

SELECTOR GUIDE



LORD® Structural Adhesives for the Sign Industry

LORD
AskUsHow™

400 SERIES – Metal bonding and cross bonding metals to plastics and other materials

The most versatile adhesive for the sign shop, the UL-approved 400 series can be used to replace welding, brazing, riveting and other mechanical fastening methods, outperforming these fasteners in harsh environments. For these reasons, the 400 series is frequently used for adding structural reinforcing members inside the sign box and building channel letters. Unleash your creativity and reduce your costs by using thinner gauge metals, pre-painted substrates and engineered plastics in various combinations.

PRODUCT	SPEED	WORK TIME (75°F/24°C)	HANDLING TIME (75°F/24°C)	CURED COLOR	SUBSTRATES
LORD 403/19 (UL)	Fast	2 - 4 min	4 - 6 min	Light Green	Bare Metals – Aluminum, Steel, Stainless Steel
LORD 406/19 (UL)	Medium	6 - 10 min	12 - 17 min	Light Green	Aluminium Composite Panel (ACP) / Aluminium Composite Material (ACM)
LORD 410/19 (UL)	Slow	20 - 45 min	1 - 2 hrs	Light Green	Painted Metals Acrylic Sheet PETG Sheet Polycarbonate Sheet Polystyrene Foam Board Expanded PVC Foam Board Vinyl Laminate High Density Urethane Foam Dissimilar Materials (metal to plastic)



Scan the QR code to watch a **YouTube** video to learn how to build a sign box.

METAL FRAME ASSEMBLY



1 Clean parts.

2 Assemble frame.

3 Fixture with tape and check for square.

4 Apply adhesive.

CHANNEL LETTER ASSEMBLY



1 Route ACM for sign face or back, bend channel sides and clean all bond areas.

2 Fixture channel sides to the ACM.

3 Apply LORD 400 series adhesive.

4 Tool and let stand until cured.

OTHER USES



Bond studs for reverse lit applications.

Reinforce butt joints or other high stress areas.

Bond simple square profiles for rigidity.

NO-MIX SERIES – Indefinite open time for large applications of metals and other materials


No-Mix adhesive components, also known as “honeymoon” adhesives, are applied on the opposite mating surfaces of the substrates to be bonded. Curing does not start until the parts are brought together. This assembly technique is especially good for large surfaces with tight tolerances, such as mounting a sign face. These adhesives are to be used at bondline thicknesses 20 mils or less.

PRODUCT	SPEED	WORK TIME (75°F/24°C)	HANDLING TIME (75°F/24°C)	CURED COLOR	SUBSTRATES
LORD 201 (Flowable)	Indefinite	6 - 8 min	12 - 16 min	Green	Acrylic Sheet Bare Metals – Aluminum, Steel, Stainless Steel
LORD 204 (Non-Sag)	Indefinite	6 - 8 min	12 - 16 min	Green	Aluminium Composite Panel (ACP) / Aluminium Composite Material (ACM)
Maxlok™ T6 (High Peel)	Indefinite	6 - 8 min	12 - 16 min	Off-white	Painted Metals PETG Sheet/Polycarbonate Sheet
LORD Accelerator 4 <i>Must be used on one side</i>		flashes in 1 min	N/A		Polystyrene Foam Board Expanded PVC Foam Board Vinyl Laminate High Density Urethane Foam



7500 SERIES – Plastic bonding and cross bonding different types of plastics and other materials

For optically clear bonding, gap filling or bonding wood or other porous substrates, the 7500 series offers tough, flexible adhesives in a variety of speeds. The 7550 A/C is the perfect choice for bonding trimcap materials to polycarbonate faces.

PRODUCT	SPEED	WORK TIME (75°F/24°C)	HANDLING TIME (75°F/24°C)	CURED COLOR	SUBSTRATES
LORD 7550 A/C	Fast	2 - 4 min	4 - 6 min	Optically Clear	Acrylic Sheet
LORD 7542 A/B 	Medium	6 - 10 min	12 - 17 min	Brown	Painted Metals
LORD 7542 A/D 	Slow	20 - 45 min	1 - 2 hrs	Brown	Paper/Foam Board PETG Sheet Polycarbonate Sheet Polystyrene Foam Board Expanded PVC Foam Board Vinyl Laminate High Density Urethane Foam Wood



Scan the QR code to watch a **YouTube** video to learn how to bond a channel letter face.

CHANNEL LETTER FACE ASSEMBLY



1 Heat trim cap.

2 Position letter face and trim cap.

3 Apply adhesive.

4 Clamp and let stand until cured.

LORD Structural Adhesives are available in a convenient variety of sizes *(images below are not to scale)*

Manual 50 mL Cartridge Dispensing Guns

Mixer – 1/4" x 6" x 21 elem.



Manual 375 mL Cartridge Dispensing Guns

Mixer – 3/8" x 9" x 24 elem.



Manual 200 mL CX Cartridge Dispensing Guns

Mixer – 3/8" x 11" x 24 elem.



Manual 405 mL CX Cartridge Dispensing Guns

Mixer – 3/8" x 9 1/2" x 24 elem.

ASK THE EXPERTS

30+ Years Sign Application Expertise • Complete Product Line • Strong Distribution Network

More adhesives, sizes and accessories are available for your unique needs. Talk to your sign materials distributor or contact us at LORD.com or **877 ASK LORD** (275 5673). To see video instruction for use of the LORD cartridges and applicator guns, access www.youtube.com/lordadhesives.

SURFACE PREPARATION

All surfaces should be clean and free from oil, grease and dirt. At a minimum, wipe surface with a clean, dry rag or blow off surface with clean air. Solvent wipe all surfaces with isopropyl alcohol. Do not use lacquer thinners, mineral spirits, gasoline, toluene or xylene as they may leave a residue that may cause bonding problems. Do not use commercial cleaners. These often leave a residue that may cause bonding problems.

SUBSTRATE	SURFACE PREPARATION
Aluminum/Steel	Solvent wipe with isopropyl alcohol.
Stainless Steel	Solvent wipe with isopropyl alcohol. Then, mechanically abrade with 80-grit paper or grinder. Wipe with isopropyl alcohol to remove sanding dust.
Aluminum Composite Material (ACM)	Solvent wipe with isopropyl alcohol.
Prefinished Metal	Factory painted metal with baked polyester finish can be solvent wiped. Shop painted or other finishes must be removed by sanding prior to bonding.
Acrylic	Scuff with scuff pad or 120-grit paper. Solvent wipe with isopropyl alcohol.
Polycarbonate	Solvent wipe with isopropyl alcohol.
PETG	Solvent wipe with isopropyl alcohol.
Trimcap	Wipe with clean, dry cloth.
Urethane Foam Board	Blow off surface with clean air or wipe with clean, dry cloth.
Sintra®	Scuff with scuff pad or 120-grit paper. Solvent wipe with isopropyl alcohol.
Ceramic and Stone	Porous: No primer is required. Non-porous (Smooth/polished): LORD AP-134 primer is required.
Wood	Wipe with clean, dry cloth.
Glass	LORD AP-134 primer is required.

CAUTIONARY INFORMATION

Before using any LORD product, refer to the Technical Data Sheet, Material Safety Data Sheet (MSDS) 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. **Talk to your sign materials distributor, contact us at LORD.com, call 877 ASK LORD (275 5673) or scan the QR code for additional assistance.**

SPECIAL THANKS TO:



Values stated herein represent typical values as not all tests are run on each lot of material produced. For formalized product specifications or specific product end uses, contact the Customer Support Center.

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LORD provides valuable expertise in adhesives and coatings, vibration and motion control, and magnetically responsive technologies. Our people work in collaboration with our customers to help them increase the value of their products. Innovative and responsive in an ever-changing marketplace, we are focused on providing solutions for our customers worldwide ... Ask Us How.

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