

LORD® 1110 A/B SYNTACTIC FOAM

Technical Data Sheet

LORD® 1110 A/B foam is a modified epoxy syntactic foam system offering long working time, very low density and high compressive strength characteristics.

Features and Benefits

Durable: provides a low weight/high strength material.

Non-Sag: renders a smooth paste when mixed; remains in position when applied, allowing for vertical application.

Room Temperature Cure: cures at room temperature providing a curing process that is not restricted to oven size.

Easy to Finish: cured material can be easily shaped by sanding, drilling or cutting.

Application

Surface Preparation: Remove all contamination and loose particles from the surfaces to be bonded. Etch aluminum alloys with sodium dichromate-sulfuric acid to obtain optimum mechanical strength.

Mixing: Thoroughly stir LORD 1110 B component before mixing with LORD 1110 A component. Mix LORD 1110 A component with LORD 1110 B component at ratio of 100:50, by weight.

Applying: Apply freshly mixed LORD 1110 foam by spatula. Foam can be injected into deep parts using a cartridge.

Curing: Allow foam to cure for 7 days at room temperature [75°F (24°C)], or for 1 hour at 250°F (121°C).

Cleanup: Before the foam sets up, clean excess foam on the bonded assembly, as well as the mixing and application equipment, with hot water and detergent or an organic solvent such as ketones. Once foam has cured, heat the material to 400°F (204°C) or above to soften foam. This allows the parts to be separated and the foam to be more easily removed.

Shelf Life/Storage

Shelf life of each component is one year when stored in a clean, dry environment at 68-86°F (20-30°C) in original, unopened containers.

Typical Properties*

	1110 A Component	1110 B Component	Mixed
Appearance	White Paste	Yellow Liquid	White Paste
Viscosity	Thixotropic	Viscous	Thixotropic
Density lb/gal (kg/m ³)	5.0 - 5.7 (600 - 680)	5.3 - 6.0 (640 - 720)	5.0 - 5.8 (600 - 700)
Working Time, minutes @ 77°F (25°C)	–	–	60

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

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 Cured Properties*

Hardness Shore D	60	
Tensile Shear Strength, psi (MPa) @ 77°F (25°C) @ -320°F (-196°C)	3100 (21.4) 2700 (18.6)	
Outgassing ASTM E595 Total Mass Loss (TML), % Collected Volatile Condensable Materials (CVCN), %	0.99 0.02	
Compressive Strength, psi (MPa) @ 77°F (25°C) @ -65°F (18°C)	6500 (44.8) Cured 7 days @ 75°F (24°C) 7000 (48.3) Cured 7 days @ 75°F (24°C)	8000 (55.2) Cured 1 hour @ 250°F (121°C) 9000 (62.1) Cured 1 hour @ 250°F (121°C)

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DS3356 OD 08/25 Rev.4

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