

LORD® Accelerator 20GB

Technical Data Sheet

LORD® Accelerator 20GB is a mix-in curative designed for use with LORD acrylic adhesives. LORD Accelerator 20GB, when mixed with LORD 800 series acrylic adhesives, creates an adhesive system that will bond a variety of prepared or unprepared metals and plastics.

Features and Benefits:

Convenient – provides room temperature cure with all LORD acrylic adhesives.

Environmentally Recommended – contains no solvent, non-flammable and virtually odorless.

Environmentally Resistant – resists common environmental conditions when used with LORD acrylic adhesives.

Bondline Control – allows precise control of adhesive bondline thickness due to content of glass beads, 10 mil (250 µm) diameter.

Application:

Mixing – Confirm the proper mix ratio of acrylic adhesive to accelerator by consulting the appropriate LORD acrylic adhesive data sheet. Thoroughly mix the proper amount of adhesive and accelerator until uniform in color and consistency. Be careful not to whip excessive air into the adhesive system.

Heat buildup due to an exothermic reaction between the two components will shorten the working time of the adhesive. Mixing smaller quantities will minimize heat buildup.

Applying – Apply adhesive to substrate surfaces using handheld cartridges or automatic meter/mix/dispense equipment. Mate the parts within the working time of the adhesive. Clamp in position until handling strength is achieved.

Curing – Handling strength and complete cure times will vary depending on acrylic adhesive used. For cure times, refer to appropriate acrylic adhesive data sheet.

Cleanup – Clean equipment and tools prior to the adhesive cure with hot water and detergent or an organic solvent such as methyl ethyl ketone (MEK). Once adhesive is cured, heat the adhesive to 400°F (204°C) or above to soften the adhesive. This allows the parts to be separated and the adhesive to be more easily removed.

Shelf Life/Storage:

Shelf life for LORD Accelerator 20GB is nine months when stored below 77°F (25°C) in original, unopened container. Shelf life can be extended by storing at temperatures of 50-65°F (10-18°C). Temperature excursions above 95°F (35°C) for extended periods of time (days or weeks) will result in reduced shelf life, indicated by increased viscosity and/or decreased cure speed related to reduced BPO content. If stored cold, allow product to return to room temperature before using. Do not freeze product.

Typical Properties*	
Appearance	Off-white Paste
Viscosity, cP @ 77°F (25°C) Brookfield T-D 5 rpm	150,000 - 400,000
Density lb/gal (kg/m ³)	13.7 - 14.2 (1640 - 1700)
Flash Point (Seta), °F (°C)	>200 (>93)
Press Flow, seconds 80 psi @ 77°F (25°C) 0.052" (1.32 mm)	25 - 65

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



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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.

Values stated in this document represent typical values as not all tests are run on each lot of material produced. For formalized product specifications for specific product end uses, contact the Customer Support Center.

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