

LORD® Maxlok™ MX/T3, MX/T6 and MX/T18 Acrylic Adhesives

LORD® Maxlok™ MX/T3, MX/T6 and MX/T18 acrylic adhesives replace welding, brazing, riveting and other mechanical fastening methods especially over a wide range of temperature environments subject to high impact or high peel loads.



Features & Benefits

Versatile – bonds a wide range of unprepared metals with minimal substrate preparation.

Temperature Resistant – performs at temperatures from -40 to +300°F (-40 to +149°C).

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

UL Rated – Maxlok MX/T6 adhesive system is UL 746C certified.

Precise Bondline – allows precise control of adhesive bondline thickness due to its content of glass beads, 0.01" (0.025 cm) diameter.

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

Part #	Description	SAP #	Cartridge Size	Case Qty	Net Weight/ Container
MX/T3	LORD Maxlok T3 Acrylic Adhesive with MX Accelerator	3022875	50 mL	12	0.132
		3019950	375 mL	12	1.059
MX/T6	LORD Maxlok T6 Acrylic Adhesive with MX Accelerator	3019632	50 mL	12	0.132
		3019621	375 mL	12	1.059
MX/T18	LORD Maxlok T18 Acrylic Adhesive with MX Accelerator	3021934	50 mL	12	0.132
		3019922	375 mL	12	1.059

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 Maxlok adhesive with the proper amount of Maxlok MX accelerator. Handheld cartridges will automatically dispense the correct volumetric ratio of each component. Even color distribution visually indicates a thorough mix. Once mixed, the adhesive cures rapidly.

Typical Properties* of Adhesive Mixed with Accelerator

	MX/T3	MX/T6	MX/T18
Mix Ratio by Volume, Accelerator to Adhesive	1:4	1:4	1:4
Solids Content, %	100	100	100
Working Time, min @ 77°F (25°C)	3-5	6-9	18-24
Time to Handling Strength, min @ 77°F (25°C)	6-8	20-24	48-72
Mixed Appearance	Grey Paste	Grey Paste	Grey Paste
Tensile Strength at Break, psi (MPa)	2800 (19.3)	2800 (19.3)	2800 (19.3)

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

Metal Bond Performance**

	Aluminum to Aluminum	HDG to HDG	EZG to EZG
Lap Shear @ Room Temperature, psi (MPa) Failure Mode	2760 (19) C	2410 (16.6) C	2190 (15.1) C
T-Peel, pli (N/mm) Failure Mode	41 (7.2) C	53 (9.3) C	54 (9.5) C

Failure Mode Definition

Adhesive Failure (A)
Cohesive Failure (C)

Plastic/Composite Bond Performance**

	ABS to ABS	FRP to FRP
Lap Shear @ Room Temperature, psi (MPa) Failure Mode	520 (3.6) SB	1280 (8.8) FT

Failure Mode Definition

Fiber Tear (FT)
Stock Break (SB)

**Bond performance data was obtained using LORD Maxlok MX/T6 adhesive. Please contact LORD Corporation regarding the use and/or performance of using other adhesive/accelerator combinations (+1 877 ASK LORD).

For more information visit us at LORD.com or call + 1 877 ASK LORD (275 5673) to speak with a customer representative.