

LORD[®] 5206 Acrylic Adhesive with LORD Accelerator 55GB

Technical Data Sheet

LORD[®] 5206 acrylic adhesive in combination with LORD Accelerator 55GB replaces welding, brazing, riveting and other mechanical fastening methods especially over a wide range of temperature environments subject to high impact or high peel loads.

LORD Accelerator 55GB allows precise control of the adhesive bondline thickness due to its content of glass beads, 0.01" (0.025 cm) diameter. For further detailed information, refer to the LORD Accelerator 55GB data sheet.

Features and Benefits:

Versatile – bonds a wide range of unprepared metals with minimal substrate preparation.

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, moisture, salt spray and weathering; provides excellent resistance to indirect UV exposure.

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

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 – Mix LORD 5206 adhesive with the proper amount of LORD Accelerator 55GB. Handheld cartridges will automatically dispense the correct volumetric ratio of each component. Even color distribution visually indicates a thorough mix. 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 material 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.

Do not re-expose adhesive to air once parts are mated. Mated parts should be repositioned by sliding to achieve proper alignment.

- Meter/Mix/Dispense Equipment
Contact your Parker LORD representative if assistance is needed using this equipment.

Curing – Cure begins immediately once adhesive and accelerator are mixed. Complete cure requires 24 hours at room temperature. Mating surfaces must be held in contact during the entire curing process. Cure rate can be accelerated by applying modest heat [$<150^{\circ}\text{F}$ ($<66^{\circ}\text{C}$)].

Typical Properties*

Appearance	Off-white to Tan Paste
Viscosity, cP @ 77°F (25°C) Brookfield	100,000 - 220,000
Density lb/gal (kg/m ³)	8.35 - 8.80 (1001 - 1054)
Flash Point (Closed Cup), °F (°C)	53 (11)

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



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Cleanup – Clean equipment and tools prior to the adhesive cure with solvents such as isopropyl alcohol, acetone or methyl ethyl ketone (MEK). 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 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 5206 acrylic adhesive is flammable. Do not store or use near heat, sparks or open flame.

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 Adhesive Mixed with Recommended Accelerator

Mix Ratio by Volume, Adhesive to Accelerator	4:1
Solids Content, %	100
Working Time, minutes @ 75°F (24°C)	6-8
Time to Handling Strength, minutes @ 75°F (24°C) 50 psi Shear	24-28
Mixed Appearance	Grey Paste

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Typical Cured Properties*

Tensile Strength at Break, psi (MPa)	3340 (23.0)
Lap Shear Strength, psi (MPa) @ 77°F 25°C Aluminum	2800 (19.3)
Elongation, % ASTM D638	14.8
Young's Modulus, psi (GPa)	506,050 (3.49)
Glass Transition Temperature (T _g), °F (°C)	195 (90.7)

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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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