

TECH TIPS:

The LORD 400 Series Acrylic Adhesive dispensed is still tan and soft after 24 hours. Why didn't it cure?

Check storage condition of the adhesive. Exposure to elevated temperatures will degrade the curative over time. Check the *Use by* date to ensure the adhesive is within its shelf life. Check to see if either the acrylic or curative has blown out around the pistons when using adhesives in cartridges, this will cause improper mix. If the adhesive is within shelf life, has been stored properly and no blow out is observed call +1 877 ASK LORD for assistance.

The LORD 400 Series Acrylic Adhesive dispensed yesterday turned green but is still tacky on the exposed adhesive. Is it cured?

Yes. Surface tack is normal for LORD 400 series acrylic adhesives. Wipe the surface with alcohol or organic solvent after full cure to remove tacky layer. Surface tack is only on surface; bonded joints are fully cured. Since LORD 400 series cures from bottom to top, the air will compete with the cure process causing surface tack.

How does the strength of adhesives compare to tape, welding, etc.?

Chemical fastening is comparable to mechanical fastening (welding). The advantage of adhesives over tape and welding are: aesthetically pleasing appearance, even distribution, flexible work time and more tolerant to harsh environmental exposure.

We had a very cold day today and the adhesive is not curing as fast as it normally would at room temperature. Will it ever cure and will it be okay when it eventually cures?

LORD adhesives cure at a slower rate in a cooler environment, however the end adhesives properties will be similar to being cured at room temperature. A general rule of thumb is that for every 18°F (or 10°C) drop in temperature the open/cure time will double. An adhesive which normally cures within 24 hours with a 15-minute open time will take approximately 48 hours to cure and offer a 30-minute open time when dispensed at 57°F (14°C) instead of 75°F (24°C). In general, cure temperatures should not be below 32°F (0°C).

A hot day will have the opposite effect. For every 18°F (or 10°C) increase in temperature, the open/cure time will be cut in half. Heat will offer some slight advantage in getting higher bond strength. In general, cure temperatures should not exceed 150°F (66°C) for acrylic adhesives and 325°F (163°C) for urethane and epoxy adhesives. Typical room temperature cure conditions for adhesives is 65°F-85°F (18°C-29°C).

Are there any applications that should not be used with LORD adhesives?

Yes. Direct human or animal contact. LORD adhesives should not be used to assemble or repair substrates that will be used with food and water.