

LORD® AC-902 LC ADHESIVE

Technical Data Sheet

LORD® AC-902 LC adhesive is a one-component, light-curing (LC) acrylic resin used to coat, reinforce, seal or adhere to various materials. LORD AC-902 LC adhesive can be cured in seconds utilizing visible or UV light.

LORD AC-902 LC adhesive is recommended for use with the following substrates: Polycarbonate (PC), Acrylonitrile-Butadiene-Styrene (ABS), PC/ABS, Polymethyl methacrylate (PMMA), polyesters, stainless steel, nickel-plated steel, aluminum, and anodized aluminum.

Features and Benefits

Easy to Use: material can be dispensed using many different dispense systems; thixotropic viscosity allows for non-sag application on vertical surfaces. Light can be applied immediately after application or following a brief period of time if process requires.

Fast Cure: cures within 15-30 seconds under light sources ranging from 365-405 nm in wavelength; works well with UV LED light sources.

High Depth of Cure: designed for applications requiring high through cure up to 10 mm deep.

Excellent Adhesion: optimized for adherence to challenging metal substrates such as aluminum and nickel-plated steel, as well as plastic substrates such as ABS and polycarbonate.

UV Fluorescence: adhesive fluoresces under low-intensity black light, permitting in-line inspection.

Low Stress: exhibits low shrinkage after cure, providing low stress on bonded components and improving durability of the bond.

Application

Surface Preparation: Remove soil, grease, oil, fingerprints, dust, mold release agents, rust and other contaminants from the surfaces to be bonded by solvent degreasing or alkaline cleaning. Some plastics and metal surfaces may require abrasion or other surface treatments for good adhesion. On metal surfaces that are free of oxidation, use a solvent wipe. If necessary, use an abrasive material to remove tarnish. Always follow abrasion by a second cleaning to ensure removal of loose particles.

Applying: LORD AC-902 LC adhesive can be dispensed either manually or with automated equipment. Caution should be taken to shield the application area from ambient light to prevent premature curing.

Curing: Complete cure is dependent on the thickness of the applied material as well as the wavelength and intensity of the light source used. Optimum cure conditions should be determined empirically for each light source by measuring the effect of exposure time and intensity on the cured properties. Complete cure occurs when increased exposure has no further effect on the cured properties.

Typical Properties*

Appearance	Light Yellow/Green Transparent Gel
Viscosity, cP @ 25°C Brookfield Spindle S06, 20 rpm	25,000
Specific Gravity	1.03
Flash Point (Closed Cup), °C	85

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

Typical Cured Properties*

Glass Transition Temperature (T _g), °C	65
Hardness Shore A	78
Tensile Strength, MPa (psi)	38 (5511)
Young's Modulus, MPa	660
Lap Shear Strength, MPa (psi) PC to Nickel-plated Steel	15 (2176)
Volume Resistivity, ohm-cm	3.05 x 10 ¹⁵
Dielectric Strength, kV/mm (V/mil) @ 1 mm	29 (737)

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Shelf Life/Storage

Shelf life is one year from date of shipment when stored at 0-35°C in original, unopened container. Store material away from light sources.

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.

Verify Volatile Organic Compounds (VOC) requirements with the applicable local, regional and state air quality authorities before importing, selling or using this product. VOC rules, thresholds and reporting obligations vary by jurisdiction; compliance is the responsibility of the importer/seller/owner.

For industrial/commercial use only. Must be applied by trained personnel only. Not to be used in household applications. Not for consumer use.

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