

# LORD® 7650 URETHANE ADHESIVE

## Technical Data Sheet

LORD® 7650 adhesive is a single-component, moisture-cure urethane adhesive designed to initially adhere similar to a contact adhesive, however permanently cross-link once cure develops.

LORD 7650 adhesive adheres to open cell polyethylene foam, styrofoam, urethane foam, plastic, fabric, rubber and prepared metal. Typical applications include gaskets, tank linings, automobile interiors, carpeting, construction panels and flooring.

### Features and Benefits

**Easy to Apply:** provides high initial tack and green strength.

**Durable:** provides good impact resistance.

**Versatile:** bonds a wide variety of substrates.

**Environmentally Resistant:** provides good resistance to water and chemicals.

**Convenient:** requires no mixing; provides working time of 15-30 minutes; requires no ovens or other heat sources for curing.

### Application

**Surface Preparation:** Surfaces should be free of grease, dirt and other contaminants. For plastics, clean the surface with a dry rag wipe or a rag dampened with solvent. For metals, prime or grit blast the surface, then solvent wash for optimum bond performance.

When bonding cured rubber, allow LORD 7701 adhesion enhancer/surface modifier to flash off before applying LORD 7650 adhesive.

**Applying:** Apply adhesive by roll coat, spray, brush or flow coat methods. Unlike contact adhesive, applying the adhesive to one side of the substrate is sufficient.

**Curing:** Handling strength is achieved after a 15-30 minute solvent flash. Complete cure will take 1-5 days depending on substrate being bonded and relative humidity.

### Shelf Life/Storage

Shelf life is six months from date of shipment when stored in a clean, dry environment at 70-80°F (21-27°C) in original, unopened container.

After opening, protect adhesive from excessive exposure to moisture by installing desiccant cartridges and/or using dry nitrogen as an inert cover.

### Typical Properties\*

Appearance	Tan Liquid
Viscosity, cP @ 77°F (25°C) Brookfield LVT Spindle 2, 12rpm	400 - 2000
Density lb/gal (kg/m³)	7.8 - 8.4 (935 - 1007)
Solids Content by Weight, %	61 - 66
Flash Point (Seta), °F (°C)	27 (-2)
Solvents	Methyl Ethyl Ketone (MEK), Toluene

\*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.

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 Bond Strengths\*\*

Substrates	Bond Strength, pli
Polyethylene Foam to Aluminum and Steel	15 - 18 Foam Tear
Vinyl to Foam	5 - 8 Foam Tear
Vinyl to Aluminum	30 - 35
Rubber to Metal	15 - 20 Thin Rubber Tear
Styrofoam to Epoxy Primed Galvanized Steel	15 - 20 Foam Tear
Rubber to Concrete	14 - 17 Rubber Tear

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Based on 48 hour cure and 50% RH.

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