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.

Typical Properties*

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

*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 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.

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

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**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
phone +1 877 275-5673
www.parker.com/APS

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