



LORD® STRUCTURAL ADHESIVES FOR UTILITY AND CLASS EIGHT TRAILERS

Selector Guide

APPLICATIONS FOR SERVICE WORK TRUCKS

LORD® Structural Adhesives provide trailer manufacturers with improved aesthetics and increased throughput with overall cost savings. Our adhesives provide improved quality and an overall improvement in strength and durability, while reducing costs and cycle times. Unlike rivets, our engineered solutions deliver enhanced interior and exterior aesthetics tailored to meet your demanding manufacturing needs. Our proven solutions have supported the transportation market for 40 years!



1 Sidewall Bonding:

Fiberglass Reinforced Plywood,
Aluminum and Galvanized

2 Roof Bonding:

Fiberglass Reinforced Plywood,
Aluminum, Galvanized and Composites

3 Front Panel Bonding:

Fiberglass Reinforced Plywood,
Aluminum and Galvanized

4 Bonded HVAC Units:

Fiberglass Reinforced Plywood,
Aluminum and Galvanized



PRODUCT SELECTION

PRODUCT		SUBSTRATES						TYPICAL PROPERTIES*					
		Bare Metal	Composite	Painted Metal	Plastics	Cross Bonding	Specialty	Work Time @ 75°F (24°C)	Mix Ratio by Volume, Adhesive to Accelerator	Time to Handling Strength @ 75°F (24°C)	Accelerator(s)	Mixed Appearance	Attributes
LORD® 7800 FAST-CURE URETHANE ADHESIVE	A/C		✓	✓	✓	✓	✓	3 min.	1:1	12 min.	N/A	Black	• 2x Faster Processing Time • Equal Mix Ratio • Sag Resistance • No Odor
	A/D							6 min.	1:1	25 min.			
LORD® 7542 URETHANE ADHESIVE	A/B ^{UL}		✓	✓	✓	✓	✓	4-7 min.	1:1	1-2 hr.	N/A	Varies** (Black or Brown)	• Structural Bonding • Lower Viscosity for Easy Dispensing • Non Flammable
	A/C ^{UL}							11-15 min	1:1	2 hr.			
	A/D ^{UL}							20-30 min.	1:1	3 hr.			
LORD® 7545 URETHANE ADHESIVE	A/G							1.5 min.	1:1	10 min.	N/A	Varies** (Off-white or Black)	• Bonds FRP, SMC, Plastics and Prepared Metals • Non-sag • Non Flammable
	A/B							3-5 min.	1:1	30 min.			
	A/C		✓	✓	✓	✓	✓	6-8 min.	1:1	60 min.			
	A/D							11-18 min.	1:1	90 min.			
	A/E							22-38 min.	1:1	2-3 hr.			
	A/F							45-65 min.	1:1	4-5 hr.			
LORD® 7555 URETHANE ADHESIVE/ SEALANT	A/C		✓	✓	✓	✓	✓	3-5 min. @ 77°F (25°C)	1:1	1 hr. @ 77°F (25°C)	N/A	White Paste	• Bonds & Seals Plastics and Prepared Metals • Non-sag, non-yellowing • Paint & Finish Immediately
	A/E							45 min. @ 77°F (25°C)	1:1	5-6 hr. @ 77°F (25°C)			
LORD® 7610DTM DIRECT-TO-METAL ADHESIVE/SEALANT		✓	✓	✓	✓	✓	✓	25-35 min. @ 77°F (25°C)	N/A	6-12 hr. @ 77°F (25°C)	N/A	White Paste	• Single Component • No Mix • UV Resistant
LORD® ACRYLIC ADHESIVE WITH ACCELERATOR 19	403 ^{UL}							2-4 min.	4:1	4-6 min.	19, 19 Black, 19GB, 19GB Grey	Tan Paste**	• Easy to Dispense • Withstands E-Coat & Powder Coat • Cold Impact
	406 ^{UL}	✓	✓	✓	✓	✓		6-10 min.	4:1	12-17 min.			
	410 ^{UL}							20-30 min.	4:1	60-120 min.			
LORD® 810S LOW READ-THROUGH (LRT) ACRYLIC ADHESIVE WITH LORD ACCELERATOR 20GB		✓	✓	✓	✓	✓		8-12 min. @ 70°F (21°C)	2:1	20-25 min. @ 70°F (21°C)	20GB	Dark Grey Paste	• Ideal for Thin, Glossy and ACM Materials • Withstands E-Coat & Powder Coat
LORD® ACRYLIC ADHESIVE WITH LORD ACCELERATOR 25GB	850S (FAST)	✓	✓	✓	✓	✓		6-10 min.	10:1	18-24 min.	25GB	Red Paste	• Toughened • High Impact • Fatigue Resistant • Low Temp Environment • Withstands E-Coat & Powder Coat
	852S (SLOW)							20-25 min.	10:1	50-70 min.			
MAXLOK® ACRYLIC ADHESIVE WITH MX ACCELERATOR	T3S							3-5 min. @ 77°F (25°C)	4:1	6-8 min. @ 77°F (25°C)	MX	Grey Paste	• Bondline Control • Glass Beads • High Impact • High Peel • Withstands E-Coat & Powder Coat
	T6S	✓	✓	✓	✓	✓		6-9 min. @ 77°F (25°C)	4:1	20-24 min. @ 77°F (25°C)			
	T18S							18-24 min. @ 77°F (25°C)	4:1	48-72 min. @ 77°F (25°C)			

Refer to LORD Structural Adhesives Guide for full product information.

Refer to LORD UL-Approved Adhesives for Sign and Electrical Enclosure Bonding for listing of specific UL-Approved products.

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

**Mixed appearance will vary based on accelerator/curative used.

ADHESIVE COVERAGE/ VOLUME ESTIMATING TABLES

Linear Feet (m) Bead Diameter Coverage in Cartridge

Use the table below to determine the length of adhesive bead that can be obtained from a cartridge of adhesive.

LINEAR FEET (m) OF BEAD IN CARTRIDGE						
CARTRIDGE VOLUME		50 mL	200 mL	400 mL	415 mL	490 mL
BEAD DIAMETER	1/8 inch (3 mm)	20.7 (6.3)	82.5 (25.15)	165.5 (50.4)	171.5 (52.27)	203 (61.87)
	1/4 inch (6 mm)	5.1 (1.55)	20.7 (6.3)	41.4 (12.6)	43 (13.1)	50.6 (15.4)
	3/8 inch (9.5 mm)	2.3 (0.7)	9.3 (2.8)	18.41 (5.6)	19.1 (5.8)	22.5 (6.86)

Compressed Bead Thickness (Spread) – inches (mm)

Use the table below to determine the required bead diameter from the dimensions of the adhesive joint.

COMPRESSED BEAD THICKNESS (SPREAD) – inches (mm)				
THICKNESS		0.010" (0.25 mm)	0.030" (0.25 mm)	0.040" (0.25 mm)
BEAD DIAMETER	1/8 inch (3 mm)	1.25 (32)	0.41 (10)	0.3 (7.6)
	1/4 inch (6 mm)	4.9 (124.5)	1.65 (42)	1.23 (31)
	3/8 inch (9.5 mm)	11.0 (279)	3.7 (94)	2.8 (71)

Parker Lord
Engineered Materials Group
 111 LORD Drive
 Cary, NC 27511-7923
 USA
 phone +1 877 275-5673
www.parker.com/APS

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