

# LORD® 400 SERIES




## Acrylic Adhesives with LORD Accelerator 19 for the Sign Industry

The most versatile adhesives for the sign shop, the UL-approved LORD® 400 series can be used to replace welding, brazing, riveting and other mechanical fastening methods, outperforming these fasteners in harsh environments.

### Features & Benefits

- **Versatile:** bonds a wide range of unprepared metals with minimal substrate preparation, as well as engineered thermoplastics including XENYO®, polycarbonate, ABS and acrylics.
- **Temperature Resistant:** performs at temperatures from -40°F to +400°F (-40°C to +204°C).
- **Environmentally Resistant:** resists dilute acids, alkalis, solvents, greases, oils, moisture, salt spray and weathering; provides excellent resistance to indirect UV exposure.
- **Non-Sag:** remains in position when applied on vertical or overhead surfaces, allowing for greater process flexibility.
- **UL Approved:** when mixed with LORD Accelerator 19, adhesive system is UL 746C certified.



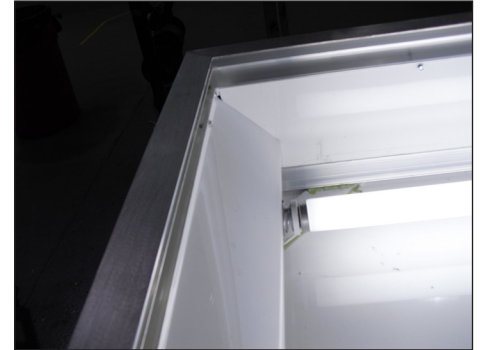
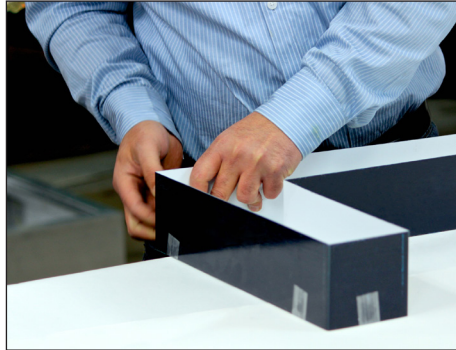
Product	Description	Color	Ratio	Cartridge Size	Part #
LORD 403/19	LORD 403 Acrylic Adhesive with LORD Accelerator 19 	Tan	4:1	50 mL	3021003
		Tan	4:1	CX (404 mL)	3021004
LORD 406/19	LORD 406 Acrylic Adhesive with LORD Accelerator 19 	Tan	4:1	50 mL	3021024
		Tan	4:1	415 mL	3032029
		Tan	4:1	CX (404 mL)	3021011
LORD 410/19GB	LORD 410 Acrylic Adhesive with LORD Accelerator 19GB 	Tan	4:1	415 mL	3032026



## Key Applications

- Channel Letter Bonding
- Sign Box Bonding

LORD 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, prepainted substrates and engineered plastics in various combinations.



Typical Properties* of Adhesive Mixed with LORD Accelerator 19	403	406	410
Solids Content, %	100	100	100
Working Time, minutes @ 75°F (24°C)	2-4	6-10	20-30
Time to Handling Strength, minutes @ 75°F (24°C) 50 psi Shear	4-6	12-17	60-120
Full Cure Time, hours @ 75°F (24°C)	24**	24	24

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

\*\*Reaches 90% of its full strength after 2 hours.

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