

LORD® 206 Acrylic Adhesive

with LORD Accelerator 4, 17 or 19

Description

LORD® 206 acrylic adhesive when cured with LORD Accelerator 4, 17 or 19 creates a long working time adhesive system that bonds a wide variety of prepared or unprepared metals and plastics. LORD 206 acrylic adhesive in combination with the recommended accelerator replaces welding, brazing, riveting and other mechanical fastening methods.

LORD 206 acrylic adhesive can be cured with either LORD Accelerator 4, LORD Accelerator 17 or LORD Accelerator 19. LORD Accelerator 4 is a no-mix accelerator applied to the substrate before the acrylic adhesive. LORD Accelerators 17 and 19 must be mixed into the acrylic adhesive prior to application. LORD Accelerator 19 is available in off-white or black. For further detailed information on LORD Accelerator 4, LORD Accelerator 17 and LORD Accelerator 19, refer to the applicable data sheet.

Features and Benefits

Convenient – provides long working time, reducing adhesive waste.

Bonds Unprepared Metals – requires little or no substrate preparation.

Versatile – bonds a wide variety of substrates such as metals, ceramics and plastics; can be used with both Mix-In and No-Mix accelerators; insensitive to minor deviations from correct mix ratio.

Temperature Resistant – performs at temperatures from -40°F to +300°F (-40°C to +149°C).

Environmentally Resistant – resists dilute acids, alkalis, solvents, greases, oils and moisture; provides excellent resistance to indirect UV exposure, salt spray and weathering.

Typical Properties*

Appearance	Off-white Liquid
Viscosity, cP @ 77°F (25°C) Brookfield HAT Spindle 7, 20 rpm	20,000-80,000
Density	
lb/gal	8.5-8.7
(kg/m ³)	(1019-1042)
Flash Point (Closed Cup), °F (°C)	66 (19)

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

Application

Surface Preparation – Remove grease, loose contamination or poorly adhering oxides from metal surfaces. Normal amounts of mill oils and drawing compounds usually do not present a problem in adhesion. Most plastics require a simple cleaning before bonding. Some may require abrading for optimum performance.

Mixing

- No-Mix Accelerator
LORD 206 acrylic adhesive and LORD Accelerator 4 are not mixed prior to application.
- Mix-In Accelerator
Mix LORD 206 acrylic adhesive with the proper amount of LORD Accelerator 17 or 19. Handheld cartridges will automatically dispense the correct volumetric ratio of each component. Even color distribution visually indicates a thorough mix. Once mixed, the acrylic adhesive cures rapidly.

Applying

- No-Mix Accelerator
Apply LORD Accelerator 4 to one or both substrate surfaces. Allow accelerator to dry. For further details on the use of LORD Accelerator 4, refer to the LORD Accelerator 4 data sheet.
Once accelerator is dry, apply adhesive using a handheld cartridge or automatic dispense equipment. Mate the two surfaces and slide into correct position within the working time of the adhesive.
- Mix-In Accelerator
Apply mixed adhesive using handheld cartridges or automatic meter/mix/dispense equipment.
Handheld Cartridges
 1. Load the cartridge into the applicator gun and remove the end caps.
 2. Level the plungers by expelling a small amount of adhesive to ensure both sides are level.

3. Attach mixing tip and expel a mixer's length of adhesive.
4. Apply adhesive to substrate and mate the parts within the working time of the adhesive. Clamp in position until adhesive reaches handling strength.

Meter/Mix/Dispense Equipment

Contact your LORD representative if assistance is needed using this equipment. When using such equipment, all wetted parts must be made of stainless steel and all hoses should be steel braided Teflon®.

Curing – Cure begins immediately once adhesive and accelerator come in contact. Handling strength is achieved within 45 minutes. Complete cure will take 24 hours at room temperature. Mating surfaces should be fixtured as soon as possible (in less than ten minutes) after adhesive application.

Shelf Life/Storage

Shelf life is six months when stored at temperatures under 80°F (27°C) in original, unopened container. For maximum shelf life, storage temperatures of 40-50°F (4-10°C) are recommended. If stored at these cooler temperatures, allow product to return to room temperature before using.

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.

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LORD TECHNICAL DATA

Typical Properties* of Adhesive Mixed with Recommended Accelerator

Mix Ratio by Volume, Adhesive to Accelerator	
A4	No-Mix
A17	10:1
A19 or A19 Black	10:5
Solids Content, %	—
Working Time, min @ 75°F (24°C)	12-14
Time to Handling Strength, min @ 75°F (24°C)	45-60
Mixed Appearance	
A4	—
A17	Tan Paste
A19	Tan Paste
A19 Black	Grey Paste
Cured Appearance	
A4	—
A17	Tan to Green
A19	Tan to Green
A19 Black	Black

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

Typical Cured Properties** – LORD 206 Adhesive/LORD Accelerator 19

Tensile Strength at Break, psi (MPa)	2472 (17)
ASTM D638, modified	
Elongation, %	8.4
ASTM D638, modified	
Young's Modulus, psi (MPa)	116,581 (803.8)
ASTM D638, modified	
Glass Transition Temperature, °F (°C)	—
ASTM E1640-99, by DMA	

**Bond performance data was obtained using LORD 206 adhesive/Accelerator 19. Please contact LORD Corporation regarding the use and/or performance of using other accelerator combinations (+1 877 ASK LORD).

LORD TECHNICAL DATA

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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