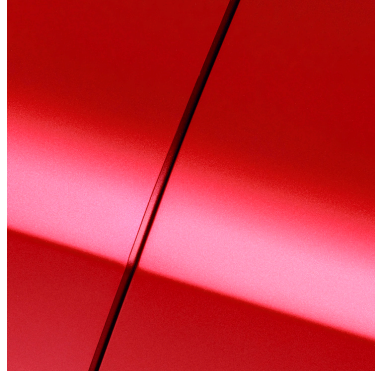




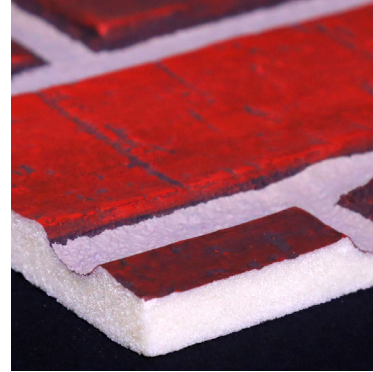
Bare Metal



ACM



Plastic



Foam









Specialty
Substrate





LORD[®] STRUCTURAL ADHESIVES FOR THE SIGN INDUSTRY

Sample Book



METAL ADHESIVES

	Signlok  400 Series	<ul style="list-style-type: none"> • Structural metal bonding adhesive to replace welding, brazing, riveting & mechanical fastening • Multiple cure speeds • Low temperature impact resistance 	<ul style="list-style-type: none"> • Performs well in high impact and high peel loads • Glass beads for precision bondline • Withstands powder coat cycles when properly fixtured
	Signlok  810S	<ul style="list-style-type: none"> • Low Read-Through (LRT) structural adhesive for bare metal and ACM panel bonding • Ideal for glossy and flexible substrates • Low exotherm, low shrinkage 	<ul style="list-style-type: none"> • Glass beads for precision bondline • Withstands powder coat cycles when properly fixtured
	LORD  400 Series	<ul style="list-style-type: none"> • Structural metal bonding adhesive to replace welding, brazing, riveting & mechanical fastening • Multiple cure speeds 	<ul style="list-style-type: none"> • Performs well in high impact and high peel loads • Withstands powder coat cycles when properly fixtured • Low temperature impact resistance

PLASTIC ADHESIVES

	LORD 7550	<ul style="list-style-type: none"> • Optically clear adhesive for non-structural assemblies • Bonds Lexan™, ABS, polycarbonate, acrylic and prefinished metals 	<ul style="list-style-type: none"> • UV resistant • Self-leveling
	Signlok 7550		
	LORD  7542	<ul style="list-style-type: none"> • Bonds plastics, FRP, SMC and prefinished metals • Minimal surface preparation 	<ul style="list-style-type: none"> • Odorless • Non-flammable
	LORD 7556	<ul style="list-style-type: none"> • Opaque adhesive for bonding Lexan™, ABS, polycarbonate and prefinished metals • Non-sag • Fast set 	

SPECIALTY ADHESIVES

	<p>LORD 7610DTM</p>	<ul style="list-style-type: none"> • General purpose adhesive/sealer • Single-component • Easy to use 	<ul style="list-style-type: none"> • Bonds wide variety of materials • UV resistant
	<p>LORD 320 / 322</p>	<ul style="list-style-type: none"> • Bond prepared metals, plastics, concrete, ceramic stone and wood • Rubber toughened 	<ul style="list-style-type: none"> • Heat resistant • High strength

Structural adhesives are engineered to form bonds that can support loads and are formulated to improve manufacturing processes and final products for a variety of composite, metal and plastic assemblies. Our Structural Adhesives replace welding, riveting and other mechanical fasteners. Their right-sized packaging fits most jobs and eliminates waste.

Signlok™ Adhesives

- UL 746C Recognized*
- 90% full cure within one hour
- Available in a range of work times accommodating a variety of process requirements
- Longer shelf life options available, reducing cost of out-of-date materials
- Glass bead options available to enable precision bondline control and manage waste

**Excluding Signlok 7550*

LORD® Adhesives

- Extensive product portfolio to address a range of applications
- Excellent chemical and environmental resistance
- Lower costs and assembly time
- Reduce waste; more accurate job estimates
- One stop shopping; address a broad range of client requirements



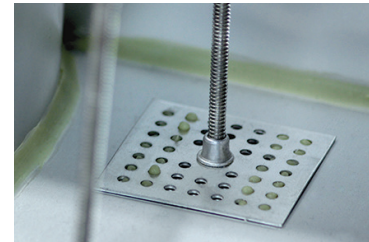
Metal Assembly



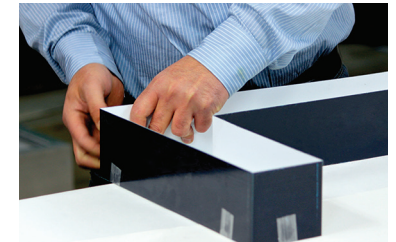
Bonding to External Surfaces



Sealing Light Leaks



Other Uses



Channel Letter Assembly

Included are samples of our product line. For custom formulation or additional products, call +1 877 275 5673 or visit Parker.com/APS for more information.

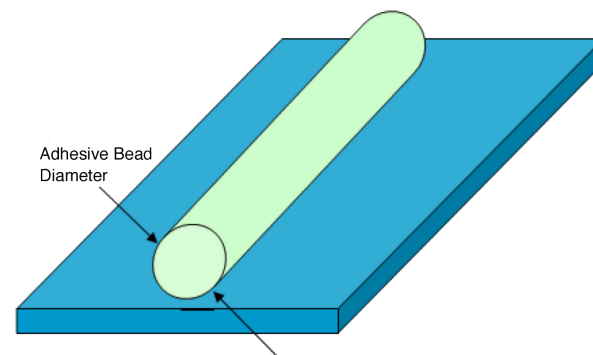
Estimating Adhesive Coverage

Apply the adhesive to the part to ensure complete adhesive coverage to the bond area. The rule of thumb is to dispense a bead with a diameter about 1/6th to 1/4th the width of the bond joint. For example, if the bond joint is 1" wide, the bead diameter should be approximately 0.17".

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	210 mL	400 mL	415 mL
BEAD DIAMETER	1/8 inch (3 mm)	20.7 (6.3)	86.6 (26.39)	165.5 (50.4)	171.5 (52.27)
	1/4 inch (6 mm)	5.1 (1.55)	21.7 (6.61)	41.4 (12.6)	43 (13.1)
	3/8 inch (9.5 mm)	2.3 (0.7)	9.7 (2.95)	18.41 (5.6)	19.1 (5.8)



Dispensing Equipment



Container Size	210 mL	50 mL	CX (404 mL)	415 mL	LORD 7610DTM Cartridge
Manual Dispensing Gun	3029937	3001112	3004487	3018302	3018079
Plunger (2:1)	–	3009588 (one plunger ships with gun)	–	–	–
Plunger (4:1)	–	3031906*	–	–	–
Pneumatic Dispensing Gun	3029936	–	–	3032023	–
Mixing Tip	3001173	3031303 (1:1); 3031281 (4:1)	3001173	3032007	Nozzle = 3015312

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