

# LORD® 305 Epoxy Adhesive

## Description

LORD® 305 adhesive is a general purpose, medium viscosity, two-component epoxy adhesive system used for applications that require strong, durable, chemically and environmentally resistant bonds. This adhesive system provides excellent adhesion to prepared metals, fiberglass reinforced plastics (FRP), phenolic, wood, prepared rubber and other materials. It is also used to bond cured rubber to itself and rubber to metal, including gaskets, bushings, shock-absorbing devices and rubber rolls. LORD 305 adhesive can be either room temperature cured or heat cured for faster processing.

## Features and Benefits

**Durable** – provides load bearing properties equal to or greater than the materials being bonded.

**Environmentally Friendly** – contains no solvent, nonflammable and virtually odorless.

**Environmentally Resistant** – resists moisture, sunlight and weathering.

**Temperature Resistant** – performs at temperatures from -30 to +250°F (-34 to +121°C).

**Chemically Resistant** – resists dilute acids, alkalis, solvents, greases and oils.

**Excellent Engineering Properties** – provides low shrinkage, good creep properties and low water absorption.

## Application

**Surface Preparation** – Remove soil, grease, oil, fingerprints, dust, mold release agents, rust and other contaminants from the surfaces to be bonded by solvent degreasing or alkaline cleaning.

On metal surfaces which are free of oxidation, use an isopropyl alcohol wipe. If necessary, use an abrasive material to remove tarnish. Always follow abrasion by a second cleaning to ensure removal of loose particles.

When bonding cured rubber, allow LORD 7701 surface treatment to flash off before applying LORD 305 adhesive. For superior environmental resistance and adhesion, prime glass and ceramic surfaces with LORD AP-134 primer.

Handle prepared surfaces carefully to avoid contamination. Assemble as soon as possible.

## Typical Properties\*

|  | 305-1 Resin        | 305-2 Hardener    |
|--|--------------------|-------------------|
| Appearance   | Clear Amber Liquid | Blue Heavy Liquid |
| Viscosity, cP @ 77°F (25°C)<br>Brookfield HBF<br>Spindle 2, 10 rpm | 10,000-18,000      | 20,000-45,000     |
| Density  |                    |                   |
| lb/gal   | 9.4-10.0           | 7.75-8.35         |
| (kg/m <sup>3</sup> )   | (1126-1198)        | (928-1001)        |
| Flash Point (Closed Cup), °F (°C)                                  | >200 (>93)         | >200 (>93)        |

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

# LORD TECHNICAL DATA

**Mixing** – Thoroughly mix the proper amount of resin and hardener until uniform in color and consistency. Be careful not to whip excessive air into the adhesive system. Handheld cartridges will automatically dispense the correct volumetric ratio of each component.

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. Do not use any adhesive that has begun to cure.

**Applying** – Apply the mixed adhesive to bond surfaces using automatic meter/mix/dispense equipment, handheld cartridges or any convenient tool such as a stiff brush, spatula or trowel. For general use, a film thickness of approximately 0.02 inch (0.51 mm) is recommended. To control bondline thickness, a small amount of solid glass beads can be added into the mixed adhesive.

Join the parts in such a way as to avoid entrapped air. Apply only enough pressure to ensure good wetting of the adhesive on both surfaces. Squeezing a little adhesive out at the edges is usually a sign of proper assembly. It is not necessary to clamp the assembly unless movement during adhesive cure is likely.

Maximum adhesion will occur only with parts which mate well without the need for excessive clamping pressure during cure. Excessive clamping may squeeze too much adhesive from the bond area which can result in a poor bond.

**Curing** – LORD 305 adhesive will cure to full strength in 24-48 hours, provided that the adhesive, substrates and ambient temperature are 65°F (18°C) or higher.

Higher temperatures will provide faster cure times; however, the bondline temperature should not exceed 325°F (162°C). Elevated temperature cure produces the highest bond strengths and impact resistance. Firm recommendations of cure times and temperatures depend on material composition and heating methods.

Once the adhesive has cured, it can be filed, sanded, machined or otherwise handled in the same way as a light metal. Paint, lacquers, enamels and other coatings can be applied to cured adhesive.

## Typical Properties\* of Resin Mixed with Hardener

Mix Ratio, Resin to Hardener

General Purpose, -30 to 250°F (-34 to 121°C)

Mixed Stress Joint Design

|           |       |
|-----------|-------|
| by Volume | 1:1   |
| by Weight | 1.2:1 |

High Temperature, 50-250°F (10-121°C)

Shear Stress Joint Design

|           |       |
|-----------|-------|
| by Volume | 2:1   |
| by Weight | 2.4:1 |

Low Temperature, -40 to 100°F (-40 to 38°C)

Peel Stress Joint Design

|           |       |
|-----------|-------|
| by Volume | 1:2   |
| by Weight | 1:1.7 |

Solids Content, %

100

Working Time, hr @ 75°F (24°C)

1-2

54 g mass

Time to Handling Strength, hr

8-16

Mixed Appearance

Blue Liquid

Cured Appearance

Translucent Blue

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

# LORD TECHNICAL DATA

## Typical Cured Properties

|   |               |
|---|---------------|
| Tensile Strength at Break, psi (MPa)<br>ASTM D882-83A, modified | 2490 (17.2)   |
| Elongation, %<br>ASTM D882-83A, modified                        | 31            |
| Young's Modulus, psi (MPa)<br>ASTM D882-83A, modified           | 108,500 (748) |
| Glass Transition Temperature, °F (°C)<br>ASTM E1640-99, by DMA  | 141 (61)      |

## Bond Performance

| Substrates   | Cold Rolled Steel to<br>Cold Rolled Steel<br>Lap Shear<br>psi (MPa) | Aluminum to<br>Aluminum<br>Lap Shear<br>psi (MPa) | SMC to<br>SMC<br>Lap Shear<br>psi (MPa) | Natural Rubber to<br>Cold Rolled Steel<br>45° Peel<br>pli (N/mm) | SBR to<br>SBR<br>T-Peel<br>pli (N/mm) |
|--|---|---|---|--|---------------------------------------|
| Test @ Room Temperature<br>Failure Mode  | 2240 (15.4)<br>A  | 1890 (13.0)<br>36C/A                              | 820 (5.6)<br>FT                         | 37 (6.5)<br>58R/A  | 84 (14.7)<br>R                        |
| Test @ Hot Strength,<br>180°F (82°C)<br>Failure Mode   | 1100 (7.6)<br>A   | 1040 (7.2)<br>A                                   | 490 (3.4)<br>13FT/A                     | 24 (4.2)<br>44R/A  | —                                     |
| Test after 7 days in<br>H <sub>2</sub> O @ 130°F (54°C)<br>Test after 24 hours<br>Failure Mode | 2630 (18.1)<br>A  | 1840 (12.7)<br>A                                  | 600 (4.1)<br>FT                         | 33 (5.8)<br>13R/A  | 83 (14.5)<br>SB                       |
| Test after 14 days Salt<br>Spray Exposure<br>Test Immediately<br>Failure Mode                  | 2500 (17.2)<br>A  | 1790 (12.3)<br>A                                  | 610 (4.2)<br>100FT                      | —  | 110 (19.3)<br>83R/SB                  |
| Test after 14 days @ 100°F<br>(38°C), 100% RH<br>Test Immediately<br>Failure Mode              | 2740 (18.9)<br>A  | 2010 (13.8)<br>A                                  | 660 (4.5)<br>FT                         | 41 (7.2)<br>50R/A  | 94 (16.5)<br>83R/SB                   |
| Test @ -30°F (-34°C)<br>Failure Mode   | 2490 (17.1)<br>A  | 1600 (11.0)<br>A                                  | 720 (5.0)<br>FT                         | 60 (10.5)<br>85R/A   | 78 (13.6)<br>R                        |

### Substrate

Cold Rolled Steel and Aluminum  
Sheet Molded Compound (SMC)  
Styrene Butadiene Rubber (SBR)  
Natural Rubber

### Surface Treatment

MEK Wipe, Grit Blast, MEK Wipe  
320-grit Sandpaper, Dry Rag Wipe  
Primed with LORD 7701 Surface Treatment  
Primed with LORD 7701 Surface Treatment

### Bonded Parameters

Metal Lap Shears  
SMC Lap Shears  
T-Peels  
45° Peels

### Bond Area

1.0"x0.5"  
1.0"x1.0"  
1.0"x3.0"  
1.0"x1.0"

### Film Thickness

0.010"  
0.030"  
0.020"  
0.020"

### Cure

72 hr @ RT  
72 hr @ RT  
72 hr @ RT  
72 hr @ RT

### Mix Ratio

1:1 by Weight  
1:1 by Weight  
1:1 by Weight  
1:1 by Weight

### Failure Mode Definition

Adhesive Failure  
Cohesive Failure  
Fiber Tear  
Rubber Failure  
Stock Break

### Abbreviation

A  
C  
FT  
R  
SB

# LORD TECHNICAL DATA

**Cleanup** – Clean excess adhesive on the bonded assembly, as well as the equipment, prior to the adhesive cure with hot water and detergent or an organic solvent such as ketones. Once adhesive has cured, heat the adhesive to 400°F (204°C) or above to soften the cured adhesive. This allows the parts to be separated and the adhesive to be more easily removed. Some success may be achieved with commercial epoxy strippers.

## Shelf Life/Storage

Shelf life is one year from date of shipment when stored at 40-80°F (4-27°C) in original, unopened container.

## Cautionary Information

Before using this or any LORD product, refer to the 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.

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.

LORD and "Ask Us How" are trademarks of LORD Corporation or one of its subsidiaries.

---

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.

### **LORD Corporation World Headquarters**

111 Lord Drive  
Cary, NC 27511-7923  
USA

### **Customer Support Center** (in United States & Canada)

+1 877 ASK LORD (275 5673)

[www.lord.com](http://www.lord.com)

For a listing of our worldwide locations, visit [LORD.com/locations](http://LORD.com/locations).

©2008 LORD Corporation OD DS3369 (Rev.4 9/08)

**LORD**  
AskUsHow™