

LORD® Accelerator 4

Description

LORD® Accelerator 4 is a no-mix curative designed for use with LORD acrylic adhesives. LORD Accelerator 4 can be used with LORD 200 series, 500 series, and Maxlok™ T6 acrylic adhesives.

Features and Benefits

Convenient – provides room temperature cure with all LORD acrylic adhesives.

Extended Work Time – provides extended assembly time as adhesive does not begin cure until it comes in contact with surface coated with dry accelerator.

Easy to Apply – applies easily by brush, wipe, spray or dip methods onto one or both bonding surfaces.

Fast Cure – dries in approximately one minute to an off-white crystalline film.

Environmentally Resistant – resists common environmental conditions when used with LORD acrylic adhesives.

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.

Applying – Apply a light coat of accelerator by brush, wipe, spray or dip method onto one or both bonding surfaces.

LORD Accelerator 4 applied to one surface will cure bondline thicknesses up to 635 micron (25 mil). For bondline thicknesses between 508-1016 micron (20-40 mil), apply accelerator to both bonding surfaces.

Drying/Curing – LORD Accelerator 4 will dry in approximately one minute to an off-white crystalline film. If accelerator does not dry within five minutes, dispose of material in compliance with regulations.

Once dry, apply adhesive resin on other bonding surface, and join the parts. Cure begins once adhesive comes in contact with accelerator. Handling strength and complete cure times will vary depending on acrylic adhesive used.

Typical Properties*

Appearance	Clear to Opaque, Colorless to Amber Liquid
Viscosity, cP @ 77°F (25°C) Brookfield LVT Spindle 3, 12 rpm	<10
Density	
lb/gal	10.2-10.7
(g/cm ³)	(1.22-1.28)
Solids Content by Weight, %	10
Flash Point, °F (°C)	>200 (>93)

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

LORD TECHNICAL DATA

Coated parts may be stored for up to four weeks if kept below 80°F (26°C) and out of direct sunlight. Keep parts covered to avoid contamination.

Cleanup – Clean equipment and tools prior to the adhesive cure with hot water and detergent or an organic solvent such as ketones. Once adhesive is cured, heat the adhesive to 400°F (204°C) or above to soften the adhesive. This allows the parts to be separated and the adhesive to be more easily removed.

Shelf Life/Storage

Shelf life is six months when stored at 40-70°F (4-21°C) in original, unopened container. Exposure to temperatures greater than 80°F (27°C) will shorten shelf life.

Cautionary Information

Before using this or any LORD product, refer to the Material Safety Data Sheet (MSDS) 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.

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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