

LORD® SIGNLOK™ 810S ADHESIVE

Technical Data Sheet

LORD® Signlok™ 810S adhesive is a two-component adhesive system designed for bonding metals, such as aluminum, aluminum composite material (ACM), galvanized steel and CRS, and engineered plastics, such as PC-ABS**. LORD Signlok 810S adhesive delivers fast cure speed and strong bonding with minimal bondline read-through (BLRT).

**When bonding to engineered plastics blends, it may be necessary to verify adhesive performance prior to customer builds. Please contact your Parker Lord representative or Parker Lord Customer Support for further guidance.

Features and Benefits

Aesthetics: bonds thin and flexible substrates with little to no bondline read-through.

Convenient: requires little or no substrate preparation for bonding metals and plastics.

Non-Sag: remains in position when applied on vertical or overhead surfaces, allowing for greater process flexibility.

Precise Bondline: allows precise control of the adhesive bondline thickness due to its content of glass beads.

Environmentally Resistant: resists dilute acids, alkalis, solvents, greases, oils and moisture; provides excellent resistance to indirect UV exposure and weathering.

UL Recognized: UL 746C recognized.

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 adhesive with accelerator at a ratio of 2:1, adhesive to accelerator, by volume. Handheld cartridges will automatically dispense the correct volumetric ratio of each component. Even color distribution visually indicates a thorough mix. Once mixed, the adhesive system cures rapidly.

Applying: Apply mixed adhesive to bond surfaces using handheld cartridge or automatic meter/mix/dispense equipment. Contact your Parker Lord representative if assistance is needed using this equipment.

Curing: Complete cure requires 24 hours at room temperature. Mating surfaces must be held in contact during the entire curing process. Cure rate can be accelerated by applying modest heat [$<150^{\circ}\text{F}$ ($<66^{\circ}\text{C}$)].

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.

Typical Properties*

	Adhesive (Part A)	Accelerator (Part B)
Appearance	Black Paste	Off-white Paste
Viscosity, cP @ 77°F (25°C) Brookfield	40,000 - 120,000	200,000 - 400,000
Density lb/gal (kg/m^3)	7.8 - 8.1 (935 - 970)	13.7 - 14.2 (1640 - 1700)
Flash Point, $^{\circ}\text{F}$ ($^{\circ}\text{C}$)	59 (15)	>200 (>93)

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

Shelf Life/Storage

Shelf life is one year when stored below 77°F (25°C) in original, unopened container. Storage temperatures of 50-60°F (10-15°C) are recommended. If stored cold, allow product to return to room temperature before using. Protect from exposure to direct sunlight.

After dispensing product from cartridge, remove the mixing tip immediately and install supplied cartridge plugs to avoid cured adhesive from plugging cartridge.

LORD Signlok 810S adhesive is flammable. Do not store or use near heat, sparks or open flame.

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 Accelerator

Mix Ratio, Adhesive to Accelerator by Weight	1.1:1
by Volume	2:1
Solids Content, %	100
Working Time, minutes @ 70°F (21°C)	8 - 12
Time to Handling Strength, minutes @ 70°F (21°C)	20 - 25
Mixed Appearance	Dark Grey Paste
Cured Appearance	Dark Grey

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

Typical Cured Properties†

Hardness Shore D	40
Tensile Strength at Break, psi (MPa)	841 (5.8)
Lap Shear Strength, psi (MPa) 0.125" Aluminum 3003 alloy panels 18 gauge #304 Stainless Steel #3 finish panels	1441 (9.94)
Elongation, %	190
Glass Transition Temperature (Tg), °F (°C)	109 (43)

†Data obtained from material cured at room temperature. Data is typical and not to be used for specification purposes.

Parker Lord
Engineered Materials Group
111 LORD Drive
Cary, NC 27511-7923
USA
phone +1 877 275-5673
www.parker.com/APS

DS4613 OD 02/26 Rev.0

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

© 2026 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.