

LORD® 7542 URETHANE ADHESIVE

Technical Data Sheet

LORD® 7542 adhesive is an equal-mix, two-component urethane adhesive system used to bond FRP, SMC and other plastics with little surface preparation. This adhesive will also bond primed metals. LORD 7542 adhesive system is available in a range of working times to accommodate a wide variety of process requirements.

Features and Benefits

Non-Flammable: does not require explosion-proof equipment.

Environmentally Recommended: does not contain ozone depleting chemicals.

Environmentally Resistant: resists weathering, humidity and salt spray.

Chemically Resistant: solvent resistant when cured. Painting and most cleaning processes do not affect bond strength.

UL Approved: UL 746C certified.

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, priming or powder painting is recommended.

Mixing: Mix LORD 7542-A resin with the appropriate curative at a 1:1 ratio, by volume. Handheld cartridges will automatically dispense the correct volumetric ratio of each component. Once mixed, the adhesive cures rapidly.

Applying: Apply adhesive using handheld cartridges or automatic meter/mix/dispense equipment.

- Handheld Cartridges
 1. Load the cartridge into the applicator gun and remove the end caps.
 2. Level the plungers by expelling a small amount of material to ensure both sides are level.
 3. Attach mixing tip and expel a mixer's length of adhesive.
 4. Apply adhesive to substrate and mate the parts within the working time of the adhesive. Clamp in position until adhesive reaches handling strength.
- Meter/Mix/Dispense Equipment
Contact your Parker Lord representative if assistance is needed using this equipment.

For optimum adhesion, bondline thickness of LORD 7542 adhesive should be 10-40 mil (254-1016 micron). During use, limit the exposure of LORD 7542 adhesive containers to cold temperatures.

Curing: LORD 7542 adhesive will cure to full strength in 24 hours or less at 75°F (24°C), depending on the curative used.

Cleanup: Clean equipment and tools prior to the adhesive cure with organic solvents such as acetone or methyl ethyl ketone (MEK). Do not use alcohol. Once adhesive is cured, heat the adhesive to 300°F (149°C) or above to soften the adhesive. This allows the parts to be separated and the adhesive to be more easily removed. Some success may be achieved with commercial adhesive strippers.

Typical Properties*

	7542-A Resin	7542-B Curative	7542-C Curative	7542-D Curative
Appearance	Dark Brown Liquid	Tan or Black Liquid	Tan Liquid	Tan Liquid
Viscosity, cP @ 77°F (25°C)	1500 - 4500	7000 - 14,000	4000 - 14,000	5000 - 14,000
Density lb/gal (kg/m ³)	11.45 - 11.75 (1372 - 1408)	10.3 - 10.6 (1234 - 1270)	10.3 - 10.6 (1234 - 1270)	10.3 - 10.6 (1234 - 1270)
Flash Point, °F (°C) Closed Cup	>200 (>93)	>200 (>93)	>200 (>93)	>200 (>93)

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

Shelf Life/Storage

Shelf life is six months when stored in a clean, dry environment at 65-85°F (18-30°C) in original, unopened container. Excluding LORD 7542-B Black and 7542-C curatives, prolonged exposure to temperatures below 50°F (10°C) during shipping or storage may cause variations in cured properties and/or significant reduction in shelf life.

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 Parker Lord product, refer to the Safety Data Sheet (SDS) 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 Properties** of Resin Mixed with Curative

	7542-A/B	7542-A/C	7542-A/D
Mix Ratio by Volume, Resin to Curative	1:1	1:1	1:1
Solids Content by Weight, %	100	100	100
Working Time, minutes @ 75°F (24°C)	4 - 7	11 - 15	20 - 30
Time to Handling Strength, hours @ 75°F (24°C)	1 - 2	2	3

**Data is typical and not to be used for specification purposes. Given a 1/2 inch (12.7 mm) bead.

Typical Cured Properties*

Hardness ASTM D2240, Method A	87
Tensile Strength at Break, psi (MPa) ASTM D638	2712 (18.70)
Elongation, % ASTM D638	70
Young's Modulus, psi (MPa) ASTM D638	12,125 (83.6)
Glass Transition Temperature (Tg), °F (°C) ASTM D3418	115 (46)
Coefficient of Linear Thermal Expansion, ppm/°C ASTM E381 below Tg above Tg	69 162
Moisture Absorption, % ASTM D570	1.65
Poisson's Ratio ASTM D638	0.414

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Bond Performance*

Substrates	SMC	E-coated Steel	CFRP
Lap Shear @ Room Temperature, psi (MPa)	600 (4.10)	2600 (17.90)	3200 (22.1)
Failure Mode	SF	CF/C	FT
Lap Shear @ 180°F (82°C), psi (MPa)	200 (1.38)	1200 (8.27)	890 (6.14)
Failure Mode	–	C	C
Lap Shear @ -30°F (-34°C), psi (MPa)	820 (5.65)	3300 (22.75)	2800 (19.31)
Failure Mode	SF	CF	SF
Lap Shear after 500 hours Salt Spray Exposure, psi (MPa) Tested after 24 hours	700 (4.80)	1200 (8.27)	3244 (22.37)
Failure Mode	SF	–	SF/C
Test after 168 hours Water Immersion @ 150°F (65°C), psi (MPa)	600 (4.10)	–	3086 (21.28)
Failure Mode	SF	–	SF
Test after 500 hours Humidity Exposure, psi (MPa) 100%RH, 165°F (74°C)	640 (4.40)	3300 (22.75)	3221 (21.52)
Failure Mode	SF	–	SF/C

Substrate	Surface Treatment
Sheet Molded Compound (SMC)	IPA Rag Wipe
E-coated Steel	Dry Rag Wipe
Carbon Fiber Reinforced Plastic (CFRP)	80 Grit Scuff

Bonded Parameters	Bond Area	Film Thickness	Cure	Mix Ratio
Composite Lap Shears	1.0"x1.0"	0.030"	24 hr @ RT	1:1 by Volume
Metal Lap Shears	1.0"x0.5"	0.010"	24 hr @ RT	1:1 by Volume

Failure Mode Definition	Abbreviation
Coating Failure	CF
Cohesive Failure	C
Fiber Tear	FT
Sub Failure	SF

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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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