. High strength in cold environments	Light amber	2 hrs.	8-16 hrs.	Pts, Qts, Gal Pail, Drum

* Working time is defined as the time allowed before bonding surfaces must be mated.
 ** May be accelerated with heat.
 *** Treated with Lord 7701 surface treatment.

Ellsworth Adhesives **1-800-888-0698**

LORD ADHESIVES

LORD® EPOXY ADHESIVES

- **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 provides the highest possible bond strength and impact resistance).
- **Low shrinkage and good creep properties.**
- **100% solids formulation to meet VOC regulations.**



LORD® EPOXY ADHESIVE SELECTION GUIDE

Mix Ratio By Wt.	Mix Ratio By Vol.	Component Description	Typical Viscosity (cps)	Density lbs/gal	Flash Point °F (°C)	Suggested Uses
4:3	1:1	304-1 Resin 304-2 Hardener	5MM-25MM 1MM-10MM	11.2 ± 3% 8.5 ± 3%	185 (85) >200 (93)	General purpose for bonding to many types of natural and synthetic rubber,*** prepared metals, ceramic and wood.
1:1	1:1	305-1 Resin 305-2 Hardener	10,000-18,000 20,000-45,000	9.7 ± 3% 8.1 ± 3%	>200 (93) >200 (93)	General purpose for bonding to many types of natural and synthetic rubber,*** prepared metals, ceramic and wood.
5:3	1:1	306-1 Resin 306-2 Hardener	5,000-25,000 1MM-10Mm	11.9 ± 3% 8.8 ± 3%	185 (85) >200 (93)	Dampening tiles to steel per Mil Spec and general purpose.
1:1	1:1	305-1 Resin 307-2 Hardener	10,000-18,000 20,000-57,000	9.7 ± 3% 8.1 ± 3%	>200 (93) >200 (93)	General purpose for bonding rubber prepared with Lord 7701 or 7707 surface treatment.
1:1	1:1	309-1 Resin 309-2 Hardener	300,000-1MM 300,000-1MM	10.6 ± 3% 8.5 ± 3%	>200 (93) >200 (93)	General purpose; many types of rubber,*** prepared metals, ceramic and wood.
1.2:1	1:1	310-A Resin 310-B Hardener	500,000-800,000 230,000-700,000	12.1 ± 3% 10.5 ± 3%	171 (77) >200 (93)	General purpose, resists temperatures to 400°F (204°C) formulated for bonding SMC, FRP and other composites.
2:1	2:1	312-A Resin 312-B Hardener	650-1,950 750-2,500	9.4 ± 3% 8.2 ± 3%	171 (77) >200 (93)	General purpose bonding and potting.
1:1.3	1:1	320 Resin 322 Hardener	300,000-1MM 400,000-2MM	12.3 ± 3% 10.3 ± 3%	>200 (93) >200 (93)	General purpose, SMC, FRP and prepared metals; for applications requiring a "toughened" adhesive with high peel strength and resistance to cracking and impact.
5:3	1:1	360-A Resin 360-B Hardener	130,000 170,000	11.8 ± 3% 9.0 ± 3%	>200 (93) >200 (93)	Excellent adhesion to scuffed SMC, FRP, wood & other plastics. Resistant to humidity, water, salt spray and high temperatures.
1:1	1:1	363-A Resin 363-B Hardener	7,000-11,000 10,000-16,000	9.7 ± 3% 9.4 ± 3%	>200 (93) >200 (93)	Fast-set, general purpose bonding.
3:5	1:2	370-A Resin 370-B Hardener	150,000-260,000 160,000-380,000	10.8 ± 3% 9.7 ± 3%	>200 (93) >200 (93)	Resistant to thermal shock and humidity.

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

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LORD ADHESIVES

LORD® URETHANE ADHESIVES



Lord® one- and two-part Urethane Adhesives provide superior bonds with minimal surface preparation for today's high-performance thermosets and thermoplastics. They offer primerless adhesion for sheet molded compounds (SMC) and are ideal for prepared metals, rubber and fiber reinforced plastics (FRP).

Lord Urethane Adhesives are available in several formulations:

- Two-pack 100% solids
- Single-pack 100% solids
- Single-pack high solids

LORD® URETHANE ADHESIVE SELECTION GUIDE

Product	Description	Appearance	Component Description	Working Time*	Sizes
710	Two-component, equal mix, non-flammable adhesive. Cures at room temperature or with heat. 100% solids	Black self-leveling paste	710-A Resin 710-B Curative	5-10 min.	1/2Pt, Gal, Pail
7412	100% solids. Single-component, moisture-cure adhesive.	Wax-like paste	7412	—	1/2Pt, Gal, Pail, Drum
7500	100% solids, two-component adhesive. Cures at room temperature or with heat.	Paste	7500-A Resin 7500-B Curative 7500-C Curative	— 20-30 min. 6-10 min.	1/2Pt, Gal, Pail
7520	100% solids. Two-component, equal-mix non-sagging adhesive.	Paste	7520-A Resin 7520-B Curative	— 5-10 min.	1/2Pt, Gal, Pail
7540	100% solids. Two-component, equal-mix adhesive.	Paste	7540-A Resin 7540-B Curative 7540-B White Curative	— 5-10 min. 5-10 min.	1/2Pt, Gal, Pail
7542	Two-component adhesive bonds FRP, SMC and other plastics with little surface preparation.	Paste	7542-A Resin 7542-B Curative 7542-C Curative 7542-D Curative 7542-E Curative	— 4-5 min. 8-15 min. 15-30 min. 30-60 min.	1/2Pt, Gal, Pail, Drum
7544	Two-component, non-sag, fast-cure, adhesive	Liquid	7544-A Resin 7544-B Hardener	— 6-8 min.	Pail, Drum
7545	Two-component, equal-mix, non-sagging adhesive. Bonds FRP, SMC and other plastics with minimal surface preparation. 100% solids	Paste	7545-A Resin 7545-B Curative 7545-C Curative 7545-D Curative 7545-E Curative 7545-F Curative	— 3-5 min. 6-8 min. 11-18 min.. 22-38 min 45-65 min.	Pail, Drum
7602	Single-component, moisture-cure adhesive/sealant.	Paste	7602	—	1/10 Gal, 1/2 Pt, Gal, Pail
7610	Single-component, moisture-cure,	White paste	7610 sealant/adhesive.	—	1/10 Gal
7650	Single-component, moisture-cure, high tack adhesive.	Liquid	7650	—	1/2Pt, Gal, Pail
7660	Single-component, moisture-cure, high tack adhesive.	Liquid	7660	—	1/2Pt, Gal, Pail

*Working time is defined for this document as the time allowed before bonding surfaces must be mated.
** May be accelerated with heat. All values are determined at 77°F (25°C), 50% relative humidity.

LORD ADHESIVES

LORD® URETHANE ADHESIVES

Benefits of Lord Urethane Adhesives:

- **Cure at room temperature.** One-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.**
- **Gravity feed.** They require no special pumping equipment.

LORD® URETHANE ADHESIVE SELECTION GUIDE

Handling Time**	Mix Ratio By Wt. By Vol.	Density lbs/gal	Flash Point °F (°C)	Suggested Uses
24 hrs.	Single-component	8.7-9.3	>200 (93)	For various thermoplastic substrates and fabrics. High-performance hose, Hytrel, TPU, polyester, Kevlar and nylon.
24 hrs.	Single-component	10.0-10.2	>200 (93)	For bonding Hytrel*, chlorinated polyethylene (CPE), TPU, nylon 11 and other thermoplastics to polyester and Kevlar* for high-pressure hose.
24 hrs.	Single-component	9.0-9.4	>200 (93)	For bonding foam, fabric, wood, thermoplastic and rubber. Adheres reinforcement yarn to thermoplastic tubing and to thermoplastic protective hose covering.
—	1.7 1.4	11.6-12.2	>200 (93)	For bonding a wide variety of plastics, prepared metals and elastomers.
24 hrs.	1 1	9.7-10.3	>200 (93)	
1 hr.	1 1	9.7-10.3	>200 (93)	
—	1 1	10.0-10.6	>200 (93)	For bonding wood, metal, plastic, foam and various honeycomb structures.
18 hrs.	2 2	11.0-11.6	>200 (93)	
9 hrs.	2 2	11.0-11.6	>200 (93)	
—	1 1	9.9-10.2	>200 (93)	For bonding assemblies made of wood, Hytrel, primed metals, foams (open- and closed-cell) and elastomers.
40 min.	1.2 1	8.7-9.0	>200 (93)	
—	1.2 1	11.7-12.1	>200 (93)	For bonding polycarbonate, ABS, thermoplastics and primed metals.
40-120 min.	1 1	10.0-10.4	>200 (93)	
40-120 min.	1 1	10.0-10.4	>200 (93)	
—	1.1 1	11.5-11.7	>200 (93)	For bonding SMC, FRP, composite materials, other plastics and primed metals.
1-2 hrs.	1 1	10.3-10.6	>200 (93)	
1-3 hrs.	1 1	10.3-10.6	>200 (93)	
1-3 hrs.	1 1	10.3-10.6	>200 (93)	
2-6 hrs.	1 1	10.3-10.6	>200 (93)	
24 hrs.	Single-component	8.6	44 (7)	Adhesive/sealant for various plastics, wood, fabrics, cured elastomers and precoated metals.
24 hrs.	Single-component	8.2	26 (-3)	For bonding open-cell polyethylene foam, styrofoam, urethane foams, plastics, fabrics, rubber and prepared metals.
24 hrs.	Single-component	8.7-9.3	42 (6)	For bonding open-cell polyethylene foam, styrofoam, urethane foams, plastics, fabrics, rubber and prepared metals.

*Hytrel and Kevlar are registered trademarks of DuPont.
The above data represents typical values and is not to be used for specification purposes.

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LORD ADHESIVES

LORD® CYANOACRYLATE ADHESIVES



Lord® Cyanoacrylate Adhesives were developed for production situations requiring instant bonds and immediate handling strength, particularly when bonding rubber, metals and plastics.

Lord Cyanoacrylate Adhesives offer these benefits:

- **Instant cure.** Lord Cyanoacrylate Adhesives develop incredibly strong bonds with setting times ranging from 5 to 130 seconds.
- **Ease of use.** Lord Cyanoacrylate Adhesives are one-component systems that facilitate set-up and minimize production costs.
- **Good environmental resistance.** Lord Cyanoacrylate Adhesives offer excellent resistance to weathering and aging.

LORD® CYANOACRYLATE ADHESIVE SELECTION GUIDE

Product	Typical Viscosity (cps)	Base	Plastic	Rubber	Set Time Metal	Density lbs/gal	Mil Spec MIL-A-46050C	Sizes
5000	30	Ethyl	2-4 sec.	2-4 sec.	15-25 sec.	8.83 ± 3%	Type II, Class 1	10, 20, 50 & 500Grm Bottles
Description: Fast setting. High elasticity. Low viscosity. Colorless adhesive for bonding plastic-to-metal and plastic-to-rubber. Very effective in bonding substrates with differing coefficients of expansion.								
5019	2,400	Ethyl	6-10 sec.	—	25-35 sec.	9.25 ± 3%	Type II, Class 3	500Grm Bottle
Description: Fast setting. High viscosity. High elasticity. Gap filling. Colorless. Temperature resistance to 250°F (121°C). Especially suitable for bonding dissimilar and porous materials. Will qualify for USP Class VI approvals.								
5181	2,400	Ethyl	30-35 sec.	30-35 sec.	80-120 sec.	9.08 ± 3%	—	50 & 500Grm Bottles
Description: High viscosity. Black general purpose adhesive. Suitable for bonding porous substrates and materials with different coefficients of thermal expansion. Repositioning of parts and inspection of bonded assemblies is also possible. Especially useful in loud speaker assembly. Resists temperatures to 250°F (121°C).								
6900	90	Butyl	6-8 sec.	3-5 sec.	—	8.83 ± 3%	Type IV, Class 2	10Grm Bottle
Description: Medium viscosity. Low odor. Low bloom. For bonding plastic and elastomers where high resistance to chlorosis and blooming is important.								
7000	90	Methyl	3-4 sec.	—	20-25 sec.	8.83 ± 3%	Type I, Class 2	10, 20, 50 & 500Grm Bottles
Description: Medium setting. Medium viscosity. Moisture resistant. Especially useful for bonding slightly dirty or oily metals to themselves and joining plastic-to-metal.								
7700	1,100	Ethyl	4-6 sec.	4-6 sec.	25-35 sec.	9.00 ± 3%	Type II, Class 3	10, 20, 50 & 500Grm Bottles
Description: Fast setting. High viscosity. Impact resistant. General purpose adhesive for plastics, wood, cork and leather. Will qualify for USP Class VI approval.								
8300	20	Ethyl	2-3 sec.	1-2 sec.	—	8.75 ± 3%	Type II, Class 1	20, 50 & 500Grm Bottles
Description: Medium setting. Medium viscosity. For bonding O-rings and elastomeric materials. Suitable for bonding more difficult substrates such as EPDM and Viton. Especially helpful for bonding loud speaker isolator rings. Will qualify for USP Class VI approval.								
8400	210	Ethyl	4-5 sec.	2-3 sec.	—	8.83 ± 3%	Type II, Class 2	10, 20, 50 & 500Grm Bottles
Description: Fast setting. Medium viscosity. For bonding most plastic and elastomeric materials. Excellent drop control and ability to bridge small tolerances. Well-suited for bonding most porous substrates such as foam rubber.								
9010	150	Methoxyethyl	5-20 sec.	5-20 sec.	25-40 sec.	8.92 ± 3%	—	50 & 500Grm Bottles
Description: Medium viscosity. Odorless and non-frosting. General purpose adhesive formulated for cosmetically critical applications because it will not etch thermoplastic surfaces. Odorless feature eliminates need for special ventilation. Will qualify for USP Class VI approval.								
9900	2,000	Methyl	4-5 sec.*	—	30-40 sec.	9.08 ± 3%	Type I, Class 3	10 & 500Grm Bottles
Description: Normal setting. High viscosity. Odorless and non-frosting. For bonding to metal parts which require gap-filling, impact and vibration resistance, and thermostability. Well-suited for bonding non-ferrous metals.								
CA Gel	Thixotropic	Ethyl	20-25 sec.	12-15 sec.	30-50 sec.	9.00 ± 3%	Type I, Class 4	20Grm Tube, 500Grm Bottle
Description: High viscosity. General purpose applications. Non-stringing and non-migrating. Can be used for bonding assemblies with wide tolerances or large gaps. Can be used on overhead or vertical surfaces. For bonding metals, rubber and most plastics.								

* Plastic-to-plastic

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LORD ADHESIVES

LORD® ADHESION ENHANCERS/SURFACE MODIFIERS



To meet the unique bonding demands that accompany use of difficult-to-bond materials, Lord Corporation offers a full line of adhesion enhancers/surface modifiers. 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	Solvents	Non-volatile weight by content	Typical Viscosity (cps)	Density lbs/gal	Flash Point F (°C)	Suggested Uses	Sizes
AP-134	Low viscosity, reactive polymer primer or adhesive for polar substrates. Clear, light straw-yellow liquid.	Toluene, n-Butanol, Ethanol	4.8-6.2%	8	7.2-7.5 Gal	35 (2)	Solvent-borne adhesion enhancer for steel, aluminum, brass, E-coated metal, glass, ceramic tile, vitrified clay pipe, concrete and some plastics.	4oz Bottle, Qt, Pail, Drum
459X	Amber liquid. In an all-Xylene solvent diluted for direct application	Xylene	2.7-4.1%	10	7.1-7.4	81 (27)	Promotes adhesion to thermoplastic elastomers (TPE), polyolefins (TPO) and EPDM. Can be used with Lord engineered acrylic, epoxy, urethane and cyanoacrylate adhesives, and double-sided tape.	1/2Pt, Gal Pail, Drum
459T	Amber liquid in an all-toluene solvent diluted for direct application.	Toluene	2.7-4.1%	10	7.2-7.4	40 (4)	Promotes adhesion to thermoplastic elastomers (TPE), polyolefins (TPO) and EPDM. Can be used with Lord engineered acrylic, epoxy, urethane and cyanoacrylate adhesives, and double-sided tape.	4oz Bottle, 1/2Pt Gal, Pail
7701	Hazy to cloudy liquid.	Ethyl Acetate	2.0-3.6%	10	7.5-7.7	25 (-4)	Surface conditioner for various vulcanized and thermoplastic polymeric materials.	1/2Pt, Gal Pail
7707	Hazy to cloudy liquid.	n-Butyl Acetate	2.0-3.6%	10	7.3-7.5	92 (33)	Surface conditioner for various vulcanized and thermoplastic polymeric materials.	1/2Pt, Gal
7713	Single-component layover primer. Purple liquid.	Trichloroethylene Methylene Chloride	13.5-13.9%	20	11.2-11.6>200 (>93)		Specifically formulated to provide increased adhesion of adhesives to SMC.	1/2Pt, Gal Pail

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