

# LORD® Structural Adhesives Product Overview

RESIN	ACCELERATOR	MIX RATIO	APPEARANCE	OPEN TIME (min.)	HANDLING TIME (min.)	SHEAR (MPa <sup>a</sup> )	Tg (°C)	ELONGATION <sup>b</sup> (%)	SERVICE TEMP. (°C)
<b>ACRYLICS (Two-Component)</b>									
LORD 403E	LORD 17	10:1	Off white to tan, non sag paste	2-4	4-6	16-23	72	30	-40/+150
	LORD 19/GB/B	4:1	Off white to tan, non sag paste/Black	2-4	4-6	16-23	72	30	-40/+150
LORD 406E	LORD 17	10:1	Off white to tan, non sag paste	6-10	12-17	16-23	72	30	-40/+150
	LORD 19/GB/B	4:1	Off white to tan, non sag paste/Black	6-10	12-17	16-23	72	30	-40/+150
LORD 410	LORD 17	10:1	Off white to tan, non sag paste	20-45	60-120	16-23	72	30	-40/+150
	LORD 19/GB/B	4:1	Off white to tan, non sag paste/Black	20-45	60-120	16-23	72	30	-40/+150
LORD 506	LORD 17	10:1	Tan, medium viscosity paste	4-6	8-12	16-18	112	20	-40/+150
LORD 606	LORD 17	10:1	Off white to white, non sag paste	6-10	16-24	16-18	100	10	-40/+150
LORD 663	LORD 17	10:1	Off white to white, non sag paste	45-75	130-160	16-18	100	10	-40/+150
LORD 810	LORD 20GB	2:1	Grey Paste, non sag paste	8-12	20-25	16-23	43	190	-40/+150
LORD 850	LORD 25GB	10:1	Amber Paste, non sag paste	6-10	18-24	16-23	80	96	-40/+150
LORD 852	LORD 25GB	10:1	Amber Paste, non sag paste	20-25	50-70	16-23	81	103	-40/+150
<b>EPOXY (Two-Component)</b>									
LORD 304-1	LORD 304-2	1:1	Gray paste	60-120	480-960	16-20	56	10	-30/+120
LORD 305-1	LORD 305-2	1:1	Clear blue liquid	60-120	480-960	14-15	61	31	-30/+120
	LORD 307-2	1:1	Clear liquid	60-120	480-960	14-15	61	31	-30/+120
LORD 309-1D	LORD 309-2D	1:1	Blue Green thixo paste	90-120	480-960	16-20	70	6	-30/+120
LORD 310A	LORD 310 B	1:1	Gray paste	30-60	360-480	16-20	60	2	-40/+150
	LORD 310B Black	1:1	Black paste	30-60	360-480	16-20	60	2	-40/+150
	LORD 310B HT	3:2	Gray paste	30-60	360-480	16-20	100	2	-40/+204
LORD 312A	LORD 312B	1.75:1	Yellow liquid	90-150	480-960	12-14	50	56	-30/+120
LORD 320	LORD 310B Black	1:1	Gray paste	30-60	360-480	16-20	80	3	-40/+150
LORD 3170A	LORD 3170B	1:1	Honey paste	120	1440	18-20			-253/+80

<sup>a</sup>Typical cohesive strength    <sup>b</sup>Elongation at break    B=Black    GB= Glass Beads

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<b>URETHANE (Two-Component)</b>									
LORD 7542A	LORD 7542B	1:1	Brown liquid, brown paste after mixing	4-7	60-120	14-16	48	90	-40/+100
	LORD 7542C	1:1	Brown liquid, brown paste after mixing	11-15	120	14-16	48	90	-40/+100
	LORD 7542D	1:1	Brown liquid, brown paste after mixing	20-30	180	14-16	44	90	-40/+100
	LORD 7542E	1:1	Brown liquid, brown paste after mixing	50-60	240	14-16	45	90	-40/+100
LORD 7545A	LORD 7545G	1:1	Black non sag paste	1.5	10	14-16	51	70	-40/+100
	LORD 7545B	1:1	Off white or black non sag paste	3-5	30	14-16	30	70	-40/+100
	LORD 7545C	1:1	Off white non sag paste	6-8	60	14-16	49	70	-40/+100
	LORD 7545E	1:1	Off white non sag paste	22-38	120-180	14-16	29	160	-40/+100
	LORD 7545F	1:1	Off white non sag paste	45-65	480-600	14-16	39	145	-40/+100
LORD 7550A	LORD 7550C	1:1	Cristal clear liquid	3-5	45	14-16	48	130	-40/+100
LORD 7555A	LORD 7555C	1:1	Bright white non sag paste	3-5	45	14-16	41	200	-40/+100
LORD 7556A	LORD 7556B	1:1	Translucent non sag paste	3-5	45	14-16	52	160	-40/+100
	LORD 7556C	1:1	Translucent non sag paste	10-15	60	14-16	52	220	-40/+100
<b>URETHANE (One-Component)</b>									
LORD 7411	-	-	Blue paste			25-30		380	-40/+100
LORD 7412	-	-	Wax like paste			25-30		380	-40/+100
LORD 7420	-	-	Blue liquid			25-30		360	-40/+100
LORD 7421	-	-	Green gray liquid			25-30		360	-40/+100
LORD 7650	-	-	Honey liquid			Substrate tear <sup>c</sup>			-40/+100

<sup>a</sup> Typical cohesive strength <sup>b</sup> Elongation at break <sup>c</sup> Peel test

Please note: For comprehensive product selection assistance, please contact the LORD® Customer Support Center at +49 2103 252 31 60 or at [info.europe@LORD.com](mailto:info.europe@LORD.com).