LORD® 7100 and 7150 Urethane Adhesives

Description

LORD® 7100 and 7150 adhesives are two-part, high strength urethane adhesives used to bond cloth, paper, plastics, foams, rubber, painted metals and powder coated metals. LORD 7100-A and 7150-A resins are composed of isocyanate. LORD 7100-B and 7150-B curatives are composed of polyol.

These adhesives can be either room temperature cured or heat cured for faster processing. LORD 7100 adhesive cures to a glossy black appearance; LORD 7150 adhesive cures to a unique gray color.

Features and Benefits

Convenient – reduces material and labor costs by eliminating the need to prime many plastics.

Durable – creates high strength bonds to plastics without crazing, attacking or lowering the strength of the plastic substrate.

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

Environmentally Recommended – no VOC content; does not contain ozone depleting chemicals.

Chemically Resistant – solvent resistant when cured.

Environmentally Resistant – resists weathering and aging.

Application

Surface Preparation – Surfaces should be free of grease, dirt and other contaminants. For most 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 appropriate curative at a 1:2 ratio, by volume. Handheld cartridges will automatically dispense the correct volumetric ratio of each component. Once mixed, the adhesive cures rapidly.

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.
  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.

Typical Properties*

	7100-A Resin	7100-B Curative	7150-A Resin	7150-B Curative
Appearance	Black Liquid	Black Liquid	Black Liquid	White Liquid
Viscosity, cP @ 75°F (24°C)	3000-16,000 Brookfield LVT Spindle 4, 30 rpm	45,000-72,000 Brookfield HA Spindle 6, 20 rpm	3000-16,000 Brookfield LVT Spindle 4, 30 rpm	41,500-65,500 Brookfield HA Spindle 6, 20 rpm
Density				
lb/gal	12.4-12.7	10.9-11.4	12.4-12.7	10.9-11.4
(kg/m^3)	(1486-1522)	(1306-1366)	(1486-1522)	(1306-1366)
Flash Point (Closed Cup), °F (°C)	>200 (>93)	>200 (>93)	>200 (>93)	>200 (>93)

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

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Curing – LORD 7100 and 7150 adhesives will cure to full strength in 24 hours at room temperature, 77°F (25°C). Cure rate can be accelerated when adhesive is cured at elevated temperatures.

Cleanup – Remove adhesive squeeze-out with a dry knife blade or similar device when the adhesive begins to harden. Take care to avoid disrupting the bondline.

Shelf Life/Storage

Shelf life is six months when stored in a clean, dry environment at 65-85°F (18-30°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 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

	7100-A/B	7150-A/B
Mix Ratio, Resin to Curative		
by Volume	1:2	1:2
by Weight	1:1.78	1:1.78
Solids Content by Weight, %	100	100
Working Time, min @ 77°F (25°C)	5-10	5-10
Purge Time, min @ 77°F (25°C)	3	3
Time to Handling Strength, hr @ 73°F (23°C)	2-3	2-3

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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.

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