



LORD[®] STRUCTURAL ADHESIVES FOR VEHICLE ACCESSORIES

Selector Guide

LORD® STRUCTURAL ADHESIVES

With more than 90 years serving the transportation market, Parker Lord brings a large range of value-added structural adhesive and sealant solutions for car and truck accessory manufacturers to assist with the design and assembly of innovative car and truck accessory products. Our best-in-class product line provides multiple options for our customers to build high-quality parts that are more durable, aesthetically appealing and cost effective.

These adhesives and sealants allow manufacturers to bond and seal in one step which improves cost, performance and warranty compared to welding and other traditional fastening methods. In addition, LORD adhesives and sealants help reduce production floor bottlenecks and improve throughput to enhance profitability. Our materials are designed to bond to a wide range of metals, plastics, composites and foams while maintaining high durability in demanding and extreme environments.

Let Parker Lord help your company save time and money, while improving quality.

Solutions:

- Component Assembly
- Dissimilar Substrate Bonding
- Panel Lamination
- Panel to Frame Bonding
- Structural Assembly
- Seam Sealing

Compatible Substrates:

- ✓ Bare Metal
- ✓ Composite
- ✓ Painted Metal
- ✓ Plastic
- ✓ Specialty Substrate
- ✓ Foam
- ✓ Crossbonding

Applicable Vehicles Accessories



Truck Caps



Toolbox/ Cargo Management



Running Boards



Rear Spoilers



Tonneau Covers

PRODUCT SELECTION

PRODUCT		SUBSTRATES						TYPICAL PROPERTIES*					
		Bare Metal	Composite	Painted Metal	Plastics	Cross Bonding	Specialty	Work Time @ 75°F (24°C)	Mix Ratio by Volume, Adhesive to Accelerator	Time to Handling Strength @ 75°F (24°C)	Accelerator(s)	Mixed Appearance	Attributes
LORD® 7800 FAST-CURE URETHANE ADHESIVE	A/C		✓	✓	✓	✓	✓	3 min.	1:1	12 min.	N/A	Black	<ul style="list-style-type: none"> • 2x Faster Processing Time • Equal Mix Ratio • Sag Resistance • No Odor
	A/D							6 min.	1:1	25 min.			
LORD® 7542 URETHANE ADHESIVE	A/B ^(L)							4-7 min.	1:1	1-2 hr.	N/A	Varies** (Black or Brown)	<ul style="list-style-type: none"> • Structural Bonding • Lower Viscosity for Easy Dispensing • Non Flammable
	A/C ^(L)	✓	✓	✓	✓	✓	11-15 min	1:1	2 hr.				
	A/D ^(L)							20-30 min.	1:1	3 hr.			
LORD® 7545 URETHANE ADHESIVE	A/G							1.5 min.	1:1	10 min.	N/A	Varies** (Off-white or Black)	<ul style="list-style-type: none"> • Bonds FRP, SMC, Plastics and Prepared Metals • Non-sag • Non Flammable
	A/B							3-5 min.	1:1	30 min.			
	A/C	✓	✓	✓	✓	✓	6-8 min.	1:1	60 min.				
	A/D							11-18 min.	1:1	90 min.			
	A/E							22-38 min.	1:1	2-3 hr.			
	A/F							45-65 min.	1:1	4-5 hr.			
LORD® 7555 URETHANE ADHESIVE/ SEALANT	A/C							3-5 min. @ 77°F (25°C)	1:1	1 hr. @ 77°F (25°C)	N/A	White Paste	<ul style="list-style-type: none"> • Bonds & Seals Plastics and Prepared Metals • Non-sag, non-yellowing • Paint & Finish Immediately
	A/E	✓	✓	✓	✓	✓	45 min. @ 77°F (25°C)	1:1	5-6 hr. @ 77°F (25°C)				
LORD® 7610DTM DIRECT-TO-METAL ADHESIVE/SEALANT		✓	✓	✓	✓	✓	✓	25-35 min. @ 77°F (25°C)	N/A	6-12 hr. @ 77°F (25°C)	N/A	White Paste	<ul style="list-style-type: none"> • Single Component • No Mix • UV Resistant
LORD® ACRYLIC ADHESIVE WITH ACCELERATOR 19	403 ^(L)							2-4 min.	4:1	4-6 min.	19, 19 Black, 19GB, 19GB Grey	Tan Paste**	<ul style="list-style-type: none"> • Easy to Dispense • Withstands E-Coat & Powder Coat • Cold Impact
	406 ^(L)	✓	✓	✓	✓	✓	6-10 min.	4:1	12-17 min.				
	410 ^(L)							20-30 min.	4:1	60-120 min.			
LORD® 810S LOW READ-THROUGH (LRT) ACRYLIC ADHESIVE WITH LORD ACCELERATOR 20GB		✓	✓	✓	✓	✓		8-12 min. @ 70°F (21°C)	2:1	20-25 min. @ 70°F (21°C)	20GB	Dark Grey Paste	<ul style="list-style-type: none"> • Ideal for Thin, Glossy and ACM Materials • Withstands E-Coat & Powder Coat
LORD® ACRYLIC ADHESIVE WITH LORD ACCELERATOR 25GB	850S (FAST)	✓	✓	✓	✓	✓		6-10 min.	10:1	18-24 min.	25GB	Red Paste	<ul style="list-style-type: none"> • Toughened • High Impact • Fatigue Resistant • Low Temp Environment • Withstands E-Coat & Powder Coat
	852S (SLOW)							20-25 min.	10:1	50-70 min.			
MAXLOK® ACRYLIC ADHESIVE WITH MX ACCELERATOR	T3S							3-5 min. @ 77°F (25°C)	4:1	6-8 min. @ 77°F (25°C)	MX	Grey Paste	<ul style="list-style-type: none"> • Bondline Control • Glass Beads • High Impact • High Peel • Withstands E-Coat & Powder Coat
	T6S	✓	✓	✓	✓	✓	6-9 min. @ 77°F (25°C)	4:1	20-24 min. @ 77°F (25°C)				
	T18S							18-24 min. @ 77°F (25°C)	4:1	48-72 min. @ 77°F (25°C)			

Refer to LORD Structural Adhesives Guide for full product information.

Refer to LORD UL-Approved Adhesives for Sign and Electrical Enclosure Bonding for listing of specific UL-Approved products.

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

**Mixed appearance will vary based on accelerator/curative used.

ADHESIVE COVERAGE/ VOLUME ESTIMATING TABLES

Linear Feet (m) Bead Diameter Coverage in Cartridge

Use the table below to determine the length of adhesive bead that can be obtained from a cartridge of adhesive.

LINEAR FEET (m) OF BEAD IN CARTRIDGE						
CARTRIDGE VOLUME		50 mL	200 mL	400 mL	415 mL	490 mL
BEAD DIAMETER	1/8 inch (3 mm)	20.7 (6.3)	82.5 (25.15)	165.5 (50.4)	171.5 (52.27)	203 (61.87)
	1/4 inch (6 mm)	5.1 (1.55)	20.7 (6.3)	41.4 (12.6)	43 (13.1)	50.6 (15.4)
	3/8 inch (9.5 mm)	2.3 (0.7)	9.3 (2.8)	18.41 (5.6)	19.1 (5.8)	22.5 (6.86)

Compressed Bead Thickness (Spread) – inches (mm)

Use the table below to determine the required bead diameter from the dimensions of the adhesive joint.

COMPRESSED BEAD THICKNESS (SPREAD) – inches (mm)				
THICKNESS		0.010" (0.25 mm)	0.030" (0.25 mm)	0.040" (0.25 mm)
BEAD DIAMETER	1/8 inch (3 mm)	1.25 (32)	0.41 (10)	0.3 (7.6)
	1/4 inch (6 mm)	4.9 (124.5)	1.65 (42)	1.23 (31)
	3/8 inch (9.5 mm)	11.0 (279)	3.7 (94)	2.8 (71)

Parker Lord
Engineered Materials Group
 111 LORD Drive
 Cary, NC 27511-7923
 USA
 phone +1 877 275-5673
www.parker.com/APS

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