

# LORD® 506 ACRYLIC ADHESIVE WITH LORD ACCELERATOR 17 OR 19

## Technical Data Sheet

LORD® 506 acrylic adhesive when cured with LORD Accelerator 17 or 19 creates a semi-flexible adhesive system that will quickly bond a wide variety of thermoplastics and thermoset plastics.

LORD 506 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

**Versatile:** bonds a wide variety of substrates including ABS, acrylic, polycarbonate, FRP, prepared metals, urethane, phenolic, polysulfone, and vinyl.

**Convenient:** cures very quickly at room temperature.

**Durable:** accommodates shock and sudden stress loading.

**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 and weathering.

### 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 506 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.

**Curing:** Cure begins immediately once adhesive and accelerator are mixed. Handling strength is achieved within 8-12 minutes. Complete cure will take 24 hours at room temperature. Mating surfaces should be fixtured as soon as possible (within 4-6 minutes) after adhesive application.

### Typical Properties\*

|   |                             |
|---|-----------------------------|
| Appearance  | Colorless to Amber Liquid   |
| Viscosity, cP @ 77°F (25°C)<br>Brookfield HBT<br>Spindle 3, 5 rpm | 20,000 - 70,000             |
| Density<br>lb/gal<br>(kg/m <sup>3</sup> )                         | 8.25 - 8.65<br>(989 - 1036) |
| Flash Point (Closed Cup), °F (°C)                                 | 53 (11)                     |

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

## 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.

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.*

## 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)                | 4-6          |
| Time to Handling Strength**, minutes @ 75°F (24°C) | 8-12         |
| 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        |

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

\*\*Dependent on ambient air temperature and mass; established when adhesive reaches 100 psi.

Parker Lord  
**Engineered Materials Group**  
111 LORD Drive  
Cary, NC 27511-7923  
USA  
[www.parker.com/APS](http://www.parker.com/APS)

DS3419E OD 11/25 Rev.6

Information and specifications subject to change without notice and without liability therefor.  
Trademarks used herein are the property of their respective owners.

© 2025 Parker Hannifin Corporation



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.

Information provided herein is based upon tests believed to be reliable. In as much as Parker Lord has no control over the manner in which others may use this information, it does not guarantee the results to be obtained. In addition, Parker Lord does not guarantee the performance of the product or the results obtained from the use of the product or this information where the product has been repackaged by any third party, including but not limited to any product end-user. Nor does the company make any express or implied warranty of merchantability or fitness for a particular purpose concerning the effects or results of such use.

**WARNING — USER RESPONSIBILITY. FAILURE OR IMPROPER SELECTION OR IMPROPER USE OF THE PRODUCTS DESCRIBED HEREIN OR RELATED ITEMS CAN CAUSE DEATH, PERSONAL INJURY AND PROPERTY DAMAGE.**

This document and other information from Parker-Hannifin Corporation, its subsidiaries and authorized distributors provide product or system options for further investigation by users having technical expertise.

The user, through its own analysis and testing, is solely responsible for making the final selection of the system and components and assuring that all performance, endurance, maintenance, safety and warning requirements of the application are met. The user must analyze all aspects of the application, follow applicable industry standards, and follow the information concerning the product in the current product catalog and in any other materials provided from Parker or its subsidiaries or authorized distributors.

To the extent that Parker or its subsidiaries or authorized distributors provide component or system options based upon data or specifications provided by the user, the user is responsible for determining that such data and specifications are suitable and sufficient for all applications and reasonably foreseeable uses of the components or systems.