LORD® MAXLOK™ MX/T3S, MX/T6S AND MX/T18S ACRYLIC ADHESIVES

LORD® Maxlok™ MX/T3S, MX/T6S and MX/T18S acrylic adhesives replace welding, brazing, riveting and other mechanical fastening methods especially over a wide range of temperature environments subject to high impact or high peel loads.

Features & Benefits

- **Versatile:** bonds a wide range of unprepared metals with minimal substrate preparation.
- **Temperature Resistant:** performs at temperatures from -40°F to +300°F (-40°C to +149°C).
- **Environmentally Resistant:** resists dilute acids, alkalis, solvents, greases, oils, moisture, salt spray and weathering; provides excellent resistance to indirect UV exposure.
- **Precise Bondline:** allows precise control of adhesive bondline thickness due to its content of glass beads, 0.01" (0.025 cm) diameter.
- **Non-Sag:** remains in position when applied on vertical or overhead surfaces, allowing for greater process flexibility.

Product	Part #	Size	Ratio	Manual Dispensing Gun	Pneumatic Dispensing Gun	Mixing Tip (12)	Plunger
LORD Maxlok T3S Acyrlic Adhesive with MX Accelerator (MX/T3S)	3031981	415 mL	4:1	3018302	3032023	3032007	–
LORD Maxlok T6S Acyrlic Adhesive with MX Accelerator (MX/T6S)	3019632	50 mL	4:1	3001112	–	3031281	3031906
	3032002	415 mL	4:1	3018302	3032023	3032007	–
LORD Maxlok T18S Acyrlic Adhesive with MX Accelerator (MX/T18S)	3032005	415 mL	4:1	3018302	3032023	3032007	–

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Application

Surface Preparation: Remove grease, loose contamination or poorly adhering oxides from metal surfaces. 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 Maxlok adhesive with the proper amount of Maxlok MX accelerator. Handheld cartridges will automatically dispense the correct volumetric ratio of each component. Even color distribution visually indicates a thorough mix. Once mixed, the adhesive cures rapidly.

Typical Properties* of Resin Mixed with Curative

	MX/T3S	MX/T6S	MX/T18S
Mix Ratio by Volume, Accelerator to Adhesive	1:4	1:4	1:4
Solids Content, %	100	100	100
Working Time, minutes @ 77°F (25°C)	3-5	6-9	18-24
Time to Handling Strength, minutes @ 77°F (25°C)	6-8	20-24	48-72
Mixed Appearance	Grey Paste	Grey Paste	Grey Paste
Tensile Strength at Break, psi (MPa)	2800 (19.3)	2800 (19.3)	2800 (19.3)

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

Metal Bond Performance**

	Aluminum to Aluminum	HDG to HDG	EZG to EZG
Lap Shear @ Room Temperature, psi (MPa)	2760 (19)	2410 (16.6)	2190 (15.1)
Failure Mode	C	C	C
T-Peel, pli (N/mm)	41 (7.2)	53 (9.3)	54 (9.5)
Failure Mode	C	C	C

Failure Mode Definition
Adhesive Failure (A)
Cohesive Failure (C)

**Bond performance data was obtained using LORD Maxlok MX/T6S adhesive. Please contact Parker Lord regarding the use and/or performance of using other adhesive/accelerator combinations.

Plastic/Composite Bond Performance**

	ABS to ABS	HDG to HDG
Lap Shear @ Room Temperature, psi (MPa)	520 (3.6)	1280 (8.8)
Failure Mode	SB	FT

Failure Mode Definition
Fiber Tear (FT)
Stock Break (SB)

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