

LORD® 320/324 Epoxy Adhesive

Description

LORD® 320/324 adhesive is a general purpose, two-component epoxy adhesive system formulated for primerless adhesion to automotive sheet molded compounds (SMC). This adhesive system also provides excellent adhesion to prepared metals, rubber, fiberglass reinforced plastics (FRP), polyester thermosets and thermoplastics, and many other materials. LORD 320/324 adhesive can be either room temperature cured or heat cured for faster processing.

Features and Benefits

Durable – provides load bearing properties equal to or greater than the materials being bonded; provides impact resistance down to -40°F (-40°C) and extreme durability through superior inhibition of crack propagation.

Environmentally Recommended – contains no solvent, nonflammable and virtually odorless.

Environmentally Resistant – resists humidity, sunlight, salt spray and temperature extremes.

High Temperature Resistant – resists postbakes up to 400°F (204°C).

Chemically Resistant – solvent resistant when cured; anti-corrosion processes including phosphatizing and ELPO (e-coat) coatings do not affect the adhesive or its bond strength. Continuous immersion in solvents is not recommended.

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.

On metal surfaces which are free of oxidation, use an isopropyl alcohol wipe. If necessary, use an abrasive material to remove tarnish. Always follow abrasion by a second cleaning to ensure removal of loose particles.

When bonding cured rubber, allow LORD 7701 adhesion enhancer/surface modifier to flash off before applying LORD 320/324 adhesive. Prime glass and ceramic surfaces with LORD AP-134 adhesion enhancer/surface modifier to promote adhesion.

Handle prepared surfaces carefully to avoid contamination. Assemble as soon as possible.

Typical Properties*

	320 Resin	324 Hardener
Appearance	Off-white Paste	Grey Paste
Density		
lb/gal	12.5-12.9	9.45-10.35
(kg/m ³)	(1498-1546)	(1132-1240)
Flash Point (Closed Cup), °F (°C)	>200 (>93)	>200 (>93)

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

LORD TECHNICAL DATA

Mixing – Thoroughly mix the proper amount of resin and hardener until uniform in color and consistency. Be careful not to whip excessive air into the adhesive system. Handheld cartridges will automatically dispense the correct volumetric ratio of each component.

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. Do not use any adhesive that has begun to cure.

Applying – Apply the mixed adhesive to bond surfaces using automatic meter/mix/dispense equipment or any convenient tool such as a stiff brush, spatula or trowel. Handheld cartridges or a disposable paper cone can be used to apply the adhesive in a continuous bead. For general use, a film thickness of approximately 0.02-0.03 inch (0.51-0.76 mm) is recommended. To control bondline thickness, a small amount of solid glass beads can be added into the mixed adhesive.

Join the parts in such a way as to avoid entrapped air. Apply only enough pressure to ensure good wetting of the adhesive on both surfaces. Squeezing a little adhesive out at the edges is usually a sign of proper assembly. It is not necessary to clamp the assembly unless movement during adhesive cure is likely.

Maximum adhesion will occur only with parts which mate well without the need for excessive clamping pressure during cure. Excessive clamping may squeeze too much adhesive from the bond area which can result in a poor bond.

Curing – LORD 320/324 adhesive will cure to full strength in approximately 24 hours, provided that the adhesive, substrates and ambient temperature are 65°F (18°C) or higher.

Higher temperatures will provide faster cure times; however, the bondline temperature should not exceed 325°F (162°C). When heated at 180°F (82°C), full cure strength can be obtained in 45-60 minutes. Elevated temperature cure produces the highest bond strengths and impact resistance. Firm recommendations of cure times and temperatures depend on material composition and heating methods.

Once the adhesive has cured, it can be filed, sanded, machined or otherwise handled in the same way as a light metal. Paint, lacquers, enamels and other coatings can be applied to cured adhesive.

Typical Properties* of Resin Mixed with Hardener

Mix Ratio, Resin to Hardener

General Purpose, -40 to 400°F (-40 to 204°C)

Mixed Stress Joint Design

by Volume	1:1
by Weight	1.2:1

High Temperature, 50-400°F (10-204°C)

Shear Stress Joint Design

by Volume	1.5:1
by Weight	1.8:1

Low Temperature, -40 to 100°F (-40 to 38°C)

Peel Stress Joint Design

by Volume	1:1.5
by Weight	1:1.2

Solids Content, %

100

Working Time, min @ 75°F (24°C)

20-40

54 g mass

Time to Handling Strength, hr

2-4

Mixed Appearance

Grey Paste

Cured Appearance

Grey

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LORD TECHNICAL DATA

Typical Cured Properties*

Tensile Strength at Break, psi (MPa) ASTM D882-83A, modified	3000 (20.7)
Elongation, % ASTM D882-83A, modified	3
Young's Modulus, psi (MPa) ASTM D882-83A, modified	120,000 (800)
Glass Transition Temperature, °F (°C) ASTM E1640-99, by DMA	158 (70)

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Bond Performance

Substrates	Cold Rolled Steel to Cold Rolled Steel Lap Shear psi (MPa)	Aluminum to Aluminum Lap Shear psi (MPa)	SMC to SMC Lap Shear psi (MPa)	Natural Rubber to Cold Rolled Steel 45° Peel pli (N/mm)
Test @ Room Temperature Failure Mode	2898 (19.9) A	2325 (16) C	400 (2.8) FT	63 (11.0) R
Substrate Cold Rolled Steel and Aluminum Sheet Molded Compound (SMC) Natural Rubber			Surface Treatment MEK Wipe, Grit Blast, MEK Wipe 320-grit Sandpaper, Dry Rag Wipe Primed with LORD 7701 Surface Treatment	
Bonded Parameters	Bond Area	Film Thickness	Cure	Mix Ratio
Metal Lap Shears	1.0"x0.5"	0.010"	72 hr @ RT	1:1 by Volume
SMC Lap Shears	1.0"x1.0"	0.030"	72 hr @ RT	1:1 by Volume
45° Peels	1.0"x1.0"	0.020"	72 hr @ RT	1:1 by Volume
Failure Mode Definition	Abbreviation			
Adhesive Failure	A			
Cohesive Failure	C			
Fiber Tear	FT			
Rubber Failure	R			

LORD TECHNICAL DATA

Cleanup – Clean excess adhesive on the bonded assembly, as well as the equipment, prior to the adhesive cure with hot water and detergent or an organic solvent such as ketones. Once adhesive has cured, heat the adhesive to 400°F (204°C) or above to soften the cured adhesive. This allows the parts to be separated and the adhesive to be more easily removed. Some success may be achieved with commercial epoxy strippers.

Shelf Life/Storage

Shelf life is two years from date of manufacture when stored at 60-80°F (16-27°C) in original, unopened container.

Cautionary Information

Before using this or any 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 technical data sheet 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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