LORD® 7550 Urethane Adhesive

Technical Data Sheet

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 Recommended – does not contain ozone depleting chemicals.

Environmentally Resistant – resists weathering, humidity and salt spray; UV resistant.

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 acetone or methyl ethyl ketone (MEK). Do not use 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. Some success may be achieved with commercial adhesive strippers.

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.

Typical Properties*

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

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

Cautionary Information:

Before using this or any Parker 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 Resin Mixed with Curative	
Mix Ratio by Volume, Resin to Curative	1:1
Solids Content by Weight, %	100
Working Time, minutes @ 75°F (24°C)	3 - 5
Purge Time, minutes @ 75°F (24°C)	2 - 3
Time to Handling Strength, minutes @ 77°F (25°C)	60

**Data is typical and not to be used for specification purposes. Given a 1/2 inch (12.7 mm) bead.

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Parker LORD
Engineered Materials Group

111 LORD Drive
Cary, NC 27511-7923
USA

phone +1 877 ASK LORD (275 5673)

www.lord.com