

LORD® Accelerator 55GB

Technical Data Sheet

LORD® Accelerator 55GB is a mix-in curative designed for use with LORD acrylic adhesives. LORD Accelerator 55GB, when mixed with LORD 5106 and 5206 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.

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 acrylic adhesive data sheet.

Cleanup – Clean equipment and tools prior to the adhesive cure with solvents such as isopropyl alcohol, acetone or 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 below 77°F (25°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.

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	Grey Paste
Viscosity, cP @ 77°F (25°C) Brookfield	170,000 - 320,000
Density, lb/gal (kg/m ³)	11.5 - 12.1 (1378 - 1450)
Flash Point (Closed Cup), °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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