

LORD® Signlok 810 Adhesive

Description

LORD® Signlok 810 adhesive when cured with LORD Accelerator 20 creates a flexible adhesive system for bonding metals, such as aluminum, aluminum composite material (ACM), galvanized steel and CRS, and engineered plastics, such as PC-ABS and ASA. LORD Signlok 810 adhesive in combination with LORD Accelerator 20 delivers fast cure speed and strong bonding with minimal bondline read-through (BLRT).

LORD Accelerator 20 allows precise control of the adhesive bondline thickness due to its content of glass beads. For further detailed information, refer to the LORD Accelerator 20 data sheet.

Features and Benefits

Aesthetics – bonds thin and flexible substrates with little to no bondline read-through.

Convenient – requires little or no substrate preparation for bonding metals and plastics.

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

Environmentally Resistant – resists dilute acids, alkalis, solvents, greases, oils and moisture; provides excellent resistance to UV exposure and weathering.

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 Signlok 810 adhesive with LORD Accelerator 20 at a ratio of 2:1, adhesive to accelerator, by volume. Even color distribution visually indicates a thorough mix. Once mixed, the adhesive system cures rapidly.

Applying – Apply the mixed adhesive to bond surfaces using a handheld cartridge or automatic meter/mix/dispense equipment. Contact your LORD representative if assistance is needed using this equipment.

Curing – 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 [$<150^{\circ}\text{F}$ ($<66^{\circ}\text{C}$)].

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.

Typical Properties*

Appearance	Black Paste
Viscosity, cP @ 77°F (25°C) Brookfield	40,000-120,000
Density	
lb/gal	7.7-8.0
(kg/m ³)	(920-960)
Flash Point, $^{\circ}\text{F}$ ($^{\circ}\text{C}$)	59 (15)

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

LORD TECHNICAL DATA

Shelf Life/Storage

Shelf life is six months when stored below 77°F (25°C) in original, unopened container. Storage temperatures of 40-60°F (4-15°C) are recommended. If stored cold, allow product to return to room temperature before using. Protect from exposure to ultraviolet light.

LORD Signlok 810 adhesive is 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 Cured Properties**

Hardness Shore D	40
Tensile Strength at Break, psi (MPa)	841 (5.8)
Elongation, %	190
Glass Transition Temperature (T _g), °F (°C)	109 (43)

**Data obtained using LORD Signlok 810 adhesive/Accelerator 20 cured at room temperature. Data is typical and not to be used for specification purposes.

Typical Properties* of Adhesive Mixed with Recommended Accelerator

Mix Ratio, Adhesive to Accelerator	
by Weight	1.1:1
by Volume	2:1
Solids Content, %	100
Working Time, min @ 70°F (21°C)	8-12
Time to Handling Strength, min @ 70°F (21°C)	20-25
Mixed Appearance	Grey Paste
Cured Appearance	Grey

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

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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