

When selecting an adhesive, there are several important considerations at every application phase, including substrate type, surface preparation, temperature, application/cure time and other factors. Use the chart to the right to determine which LORD solution is best suited for your particular application.

Please note: These are general recommendations. For comprehensive product selection assistance, please contact the LORD Customer Support Center at +1 877 ASK LORD (275 5673) in United States and Canada.

- * Potlife for mix-in-only; no-mix type has no potlife consideration
- ** Potlife for two-component type only
- *** Both mix and no-mix systems are available
- **** Mix required for two-component systems only. Contact the LORD Customer Support Center at +1 877 ASK LORD (275 5673) for specific recommendations.

Surface Preparation

Preparing Your Substrate

Prior to adhesive application remove soils, greases, oils, dust, mold release agents, rust and other contaminants from substrate surface with the use of a vapor-free solvent, such as MEK, acetone or IPA.

Plastics: Clean the surface with a dry rag or dampened solvent rag.

Metals: Prime, paint or grit blast, followed by a solvent wash for optimum bond performance.

	ACRYLIC	EPOXY	URETHANE
PRE-APPLICATION PHASE			
ADHESIVE COMPONENTS	2	2	1 OR 2
SUBSTRATE	METALS THERMOPLASTICS THERMOSETS COMPOSITES	PREPARED METALS RUBBER THERMOSETS COMPOSITES	THERMOPLASTICS RUBBER THERMOSETS COMPOSITES PRIMED METALS
SURFACE PREPARATION Metals Thermosets Thermoplastics	NO YES NO	YES NO NO	YES NO NO
PHYSICAL STATE	MED. LIQUID TO PASTE	MED. LIQUID TO PASTE	MED. LIQUID TO PASTE
PACKAGING	3 OZ - 55 GAL	3 OZ - 55 GAL	3 OZ - 55 GAL
APPLICATION PHASE			
CURE TEMPERATURE	ROOM TEMP. OR HEAT	ROOM TEMP. OR HEAT	ROOM TEMP. OR HEAT
WORKING TIME	1 - 30 MIN*	5 - 180 MIN	4 - 120 MIN**
HANDLING TIME	2 - 60 MIN	2 - 12 HR	0.5 - 24 HR
SPEED CURE WITH	MILD HEAT/CATALYST	HEAT	HEAT/CATALYST
FLASH POINT °F(°C)	>50 TO 200 (10-93)	>200 (93)	>200 (93)
HUMIDITY DEPENDENT	NO	NO	YES, SINGLE-COMPONENT
MIX REQUIRED	NO***	YES	YES****
POST-APPLICATION PHASE			
SHEAR STRENGTH	VERY HIGH	VERY HIGH	HIGH
PEEL STRENGTH	MEDIUM	MEDIUM	HIGH
IMPACT STRENGTH	HIGH	HIGH	HIGH
RESISTANCE TO: Moisture Chemicals UV Light	EXCELLENT EXCELLENT EXCELLENT	VERY GOOD VERY GOOD EXCELLENT	VERY GOOD VERY GOOD VERY GOOD
TEMPERATURE RANGE °F(°C)	-40 TO 400 (-40 TO 204)	-20 TO 400 (-29 TO 204)	-40 TO 350 (-40 TO 178)

The above data represents typical values and is not to be used for specification purposes.

SELECTION CONSIDERATIONS

	BARE ALUMINUM OR STEEL, INCLUDING STAINLESS	GALVANIZED STEEL	PREFINISHED METAL	FRP/GRP	SMC	RUBBER (1)	ENGINEERING THERMOPLASTICS (POLYCARBONATE, ACRYLIC, ABS, PVC) (5)	WOOD	URETHANE FOAM (2)	CERAMIC/STONE	THERMOPLASTIC, TPU, TPO, NYLON, POLYPROPYLENE (3)	GLASS (1)
BARE ALUMINUM OR STEEL, INCLUDING STAINLESS	2XX 4XX 6XX Maxlok 3XX (4,6)	2XX 4XX 6XX Maxlok 3XX (4,6)	2XX 4XX 6XX Maxlok 3XX (4,6)	2XX 4XX 6XX Maxlok 3XX (4,6)	2XX 4XX 6XX Maxlok 3XX (4,6)	3XX (1,4)	2XX 4XX 6XX Maxlok 3XX (4) 7XXX (2)	3XX (4) 7XXX	6XX 3XX (4) 7XXX	3XX (4) 7XXX (1)	2XX 4XX Maxlok 3XX (4) 7XXX	2XX (1) 4XX (1) Maxlok (1) 7XXX (1)
GALVANIZED STEEL		2XX 4XX 606 (2) Maxlok	2XX 4XX 606 (2) Maxlok	2XX 4XX 606 (2) Maxlok	2XX 4XX 606 (2) Maxlok	606 (2)	2XX 4XX 606 (2) Maxlok	606 (2)	606 (2)	3XX	2XX 4XX 606 (2)	2XX (1) 4XX (1) Maxlok (1)
PREFINISHED METAL			2XX 4XX 6XX Maxlok 3XX 7XXX	2XX 4XX 6XX Maxlok 3XX 7XXX (6)	2XX 4XX 6XX Maxlok 3XX 7XXX	6XX (1,6) 3XX (1,6) 76XX (1,6)	2XX (6) 4XX (6) 6XX (6) Maxlok (6) 3XX (6) 7XXX (6)	3XX 7XXX	6XX 3XX 7XXX	2XX (1,6) 4XX (1,6) 6XX (1,6) Maxlok (1,6) 3XX (1,6) 76XX (1,6)	2XX 4XX 6XX Maxlok 3XX 7XXX	2XX (1) 4XX (1) Maxlok (1) 7XXX (1)
FRP/GRP				2XX 4XX 6XX Maxlok 3XX (6) 7XXX (6)	6XX 3XX (6) 7XXX (6)	3XX (1) 7XXX (1)	6XX 3XX 7XXX	606 3XX 7XXX	6XX 3XX 7XXX	6XX 3XX 7XXX	6XX (1) 3XX (1) 7XXX (1)	7XXX (1)
SMC					606 3XX 7XXX	6XX 3XX (1) 7XXX (1)	2XX 4XX 6XX Maxlok 3XX 7XXX	606 3XX 7XXX	6XX 3XX 7XXX	6XX 3XX 7XXX	6XX (1) 3XX (1) 7XXX (1)	7XXX (1)
RUBBER (1)						3XX 7XXX	3XX 7XXX	3XX 7XXX	3XX 7XXX	3XX 7XXX	3XX 7XXX	7XXX (1)
ENGINEERING THERMOPLASTICS (POLYCARBONATE, ACRYLIC, ABS, PVC) (5)							2XX 4XX Maxlok 3XX 7XXX	606 3XX 7XXX	2XX 4XX 6XX Maxlok 3XX 7XXX	2XX 4XX Maxlok 3XX 7XXX	2XX 4XX Maxlok 3XX 7XXX	4XX (1) Maxlok (1) 7XXX (1)
WOOD								3XX 7XXX	3XX 7XXX	3XX 7XXX	3XX 7XXX	7XXX (1)
URETHANE FOAM (2)									3XX 7XXX	3XX 7XXX	3XX 7XXX	7XXX (1)
CERAMIC/STONE										3XX 76XX	3XX 76XX	7XXX (1)
THERMOPLASTIC, TPU, TPO, NYLON, POLYPROPYLENE (3)											606 3XX 76XX	NR NR NR
GLASS (1)												4XX (1) Maxlok (1) 7XXX (1)

- (1) Requires a primer or adhesion promoter.
- (2) Variable results - Contact the LORD Customer Support Center for special instructions.
- (3) Flame, corona, plasma treatment or a primer is required - Contact the LORD Customer Support Center.
- (4) Epoxy used on bare metals requires a clean, solvent-wiped surface for best results.
- (5) Acrylic adhesive should not be used to attach large thermoplastic parts due to the differences in thermal expansion - Contact the LORD Customer Support Center.
- (6) May require scuffing or abrading surfaces.

XX-XXX - Represents numbers for the family of adhesives to be utilized - Contact the LORD Customer Support Center.
NR - Not Recommended