

# LORD® Sign Assembly Adhesives



## Metal Bonding Adhesives

Technical Data reported at 70-77°F (21-25°C).

Product	Features	Applications	Technical Data							Accessories		
			Work Time	Handling Time	Full Cure	Mix Ratio	Color	Size	Part #	Dispensing Gun	Mixing Tip	Plunger
<b>LORD Signlok 403</b> Fast	Right-Sized Packaging Powder Coating* Extended Shelf Life	Replace Welding and Mechanical Fastening Channel Letter Assembly Metal Box Frame Assembly	2-4 min	4-6 min	24 hr	2:1	Tan	225 mL	3024187	3029124 3001129	3001173	
<b>LORD Signlok 406</b> Medium	Glass Beads for Precision Bondline UV & Corrosion Resistance for Outdoor Assemblies Minimal Surface Preparation	Corner Key Installation Bond and Seal in One Step Seal for Light Leaks	6-10 min	12-17 min	24 hr	2:1	Tan	225 mL	3024186	3029124 3001129	3001173	
<b>LORD Signlok 810</b> Medium	Low Read-Through Powder Coating* Right-Sized Packaging Extended Shelf Life Glass Beads for Precision Bondline UV Resistant	ACM Panel Bonding Thin Gauge Material Bonding Glossy Material Bonding Flexible Material Bonding	8-12 min	20-25 min	24 hr	2:1	Grey	225 mL	3024307	3029124 3001129	3001173	
<b>LORD Signlok 204</b> Fast	Right-Sized Packaging Limited Cold Impact Resistance Limited High Impact Resistance	Replace Welding and Mechanical Fastening	4-6 min	22-26 min	24 hr	2:1	Tan	225 mL	3028420	3029124 3001129	3001173	
<b>LORD 403/19</b> Fast		Replace Welding and Mechanical Fastening	2-4 min	4-6 min	24 hr	4:1	Tan	50 mL CX (404 mL)	3021003 3021004	3001112 3004487	3004476 3001179	3004479 N/A (4:1)
<b>LORD 406/19</b> Medium	Powder Coating* UV & Corrosion Resistance for Outdoor Assemblies Minimal Surface Preparation	Channel Letter Assembly Metal Box Frame Assembly Corner Key Installation Bond and Seal in One Step Seal of Light Leaks	6-10 min	12-17 min	24 hr	4:1	Tan	50 mL 375 mL CX (404 mL)	3021024 3020514 3021011	3001112 3004857 3004487	3004476 3004657 3001179	3004479 N/A (4:1) N/A (4:1)
<b>LORD 410/19</b> Slow			20-30 min	1-2 hr	24 hr	4:1	Tan	CX (404 mL)	3021027	3004487	3001179	
<b>LORD 201</b> Indefinite Open Time, Fast Cure	No-Mix Brush on Lower Viscosity Flowable	Laminating (Full Surface Coverage) Assembly of Large Surfaces & Surfaces with Tight Tolerances	5-8 min	12-16 min	24 hr	Per Application	Off-white	1/10 gal/ cart pail	3003489 3003492			
<b>LORD 204</b> Indefinite Open Time, Fast Cure	No-Mix Trowel on High Viscosity Non-sag	Laminating (Full Surface Coverage) Metal Fabrication Assembly of Large Surfaces & Surfaces with Tight Tolerances	6-8 min	20-30 min	24 hr	Per Application	Off-white	1/10 gal/ cart	3003505			
<b>LORD Accelerator 4</b>	No-Mix Catalyst for LORD 201 & 204	Laminating with LORD 201 & 204	N/A	N/A	N/A	Per Application	Clear (Dries Crystalline)	1 oz 1 qt 1 gal	3004031 3004033 3004032			
<b>LORD 7610DTM</b> Slow	Single-Component Easy to Use Bonds to Wide Variety of Materials UV Resistant	General Purpose Adhesive & Seam Sealer Seals Light Leaks Sealer for Channel Letter Cans Water Intrusion Barrier or Sealant	25-35 min	6-12 hr	1-5 days	1 Part	Bright White	1/10 gal/ cart	3029094	3023577		

\*Refer to complete instructions for Powder Coating after Bonding with LORD Acrylic Adhesives (TT3068).

## Plastic Bonding Adhesives

Technical Data reported at 70-77°F (21-25°C).

Product	Features	Applications	Technical Data							Accessories		
			Work Time	Handling Time	Full Cure	Mix Ratio	Color	Size	Part #	Dispensing Gun	Mixing Tip	Plunger
<b>LORD 7550 A/C</b> Fast	Optically Clear Adhesive for Non-Structural Assemblies UV Resistant Self-leveling	Trimcap Letter Track Aesthetic Assemblies Potting, Encapsulation	3-5 min	1 hr	72 hr	1:1	Optically Clear	50 mL	3003953	3001112	3004476	3009588
<b>LORD 7542 A/B</b> Medium	Bonds plastics, FRP & SMC with Minimal Surface Prep Odorless Non-flammable	Bonding Plastics Bonding Foam, Foam Board, Natural Materials Cross Bonding** Metal to Engineered Plastics for Larger, Outdoor Assemblies subject to Thermal Expansion	4-7 min	1-2 hr	24 hr	1:1	Brown	50 mL	3003884	3001112	3004476	3009588
<b>LORD 7556 A/B</b> Fast	Translucent Adhesive for Wide Range of Plastics, Polycarbonate and Prefinished Metals Non-sag Fast Set Non-yellowing	Aesthetic Assemblies Decorative Parts	3-5 min	1 hr	24hr	1:1	Translucent	50 mL	3003962	3001112	3004476	3009588

\*\*Refer to cross bonding chart for specific materials.

## Cross Bonding Adhesives

Technical Data reported at 70-77°F (21-25°C).

Product	Features	Applications	Technical Data							Accessories		
			Work Time	Handling Time	Full Cure	Mix Ratio	Color	Size	Part #	Dispensing Gun	Mixing Tip	Plunger
<b>LORD Signlok 810</b> Medium	Flexible UV Resistant Bonds to Bare Metal	Cross Bonding** Metal to Engineered Plastics for Larger, Outdoor Assemblies subject to Thermal Expansion	8-12 min	20-25 min	24 hr	2:1	Grey	225 mL	3024307	3029124 3001129	3001173	
<b>LORD 7542 A/B</b> Medium	Bonds plastics, FRP & SMC with Minimal Surface Prep Odorless Non-flammable	Cross Bonding** Prefinished Metals to Engineered Plastics for Larger, Outdoor Assemblies	4-7 min	1-2 hr	24 hr	1:1	Brown	50 mL	3003884	3001112	3004476	3009588
<b>LORD 7610DTM</b> Slow	Single-Component Easy to Use Bonds to Wide Variety of Materials UV Resistant	General Purpose Adhesive & Seam Sealer Seals Light Leaks Sealer for Channel Letter Cans Water Intrusion Barrier or Sealant	25-35 min	6-12 hr	1-5 days	1 Part	Bright White	1/10 gal/ cart	3029094	3023577	3015312	

\*\*Refer to cross bonding chart for specific materials.

## Specialty Adhesives/Surface Modifier

Technical Data reported at 70-77°F (21-25°C).

Product	Features	Applications	Technical Data							Accessories		
			Work Time	Handling Time	Full Cure	Mix Ratio	Color	Size	Part #	Dispensing Gun	Mixing Tip	Plunger
<b>LORD 7610DTM</b> Slow	Single-Component Paintable Easy to Use Bonds to Wide Variety of Materials UV Resistant	General Purpose Adhesive & Seam Sealer Seals Light Leaks Sealer for Channel Letter Cans Water Intrusion Barrier or Sealant	25-35 min	6-12 hr	1-5 days	1 Part	Bright White	1/10 gal/ cart	3029094	3023577	3015312	
<b>LORD 7650</b> Slow	Single-Component High Tack Low Viscosity	Laminating Foam & Paper Board	15-30 min	24 hr	1-5 days	1 Part	Honey	1/2 pt 1 gal	3003977 3003978			
<b>LORD 320/322</b> Slow	Rubber Toughened Heat Resistant High Strength	Studs Bolting Concrete Potting Gap Filling	20-40 min	2-4 hr	24 hr	1:1	Grey	50 mL	3003632	3001112	3004476	3009588
<b>LORD 360</b> Fast	Fast Cure at Room Temperature Non-Sag on Vertical Surfaces	Studs Bolting to Concrete & Foam	2-4 min	5-10 min	24 hr	1:1	Tan	50 mL	3003643	3001112	3004476	3009588
<b>LORD AP-134</b> Surface Modifier	One-coat adhesion enhancer/surface modifier	Promotes adhesion to glass, polished stone, tile, ceramic	Hydrolyze in moist air 1-2 hr @ 70-90°F (21-32°C) prior to adhesive application			1 part	Slight Yellow	4 oz 1 gal	3004048 3004049			



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# Cross Bonding with LORD Sign Assembly Adhesives

	Trade Name ‡	Surface Preparation	Aluminum/Steel*	Prefinished Metal & Aluminum Composite Material (ACM)	Polycarbonate*	Acrylic*	Urethane Foam	PVC Foam Board	Ceramic/Stone	Wood
<b>Aluminum/Steel*</b>		Solvent wipe with isopropyl alcohol	Signlok 4xx Signlok 810 Signlok 204 4xx/19 2xx	Signlok 4xx Signlok 810 4xx/19	Contact LORD	Contact LORD	7610DTM** 7542**	Signlok 4XX Signlok 810 4xx/19	320/322 †	7610DTM 320/322 †
<b>Stainless Steel</b>		Solvent wipe with isopropyl alcohol, mechanically abrade with 80-grit paper or grinder, wipe with IPA to remove sanding dust	Signlok 4xx Signlok 810 Signlok 204 4xx/19 2xx	Signlok 4xx Signlok 810 4xx/19	Contact LORD	Contact LORD	7610DTM** 7542**	Signlok 4xx Signlok 810 4xx/19	320/322 †	7610DTM 320/322 †
<b>Prefinished Metal &amp; Aluminum Composite Material (ACM)</b>	AlumaCorr™ NuAlum™ Poly-Metal™ Alumalite™ DiBond® Econolite™ MAXX™ Alucobond® Anodized Alucobond®	Factory painted metal or ACM panels: solvent wipe Shop painted or other finishes: remove by sanding prior to bonding	Signlok 4xx Signlok 810 4xx/19	Signlok 810 Signlok 4xx 4xx/19	Signlok 4xx 4xx/19 7542 7610DTM	7542 7610DTM <sup>n</sup>	7542 7650 7610DTM	Signlok 4xx Signlok 810 4xx/19 7542 7650 7610DTM	320/322 †	7542 7650 7610DTM
<b>Polycarbonate*</b>	Lexan® Tuffak®	Solvent wipe with isopropyl alcohol	Contact LORD	7542 7610DTM	Signlok 4xx 4xx/19 7542 7610DTM	7542 7610DTM	7542 7650 7610DTM	7542 7650 7610DTM	7610DTM <sup>n</sup>	7542 7650 7610DTM
<b>Acrylic*</b>	Acrylite® Acrysteel® IGP Duraplex® Optix®SG Implex® Plexiglas®G	Scuff with scuff pad or 120-grit paper, solvent wipe with isopropyl alcohol	Contact LORD	7542 7610DTM 7650	7542 7610DTM 7550 <sup>n</sup> 7556	7542 7610DTM	7542 7610DTM 7550 <sup>n</sup> 7556	7542 7650 7610DTM	7610DTM <sup>n</sup>	7542 7650 7610DTM
<b>TrimCap</b>	Jewelite® SignATrim™	Scuff with scuff pad or 120-grit paper, solvent wipe with isopropyl alcohol	N/A	7550 <sup>n</sup> 7542 7556	7550 <sup>n</sup> 7556	7550 <sup>n</sup> 7556	7542 7550 <sup>n</sup> 7556 7610DTM	7542 7650 7610DTM		7542 7550 <sup>n</sup> 7556
<b>Urethane Foam</b>	Precision Board Last-A-Foam® Sign Foam 3® Design Board® CORAFOAM®	Blow off surface with clean air or wipe with clean dry cloth	7650 7610DTM 7542	7542 7650 7610DTM	7542 7650 7610DTM	7542 7650 7610DTM	7542 7610DTM	7542 7650 7610DTM	7542 7610DTM	7542 7650 7610DTM
<b>PVC Foam Board</b>	Komatex® Sintra®	Scuff with scuff pad or 120-grit paper, solvent wipe with isopropyl alcohol	Signlok 4xx Signlok 810 4xx/19	Signlok 4xx Signlok 810 4xx/19	7542 7650 7610DTM	7452 7650 7610DTM	7542 7610DTM	Signlok 4xx 4xx/19 7542 7650 7610DTM	7542 7610DTM <sup>n</sup>	7542 7650 7610DTM
<b>Paper/Foam Board</b>	Foam-X® Recovery Foam-Cor®	Wipe with clean dry cloth	7542** 7610DTM 7650**	7542 7650	7542 7610DTM	7542	7542 7610DTM	7542 7610DTM	7542 7610DTM	7542 7610DTM
<b>PETG Sheet</b>	Spectar™ PETG	Solvent wipe with isopropyl alcohol	7542** Signlok 4xx Signlok 810 4xx/19	7542** Signlok 4xx Signlok 810 4xx/19	7542 7610DTM	7542	7542 7610DTM	7542 7610DTM	7542 7610DTM	7542 7610DTM
<b>Polystyrene Foam Board</b>	Gatorfoam® Gatorblanks® Gatorplast® Ultra	Wipe with clean dry cloth Solvent wipe with isopropyl alcohol	Signlok 4xx (N/A Gatorblanks®) Signlok 810 (N/A Gatorblanks®) 4xx/19 (N/A Gatorblanks®) 7542** 7610DTM 7650**	Signlok 4xx Signlok 810 4xx/19 7542 7610DTM 7650	7542 7550 <sup>n</sup> 7556	7542 7610DTM 7650	7542 7610DTM 7650	7542 7610DTM	7542 7610DTM	7542 7610DTM
<b>Vinyl Laminate</b>	White-Wood® Maxx-Board®	Wipe with clean dry cloth, scuff Solvent wipe with isopropyl alcohol	Signlok 4xx Signlok 810 4xx/19 7542** 7610DTM 7650	Signlok 4xx Signlok 810 4xx/19 7542** 7610DTM 7650	7542 7650	7542	7542 7610DTM 7650	7542 7610DTM	7542 7610DTM	7542 7610DTM
<b>Wood</b>		Wipe with clean dry cloth	320/322 †	7542 320/322 † 7650	7542 7650 7610DTM	7542 7650 7610DTM	7542 7610DTM	7542 7650 7610DTM	7542 7610DTM <sup>n</sup> 320/322	7542 320/322 7610DTM 7650
<b>Ceramic/Stone</b>		Porous: Wipe with clean dry cloth Non-porous (Smooth/polished): LORD AP-134 Adhesion Enhancer/Surface Modifier required	320/322 †	320/322 †	7542 7610DTM <sup>n</sup>	7542 7610DTM <sup>n</sup>	7542 7610DTM <sup>n</sup>	7610DTM <sup>n</sup>	320/322	7542 7610DTM <sup>n</sup>
<b>Cured Concrete</b>		Wipe with clean dry cloth	7610DTM 320/322 †	320/322 † 360 7610DTM	7542 7610DTM	7542 7610DTM			320/322	7610DTM 320/322
<b>Glass**</b>		LORD AP-134 Adhesion Enhancer/Surface Modifier required	Signlok 4xx 4xx/19	Signlok 4xx 4xx/19 7542		7542 7610DTM	7610DTM	7610DTM	7542 7610DTM	7542 7610DTM

xx Represents numbers for the family of adhesive to be utilized. Contact LORD Customer Support Center, 877 ASK LORD (275 5673).

‡ All substrate Trade Names are trademarks or registered trademarks of the substrate supplier.

\* Coefficient of thermal expansion is a major consideration when cross-bonding these substrates. Acrylic adhesives should not be used to attach large thermoplastic parts due to the differences in thermal expansion.

\*\* Additional surface preparation recommended: Metals should be painted or primed. Glass, Ceramic and Stone should be primed with LORD AP-134 Adhesion Enhancer/Surface Modifier to promote adhesion, 120 minutes to hydrolyze.

† Prepare metal by scuffing/abrading followed by a solvent wipe.

<sup>n</sup> For non-structural bonding (assemblies where adhesive is used for aesthetic attachment in minimum stress areas).



Signlok 403, Signlok 406, Signlok 810, Signlok 204, LORD 4xx/19 and LORD 7542 are UL recognized.

Each substrate and adhesive should be tested for the specific use in which it will be expected to perform. The information reported here is from laboratory studies and is intended only to provide general information regarding the ability of material to be bonded with LORD® Structural Adhesives.

## Dispensing Equipment

<b>Container Size</b>	225 mL	50 mL	CX (404 mL)	375 mL	LORD 7610DTM Cartridge
<b>Manual Dispensing Gun</b>	3029124	3001112	3004487	3004857	3018079
<b>Plunger (2:1)</b>	–	3009588 (one 1:1/2:1 plunger ships with gun)	–	–	–
<b>Plunger (4:1)</b>	–	3004479*	–	–	–
<b>Pneumatic Dispensing Gun</b>	3001129	–	–	3004856	–
<b>Mixing Tip</b>	3001173	3004476	3001179	3004657	Nozzle= 3015312

\*4:1 plunger required for LORD 400 Series 50 mL cartridges.



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