LORD® 201 ACRYLIC ADHESIVE WITH LORD ACCELERATOR 17 OR 19

Technical Data Sheet

LORD® 201 acrylic adhesive when cured with LORD Accelerator 17 or 19 creates an adhesive system that will bond a wide variety of prepared or unprepared metals and plastics. LORD 201 acrylic adhesive in combination with the recommended accelerator replaces welding, brazing, riveting and other mechanical fastening methods.

LORD 201 acrylic adhesive can be cured with either LORD Accelerator 17 or LORD Accelerator 19. LORD Accelerators 17 and 19 must be mixed into the acrylic adhesive prior to application. LORD Accelerator 19 is available in off-white or black. For further detailed information, refer to the applicable data sheet.

Features and Benefits

Bonds Unprepared Metals: requires little or no substrate preparation.

Versatile: bonds a wide variety of substrates such as metals, ceramics and plastics; insensitive to minor deviations from correct mix ratio.

Self-Leveling: flows into hard-to-reach places and is excellent for bonding irregular shapes.

Temperature Resistant: performs at temperatures from -40°F to +300°F (-40°C to +149°C).

Environmentally Resistant: resists dilute acids, alkalis, solvents, greases, oils and moisture; provides excellent resistance to indirect UV exposure, salt spray and weathering.

UL Approved: when mixed with LORD Accelerator 19, adhesive system is UL 746C certified.

Application

Surface Preparation: Remove grease, loose contamination or poorly adhering oxides from metal surfaces. Normal amounts of mill oils and drawing compounds usually do not present a problem in adhesion. Most plastics require a simple cleaning before bonding. Some may require abrading for optimum performance.

Mixing: Mix LORD 201 acrylic adhesive with the proper amount of LORD Accelerator 17 or 19. Handheld cartridges will automatically dispense the correct volumetric ratio of each component. Even color distribution visually indicates a thorough mix. Once mixed, the adhesive cures rapidly

Applying: Apply mixed 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. When using such equipment, all wetted parts must be made of stainless steel and all hoses should be Teflon® -lined high pressure hose.

Typical Properties*

Appearance	Off-white Liquid
Viscosity, cP @ 77°F (25°C) Brookfield HAT Spindle 6, 20 rpm	15,000 - 55,000
Density lb/gal (kg/m^3)	 8.5 - 8.7 (1019 - 1042)
Flash Point (Closed Cup), °C (°F)	65 (18)

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

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Curing: Cure begins immediately once adhesive and accelerator are mixed. Handling strength is achieved within 12-16 minutes. Complete cure will take 24 hours at room temperature. Mating surfaces should be fixtured as soon as possible (in less than five minutes) after adhesive application.

Shelf Life/Storage

Shelf life is six months when stored at temperatures below 80°F (27°C) in original, unopened container. Storage temperatures of 40-50°F (4-10°C) are recommended. If stored cold, allow product to return to room temperature before using.

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 Adhesive Mixed with Recommended Accelerator

Mix Ratio by Volume, Adhesive to Accelerator	
A17	10:1
A19 or A19 Black	10:5
Solids Content, %	100
Working Time, minutes @ 75°F (24°C)	5-8
Time to Handling Strength, minutes @ 75°F (24°C)	12-16
Mixed Appearance	
A17	Tan Paste
A19	Tan Paste
A19 Black	Grey Paste
Cured Appearance	
A17	Tan to Green
A19	Tan to Green
A19 Black	Black

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Bond Performance** – LORD 201 Adhesive/LORD Accelerator 17

Substrates	Lap Shear Strength, psi (MPa)	Failure Mode
Cold Rolled Steel		
SAE 1010	4500 (31.0)	A/C
Commercial Quality 1010	3200 (22.1)	A/C
Drawing Quality Aluminum Killed 1008	3600 (24.8)	A/C
Stainless Steel	4000 (27.6)	A/C
Galvanized Steel	1300 (9.0)	A/C
Aluminum		
6061-T6	4600 (31.7)	A/C
2014-T3	2500 (17.2)	A/C
5052-0	2000 (13.8)	A/C
Copper	3500 (24.1)	A/C
Brass SAE 72	2600 (17.9)	A/C
Titanium	3200 (22.1)	A/C
Magnesium	2000 (13.8)	A/C
SMC (Polyester)	800 (5.5)	SB
ABS	670 (4.6)	SB
Plexiglas®	900 (6.2)	SB
Noryl®	800 (5.5)	SB
Polycarbonate	1500 (10.3)	SB

Substrate	Surface Treatment
Metal	MEK Wipe
Plastic	Isopropyl Alcohol Wipe

Bonded Parameters	Overlap	Film Thickness	Cure	Mix Ratio
Metal (ASTM D1002)	1/2"	0.010"	24 hr @ RT	10:1 by Volume
Plastic	1"	0.010"	24 hr @ RT	10:1 by Volume

Failure Mode Definition	Abbreviation
Adhesive Failure	A
Cohesive Failure	C
Stock Break	SB

**Bond strength data was obtained using LORD 201 adhesive/Accelerator 17. Please contact Parker Lord regarding the use and/or performance of using other accelerator combinations.

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