

LORD® ACCELERATOR 25GB

Technical Data Sheet

LORD® Accelerator 25GB is a mix-in curative designed for use with LORD acrylic adhesives. LORD Accelerator 25GB, when mixed with LORD 850S or 852S acrylic adhesives, creates an adhesive system that will bond a variety of prepared or unprepared metals and plastics.

Features and Benefits

Convenient: provides room temperature cure with all LORD acrylic adhesives.

Environmentally Recommended: contains no solvent, non-flammable and virtually odorless.

Environmentally Resistant: resists common environmental conditions when used with LORD acrylic adhesives.

Bondline Control: allows precise control of adhesive bondline thickness due to content of glass beads, 0.01" (0.025 cm) diameter.

Application

Mixing: Confirm the proper mix ratio of acrylic adhesive to accelerator by consulting the appropriate LORD acrylic adhesive data sheet. Thoroughly mix the proper amount of adhesive and accelerator until uniform in color and consistency. Be careful not to whip excessive air into the adhesive system.

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.

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Applying: Apply adhesive to substrate surfaces using handheld cartridges or automatic meter/mix/dispense equipment. Mate the parts within the working time of the adhesive. Clamp in position until handling strength is achieved.

Curing: Handling strength and complete cure times will vary depending on acrylic adhesive used. For cure times, refer to appropriate LORD acrylic adhesive data sheet.

Cleanup: Clean equipment and tools prior to the adhesive cure with hot water and detergent or an organic solvent such as methyl ethyl ketone (MEK). Once adhesive is cured, heat the adhesive to 400°F (204°C) or above to soften the adhesive. This allows the parts to be separated and the adhesive to be more easily removed.

Shelf Life/Storage

Shelf life is six months when stored at 59-77°F (15-25°C) in original, unopened container.

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*

Appearance	Red Paste
Viscosity, cP @ 77°F (25°C) Brookfield	100,000 - 300,000
Density lb/gal (kg/m ³)	9.80 - 10.20 (1174 - 1222)
Flash Point (Seta), °F (°C)	201 (94)

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

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.

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