

LORD® 810/Accelerator 20GB Acrylic Adhesive

Technical Data Sheet – India/SEA only

LORD® 810/Accelerator 20GB adhesive is a two-component, acrylic-based adhesive that creates a highly flexible adhesive system for bonding metals and engineered plastics. This structural adhesive system can also be used for solar bonding applications.

LORD 810/20GB adhesive delivers fast cure speed and strong bonding with minimal bondline read-through (BLRT). LORD Accelerator 20GB allows precise control of the adhesive bondline thickness due to its content of glass beads.

Features and Benefits:

Versatile – bonds metals, such as aluminum, galvanized steel and CRS, as well as engineered plastics, such as PC, ABS, acrylic, PVC and composites (FRP, SMC); low-exotherm adhesive system can be used for solar rooftop applications such as bonding metal brackets, short rails, long rails, walkways, cable trays and lightening arresters to a metal roof.

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; cures quickly even in low temperatures.

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

Temperature Resistant – performs at temperatures from -40°C to +149°C (-40°F to +300°F).

Note: Based on test results, LORD 810/20GB adhesive system exhibits post bake/powder coating temperature resistance up to 204°C (400°F) for 90 minutes. Customer specific substrates should always be evaluated for specific application performance.

Environmentally Resistant – resists dilute acids, alkalis, solvents, greases, oils and moisture; provides excellent resistance to indirect UV exposure and weathering; withstands high wind pressure for solar applications.

Application:

Surface Preparation – Remove grease, loose contamination or poorly adhering oxides from metal surfaces. Clean bondline area using a dry rag wipe or solvent wipe (MEK, IPA or acetone). 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 810 adhesive with LORD Accelerator 20GB 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 Parker LORD representative if assistance is needed using this equipment.

Recommended bondline thickness is 10 mil (0.25 mm) for optimal bonding performance and less than 20 mil (0.50 mm) for minimal bondline read-through.

Curing – Initial cure (60-70% of final strength) is achieved after one hour at 30-35°C (86-95°F). Panel installation can be done one hour after adhesive application.

Typical Properties*

	810	Accelerator 20GB
Appearance	Black Paste	Off-white Paste
Viscosity, cP @ 25°C (77°F) Brookfield	40,000 - 130,000	150,000 - 400,000
Density kg/m ³ (lb/gal)	935 - 970 (7.8 - 8.1)	1640 - 1700 (13.7 - 14.2)
Flash Point, °C (°F)	15 (59)	>93 (>200)

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

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 [$<66^{\circ}\text{C}$ ($<150^{\circ}\text{F}$)]. Customer should evaluate adhesive strength and quality through a functional trial of their intended application process. Consult with Parker LORD application engineer for recommended maximum temperature dependent on chosen adhesive cure speed.

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 204°C (400°F) 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 one year when stored below 25°C (77°F) in original, unopened container. Storage temperatures of 4 – 15°C (40 – 60°F) are recommended. If stored cold, allow product to return to room temperature before using. Protect from exposure to direct sunlight.

After dispensing product from cartridge, remove the mixing tip immediately and install supplied cartridge plugs to avoid cured adhesive from plugging cartridge.

LORD 810 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 Accelerator

Mix Ratio, Adhesive to Accelerator	
by Weight	1.1:1
by Volume	2:1
Working Time, minutes @ 21°C (70°F)	8
Time to Handling Strength, minutes @ 30 – 35°C (86 – 95°F)	15
Mixed Appearance	Dark Grey Paste
Cured Appearance	Dark Grey

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

Typical Cured Properties**

Hardness Shore D	40
Tensile Strength at Break, psi (MPa)	841 (5.8)
Elongation, %	190
Glass Transition Temperature (T_g), $^{\circ}\text{C}$ ($^{\circ}\text{F}$)	43 (109)

**Data obtained using LORD 810/20GB cured for 24 hours at room temperature. Data is typical and not to be used for specification purposes.

Typical Post-Baked Properties†

Hardness Shore D	69
Tensile Strength at Break, psi (MPa)	2088 (14.4)
Elongation, %	22
Glass Transition Temperature (T_g), $^{\circ}\text{C}$ ($^{\circ}\text{F}$)	58 (136)

† Data obtained using LORD 810/20GB cured for 24 hours at room temperature then baked at 60°C (140°F) for 500 hours. Data is typical and not to be used for specification purposes.

Values stated in this document 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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**Parker Lord
Engineered Materials Group**

111 LORD Drive
Cary, NC 27511-7923
USA

www.Parker.com/APS

**Lord India Pvt. Ltd.
India Head Office**

A/401-404, 215-Atrium Chakala
Andheri-Kurla Road Andheri (E)
Mumbai – 400 093, India
Tel: +91 22 6131 6500
Fax: +91 22 6131 6536
Email: ParkerLord.indiasupport@parker.com