

LORD® 661, 662 and 663 Acrylic Adhesives with LORD Accelerator 6

Description

LORD® 661, 662 and 663 acrylic adhesives when cured with LORD Accelerator 6 create adhesive systems that will bond composites including DCPD (dicyclopentadiene) resin and modified DCPD resin based FRP (fiber reinforced plastic). These adhesive systems can also cross-bond composites to many metals.

LORD 661, 662 and 663 acrylic adhesives in combination with LORD Accelerator 6 utilize unique patented technology to create exceptionally strong bonds with excellent surface cure and minimal surface preparation. LORD 661, 662 and 663 acrylic adhesives are available in a range of working times to accommodate a wide variety of process requirements.

For further detailed information on LORD Accelerator 6, refer to the LORD Accelerator 6 data sheet.

Features and Benefits

Versatile – bonds difficult-to-bond composites, such as DCPD based FRP, and a wide range of metals with minimal surface preparation.

Environmentally Resistant – resists dilute acids, alkalis, solvents, water immersion, moisture and weathering.

Gap Filling Capability – fills gaps as large as 1.0 inch (25.4 mm).

Non-Sag – remains in position when applied on vertical or overhead surfaces, allowing for greater process flexibility.

Application

Surface Preparation – Surfaces should be free of grease, dirt and other contaminants. Some surfaces may require abrading for optimum performance.

Mixing – Mix LORD 661, 662 or 663 acrylic adhesive with the proper amount of LORD Accelerator 6. Hand-held cartridges will automatically dispense the correct volumetric ratio of each component. Once mixed, the adhesive begins to cure.

Applying – Apply 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.

Typical Properties*

	661	662	663
Appearance	White/Off-white/ Blue Tint Paste	White/Off-white/ Blue Tint Paste	White/Off-white/ Blue Tint Paste
Viscosity, cP	125,000 - 350,000	125,000 - 350,000	125,000 - 350,000
Density			
lb/gal	8.8-9.8	8.8-9.8	8.8-9.8
(kg/m ³)	(1055-1174)	(1055-1174)	(1055-1174)
Flash Point, °F (°C)	59 (15)	59 (15)	59 (15)

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

LORD TECHNICAL DATA

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.

Curing – Cure begins immediately once adhesive and accelerator are mixed. Depending on adhesive, handling strength is achieved within 45-160 minutes. Complete cure will take 24 hours at room temperature. Adhesive will cure to a tack-free surface.

Shelf Life/Storage

Shelf life is six months when stored below 80°F (27°C) in original, unopened container. Storage temperatures of 40-50°F (4-10°C) are recommended. If stored cold, allow product to return to room temperature before using. Protect from exposure to direct sunlight.

LORD 661, 662 and 663 acrylic adhesives are flammable. Do not store or use near heat, sparks or open flame.

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.

Typical Properties* of Adhesive Mixed with Recommended Accelerator

	661	662	663
Mix Ratio, Adhesive to Accelerator			
by Weight	7.4:1	7.4:1	7.4:1
by Volume	10:1	10:1	10:1
Solids Content, %	100	100	100
Working Time, min @ 90°F (32°C) 1" diameter bead	11-19	22-38	45-75
Time to Handling Strength**, min 100 psi Lap Shears in 30 mil x 1" x 1"	45-55	70-90	130-160

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

**Time may change if bondline dimension and temperature vary.

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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