

LORD® 7650 Urethane Adhesive

Description

LORD® 7650 adhesive is a single-component, moisture-cure urethane adhesive designed to initially adhere similar to a contact adhesive, however permanently cross-link once cure develops.

LORD 7650 adhesive adheres to open cell polyethylene foam, styrofoam, urethane foam, plastic, fabric, rubber and prepared metal. Typical applications include gaskets, tank linings, automobile interiors, carpeting, construction panels and flooring.

Features and Benefits

Easy to Use – provides high initial tack and green strength.

Durable – provides good impact resistance.

Versatile – bonds a wide variety of substrates.

Environmentally Resistant – provides good resistance to water and chemicals.

Convenient – requires no mixing; provides working time of 15-30 minutes; requires no ovens or other heat sources for curing.

Application

Surface Preparation – Surfaces should be free of grease, dirt and other contaminants. For plastics, clean the surface with a dry rag wipe or a rag dampened with solvent. For metals, prime or grit blast the surface, then solvent wash for optimum bond performance.

When bonding cured rubber, allow LORD 7701 adhesion enhancer/surface modifier to flash off before applying LORD 7650 adhesive.

Applying – Apply LORD 7650 adhesive by roll coat, spray, brush or flow coat methods. Unlike contact adhesive, applying the adhesive to one side of the substrate is sufficient.

Curing – Handling strength is achieved after a 15-30 minute solvent flash. Complete cure will take 1-5 days depending on substrate being bonded and relative humidity.

Typical Properties*

| | |
|--|------------------------------------|
| Appearance | Honey Liquid |
| Viscosity, cP Brookfield LVT Spindle 2, 12 rpm | 400-2000 |
| Density lb/gal (kg/m ³) | 7.8-8.4 (935-1007) |
| Solids Content by Weight, % | 61-66 |
| Flash Point (Seta), °F (°C) | 26 (3) |
| Solvents | Methyl Ethyl Ketone (MEK), Toluene |

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

LORD TECHNICAL DATA

Shelf Life/Storage

Shelf life is six months from date of shipment when stored in a clean, dry environment at 70-80°F (21-27°C) in original, unopened container.

After opening, protect adhesive from excessive exposure to moisture by installing desiccant cartridges and/or using dry nitrogen as an inert cover.

Cautionary Information

Before using this or any LORD product, refer to the Material Safety Data Sheet (MSDS) 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 Bond Strengths**

| Substrates | Bond Strength, pli |
|--|---------------------------|
| Polyethylene Foam to Aluminum and Steel | 15-18 Foam Tear |
| Vinyl to Foam | 5-8 Foam Tear |
| Vinyl to Aluminum | 30-35 |
| Rubber to Metal | 15-20 Thin Rubber Tear |
| Styrofoam to Epoxy Primed Galvanized Steel | 15-20 Foam Tear |
| Rubber to Concrete | 14-17 Rubber Tear |

*Data is typical and not to be used for specification purposes.
Based on 48 hr cure and 50% RH.

Values stated in this technical data sheet 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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