

LORD® 7610DTM Direct-to-Metal Adhesive/Sealant

Description

LORD® 7610DTM direct-to-metal adhesive/sealant is a single-component, moisture-cure product offering excellent adhesion to various substrates including many plastics, glass, concrete, wood and metals, especially precoated metals.

Features and Benefits

Durable – creates high strength bonds, replacing mechanical fastening methods; exhibits excellent primerless adhesive properties.

Convenient – requires no mixing; cures quickly even at low temperatures; requires no ovens or other heat sources for curing.

Chemically Resistant – solvent resistant when cured. Painting and most cleaning processes do not affect bond strength.

Temperature Resistant – uncured material can endure 225°F (107°C) for 60 minutes, and cured material can endure 325°F (163°C) for 60 minutes with no negative effect.

Environmentally Resistant – resists weathering and aging; provides excellent resistance to indirect UV exposure.

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

Application

Surface Preparation – Clean and dry surfaces prior to product application. Surfaces should be free of grease, dirt and other contaminants.

Applying – Using a handheld cartridge, apply LORD 7610DTM adhesive/sealant to substrate and mate the parts within the work time of the material. Do not allow the material to skin over before mating parts.

Typical Properties*

Appearance	White, Black or Grey Paste
Skin Time, min @ 77°F (25°C), 50% RH	15-45
Work Time, min @ 77°F (25°C), 50% RH	25
Paint Time	Immediately and up to 30 days without a scuff

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

Typical Cured Properties*

Hardness Shore A	50
Tensile Strength, psi (MPa)	200 (1.38) minimum
Lap Shear Strength, psi (MPa)	200-500 (1.38-3.45)
Elongation, % ASTM D412	400 minimum

Curing – Through cure will vary depending on temperature and humidity. Product cures 1/8 inch every 24 hours at 77°F (25°C). Product thickness will determine full cure time. Product may be painted immediately with most industrial and consumer paints.

Cleanup – Use isopropyl alcohol (IPA) to clean up adhesive. Once cured, any remaining adhesive can be removed mechanically.

Shelf Life/Storage

Shelf life is 15 months when stored in a well ventilated area at or below 80°F (27°C) in original, unopened container. Once cartridge has been opened, leave the dispense tip on to act as a seal against moisture.

Cautionary Information

Before using this or any 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.

LORD TECHNICAL DATA

Typical Bond Strengths**

Substrates	Bond Strength, psi (MPa)	Failure Mode
Hot Dipped Galvanize (HDG)		
0.047"	439 (3.03)	C (95%)
0.047" & 80-grit Grind	400 (2.76)	C (98%)
Galvaneal		
0.029"	411 (2.83)	C (97%)
0.029" & 80-grit Grind	311 (2.14)	A (53%)
Cold Rolled Steel (CRS)		
0.030"	285 (1.96)	A (97%)
0.030" & 80-grit Grind	434 (3.00)	C (98%)
Aluminum (AL)		
0.034" 6022T6	157 (1.09)	A (99%)
0.034" 6022T6 & 80-grit Grind	393 (2.71)	C (90%)
Cromax 2580CR Scuffed on 0.030" CRS	498 (3.44)	C (100%)
Valspar VP50 Scuffed on 0.030" CRS	418 (2.88)	C (100%)
Polyester Paint on 19 Ga 3003 H16 AL	483 (3.33)	C (100%)

Failure Mode Definition	Abbreviation
Adhesive Failure	A
Cohesive Failure	C

**Bond strength data was obtained using LORD 7610DTM adhesive/sealant with 0.010" glass beads. Please contact LORD Corporation regarding the use and/or performance of using other combinations (+1 877 ASK LORD).

LORD TECHNICAL DATA

Values stated in this technical data sheet 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 LORD Corporation has no control over the manner in which others may use this information, it does not guarantee the results to be obtained. In addition, LORD Corporation 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.

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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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