



LORD SIGN ASSEMBLY ADHESIVES

Metal Bonding Adhesives

Technical Data reported at 70-77°F (21-25°C).

Product	Features	Applications	Technical Data							Accessories		
			Work Time	Handling Time	Full Cure	Mix Ratio	Color	Size	Part #	Dispensing Gun	Mixing Tip	Plunger
LORD Signlok 403 Fast	Right-Sized Packaging Powder Coating* Extended Shelf Life Glass Beads for Precision Bondline UV & Corrosion Resistance for Outdoor Assemblies Minimal Surface Preparation	Replace Welding and Mechanical Fastening Channel Letter Assembly Metal Box Frame Assembly Corner Key Installation Bond and Seal in One Step Seal for Light Leaks	2-4 min	4-6 min	24 hr	2:1	Tan	210 mL	3031522	3029937 3029936	3001173	
LORD Signlok 406 Medium			6-10 min	12-17 min	24 hr	2:1	Tan	210 mL	3031524	3029937 3029936	3001173	
LORD Signlok 810S Medium	Low Read-Through Powder Coating* Right-Sized Packaging Extended Shelf Life Glass Beads for Precision Bondline UV Resistant	ACM Panel Bonding Thin Gauge Material Bonding Glossy Material Bonding Flexible Material Bonding	8-12 min	20-25 min	24 hr	2:1	Dark Grey	210 mL	3031523	3029937 3029936	3001173	
LORD Signlok 204 Fast	Right-Sized Packaging Limited Cold Impact Resistance Limited High Impact Resistance	Replace Welding and Mechanical Fastening	4-6 min	22-26 min	24 hr	2:1	Tan	225 mL	3028420	3029937 3029936	3001173	
LORD 403/19 Fast	Powder Coating* UV & Corrosion Resistance for Outdoor Assemblies Minimal Surface Preparation	Replace Welding and Mechanical Fastening Channel Letter Assembly Metal Box Frame Assembly Corner Key Installation Bond and Seal in One Step Seal of Light Leaks	2-4 min	4-6 min	24 hr	4:1	Tan	50 mL CX (404 mL)	3021003 3021004	3001112 3004487	3031281 3001173	3031906 N/A (4:1)
LORD 406/19 Medium			6-10 min	12-17 min	24 hr	4:1	Tan	50 mL 415 mL CX (404 mL)	3021024 3032029 3021011	3001112 3018302 3004487	3031281 3032007 3001173	3031906 N/A (4:1) N/A (4:1)
LORD 406/19GB Medium	Powder Coating* UV & Corrosion Resistance for Outdoor Assemblies Minimal Surface Preparation Glass Beads for Precision Bondline	Replace Welding and Mechanical Fastening Channel Letter Assembly Metal Box Frame Assembly Corner Key Installation Bond and Seal in One Step Seal of Light Leaks	6-10 min	12-17 min	24 hr	4:1	Tan	50 mL 415 mL CX (404 mL)	3021025 3032003 3031478	3001112 3018302 3004487	3031281 3032007 3001173	3031906 N/A (4:1) N/A (4:1)
LORD 7610DTM Slow	Single-Component Easy to Use Bonds to Wide Variety of Materials UV Resistant	General Purpose Adhesive & Seam Sealer Seals Light Leaks Sealer for Channel Letter Cans Water Intrusion Barrier or Sealant	25-35 min	6-12 hr	1-5 days	1 Part	White	1/10 gal/ cart	3029094	3023577	3015312	

*Refer to complete instructions for Powder Coating after Bonding with LORD Acrylic Adhesives (TT3068).

Plastic Bonding Adhesives

Technical Data reported at 70-77°F (21-25°C).

Product	Features	Applications	Technical Data							Accessories		
			Work Time	Handling Time	Full Cure	Mix Ratio	Color	Size	Part #	Dispensing Gun	Mixing Tip	Plunger
LORD 7550 A/C Fast	Optically Clear Adhesive for Non-Structural Assemblies UV Resistant Self-leveling	Trimcap Letter Track Aesthetic Assemblies Potting, Encapsulation	3-5 min	1 hr	72 hr	1:1	Optically Clear	50 mL	3003953	3001112	3031303	3009588
Signlok 7550 Fast								210 mL	3031702	3029937 3029936	3001173	
LORD 7542 A/B Medium	Bonds plastics, FRP & SMC with Minimal Surface Prep Odorless Non-flammable	Bonding Plastics Bonding Foam, Foam Board, Natural Materials Cross Bonding** Metal to Engineered Plastics for Larger, Outdoor Assemblies subject to Thermal Expansion	4-7 min	1-2 hr	24 hr	1:1	Brown	50 mL	3003884	3001112	3031303	3009588
LORD 7556 A/C Medium	Translucent Adhesive for Wide Range of Plastics, Polycarbonate and Prefinished Metals Non-sag Fast Set Non-yellowing	Aesthetic Assemblies Decorative Parts	4-6 min @ 90°F (32°C)	1.5-2.3 hr @ 73°F (23°C)	24 hr	1:1	Translucent	400 mL	3018335	3004277 3027081	3001178	

**Refer to cross bonding chart for specific materials.

Cross Bonding Adhesives

Technical Data reported at 70-77°F (21-25°C).

Product	Features	Applications	Technical Data							Accessories		
			Work Time	Handling Time	Full Cure	Mix Ratio	Color	Size	Part #	Dispensing Gun	Mixing Tip	Plunger
LORD Signlok 810S Medium	Flexible UV Resistant Bonds to Bare Metal	Cross Bonding** Metal to Engineered Plastics for Larger, Outdoor Assemblies subject to Thermal Expansion	8-12 min	20-25 min	24 hr	2:1	Dark Grey	210 mL	3031523	3029937	3001173	
LORD 7542 A/B Medium	Bonds plastics, FRP & SMC with Minimal Surface Prep Odorless Non-flammable	Cross Bonding** Prefinished Metals to Engineered Plastics for Larger, Outdoor Assemblies	4-7 min	1-2 hr	24 hr	1:1	Brown	50 mL	3003884	3001112	3031303	3009588
LORD 7610DTM Slow	Single-Component Easy to Use Bonds to Wide Variety of Materials UV Resistant	General Purpose Adhesive & Seam Sealer Seals Light Leaks Sealer for Channel Letter Cans Water Intrusion Barrier or Sealant	25-35 min	6-12 hr	1-5 days	1 Part	White	1/10 gal/ cart	3029094	3018079	3015312	

**Refer to cross bonding chart for specific materials.

Specialty Adhesives/Surface Modifier

Technical Data reported at 70-77°F (21-25°C).

Product	Features	Applications	Technical Data							Accessories		
			Work Time	Handling Time	Full Cure	Mix Ratio	Color	Size	Part #	Dispensing Gun	Mixing Tip	Plunger
LORD 7610DTM Slow	Single-Component Paintable Easy to Use Bonds to Wide Variety of Materials UV Resistant	General Purpose Adhesive & Seam Sealer Seals Light Leaks Sealer for Channel Letter Cans Water Intrusion Barrier or Sealant	25-35 min	6-12 hr	1-5 days	1 Part	Bright White	1/10 gal/ cart	3029094	3023577	3015312	
LORD 7650 Slow	Single-Component High Tack Low Viscosity	Laminating Foam & Paper Board	15-30 min	24 hr	1-5 days	1 Part	Honey	1/2 pt 1 gal	3003977 3003978			
LORD 320/322 Slow	Rubber Toughened Heat Resistant High Strength	Studs Bolting Concrete Potting Gap Filling	20-40 min	2-4 hr	24 hr	1:1	Grey	50 mL	3003632	3001112	3031303	3009588
LORD 360 Fast	Fast Cure at Room Temperature Non-Sag on Vertical Surfaces	Studs Bolting to Concrete & Foam	2-4 min	5-10 min	24 hr	1:1	Tan	50 mL	3003643	3001112	3031303	3009588
LORD AP-134 Surface Modifier	One-coat adhesion enhancer/surface modifier	Promotes adhesion to glass, polished stone, tile, ceramic	Hydrolyze in moist air 1-2 hr @ 70-90°F (21-32°C) prior to adhesive application			1 part	Slight Yellow	1 gal	3004049			

Cross Bonding with LORD Sign Assembly Adhesives

	Trade Name ‡	Surface Preparation	Aluminum/Steel*	Prefinished Metal & Aluminum Composite Material (ACM)	Polycarbonate*	Acrylic*	Urethane Foam	PVC Foam Board	Ceramic/Stone	Wood
Aluminum/Steel*		Solvent wipe with isopropyl alcohol	Signlok 4xx Signlok 810S Signlok 204 4xx/19	Signlok 4xx Signlok 810S Signlok 204 4xx/19	Contact Parker Lord	Contact Parker Lord	7610DTM** 7542**	Signlok 4XX Signlok 810S Signlok 204 4xx/19	320/322 †	7610DTM 320/322 †
Stainless Steel		Solvent wipe with isopropyl alcohol, mechanically abrade with 80-grit paper or grinder, wipe with IPA to remove sanding dust	Signlok 4xx Signlok 810S Signlok 204 4xx/19	Signlok 4xx Signlok 810S Signlok 204 4xx/19	Contact Parker Lord	Contact Parker Lord	7610DTM** 7542**	Signlok 4xx Signlok 810S Signlok 204 4xx/19	320/322 †	7610DTM 320/322 †
Prefinished Metal & Aluminum Composite Material (ACM)	AlumaCorr™, NuAlum™ Poly-Metal™ Alumalite™, DiBond® Econolite™, MAXX™ Alucobond® Anodized Alucobond®	Factory painted metal or ACM panels: solvent wipe Shop painted or other finishes: remove by sanding prior to bonding	Signlok 4xx Signlok 810S Signlok 204 4xx/19	Signlok 810S Signlok 4xx Signlok 204 4xx/19	Signlok 4xx Signlok 204 4xx/19 7542 7610DTM	7542 7610DTM ⁿ	7542 7650 7610DTM	Signlok 4xx Signlok 810S Signlok 204 4xx/19 7542 7650 7610DTM	320/322 †	7542 7650 7610DTM
Polycarbonate*	Lexan® Tuffak®	Solvent wipe with isopropyl alcohol	Contact LORD	7542 7610DTM	Signlok 4xx Signlok 204 4xx/19 7542 7610DTM	7542 7610DTM	7542 7650 7610DTM	7542 7650 7610DTM	7610DTM ⁿ	7542 7650 7610DTM
Acrylic*	Acrylite® Acrysteel® IGP Duraplex® Optix®SG Implex®, Plexiglas®G	Scuff with scuff pad or 120-grit paper, solvent wipe with isopropyl alcohol	Contact LORD	7542 7610DTM 7650	7542 7610DTM 7550 ⁿ Signlok 7550 ⁿ 7556	7542 7610DTM 7550 ⁿ Signlok 7550 ⁿ	7542 7610DTM 7550 ⁿ Signlok 7550 ⁿ 7556	7542 7650 7610DTM	7610DTM ⁿ	7542 7650 7610DTM
TrimCap	Jewelite® SignATrim™	Scuff with scuff pad or 120-grit paper, solvent wipe with isopropyl alcohol	N/A	7550 ⁿ Signlok 7550 ⁿ 7542 7556	7550 ⁿ Signlok 7550 ⁿ 7556	7550 ⁿ Signlok 7550 ⁿ 7556	7542 7550 ⁿ Signlok 7550 ⁿ 7556 7610DTM	7542 7650 7610DTM		7542 7550 ⁿ Signlok 7550 ⁿ 7556
Urethane Foam	Precision Board Last-A-Foam® Sign Foam 3® Design Board® CORAFOAM®	Blow off surface with clean air or wipe with clean dry cloth	7650 7610DTM 7542	7542 7650 7610DTM	7542 7650 7610DTM	7542 7650 7610DTM	7542 7610DTM	7542 7650 7610DTM	7542 7610DTM	7542 7650 7610DTM
PVC Foam Board	Komatex® Sintra®	Scuff with scuff pad or 120-grit paper, solvent wipe with isopropyl alcohol	Signlok 4xx Signlok 810S Signlok 204 4xx/19	Signlok 4xx Signlok 810S Signlok 204 4xx/19 7542 7650 7610DTM	7542 7650 7610DTM	7452 7650 7610DTM	7542 7610DTM	Signlok 4xx Signlok 810S Signlok 204 4xx/19 7542 7650 7610DTM	7542 7610DTM ⁿ	7542 7650 7610DTM
Paper/Foam Board	Foam-X® Recovery Foam-Cor®	Wipe with clean dry cloth	7542** 7610DTM 7650**	7542 7650	7542 7610DTM	7542	7542 7610DTM	7542 7610DTM	7542 7610DTM	7542 7610DTM
PETG Sheet	Spectar™ PETG	Solvent wipe with isopropyl alcohol	7542** Signlok 4xx Signlok 810S Signlok 204 4xx/19	7542** Signlok 4xx Signlok 810S Signlok 204 4xx/19	7542 7610DTM	7542	7542 7610DTM	7542 7610DTM	7542 7610DTM	7542 7610DTM
Polystyrene Foam Board	Gatorfoam® Gatorblanks® Gatorplast®	Wipe with clean dry cloth	Signlok 4xx (N/A Gatorblanks) Signlok 810S (N/A Gatorblanks) Signlok 204	Signlok 4xx Signlok 810S Signlok 204 4xx/19	7542 7550 ⁿ Signlok 7550 ⁿ 7556	7542 7610DTM 7650	7542 7610DTM 7650	7542 7610DTM	7542 7610DTM	7542 7610DTM
	Ultra	Solvent wipe with isopropyl alcohol	4xx/19 (N/A Gatorblanks) 7542** 7610DTM 7650**	4xx/19 7542 7610DTM 7650						
Vinyl Laminate	White-Wood®	Wipe with clean dry cloth, scuff	Signlok 4xx Signlok 810S Signlok 204	Signlok 4xx Signlok 810S Signlok 204 4xx/19	7542 7650	7542	7542 7610DTM 7650	7542 7610DTM	7542 7610DTM	7542 7610DTM
	Maxx-Board®	Solvent wipe with isopropyl alcohol	4xx/19 7542** 7610DTM 7650	4xx/19 7542** 7610DTM 7650						
Wood		Wipe with clean dry cloth	320/322 †	7542 320/322 † 7650	7542 7650 7610DTM	7542 7650 7610DTM	7542 7610DTM	7542 7650 7610DTM	7542 7610DTM ⁿ 320/322	7542 320/322 7610DTM 7650
Ceramic/Stone		Porous: Wipe with clean dry cloth Non-porous (Smooth/polished): LORD AP- 134 Adhesion Enhancer/ Surface Modifier required	320/322 †	320/322 †	7542 7610DTM ⁿ	7542 7610DTM ⁿ	7542 7610DTM ⁿ	7610DTM ⁿ	320/322	7542 7610DTM ⁿ
Cured Concrete		Wipe with clean dry cloth	7610DTM 320/322 †	320/322 † 360 7610DTM	7542 7610DTM	7542 7610DTM			320/322	7610DTM 320/322
Glass**		LORD AP- 134 Adhesion Enhancer/ Surface Modifier required	Signlok 4xx Signlok 204 4xx/19	Signlok 4xx Signlok 204 4xx/19 7542		7542 7610DTM	7610DTM	7610DTM	7542 7610DTM	7542 7610DTM

xx Represents numbers for the family of adhesive to be utilized. Contact Parker Lord Customer Support Center, 877 275 5673.
‡ All substrate Trade Names are trademarks or registered trademarks of the substrate supplier.
* Coefficient of thermal expansion is a major consideration when cross-bonding these substrates. Acrylic adhesives should not be used to attach large thermoplastic parts due to the differences in thermal expansion.
** Additional surface preparation recommended: Metals should be painted or primed. Glass, Ceramic and Stone should be primed with LORD AP- 134 Adhesion Enhancer/Surface Modifier to promote adhesion, 120 minutes to hydrolyze.
† Prepare metal by scuffing/abrading followed by a solvent wipe.
ⁿ For non-structural bonding (assemblies where adhesive is used for aesthetic attachment in minimum stress areas).

Signlok 403, Signlok 406, Signlok 810S, Signlok 204, LORD 4xx/19 and LORD 7542 are UL recognized.

Each substrate and adhesive should be tested for the specific use in which it will be expected to perform. The information reported here is from laboratory studies and is intended only to provide general information regarding the ability of material to be bonded with LORD® Structural Adhesives.

Dispensing Equipment

					
Container Size	210 mL	50 mL	CX (404 mL)	415 mL	LORD 7610DTM Cartridge
Manual Dispensing Gun	3029937	3001112	3004487	3018302	3018079
Plunger (2:1)	–	3009588 (one 1:1/2:1 plunger ships with gun)	–	–	–
Plunger (4:1)	–	3031906*	–	–	–
Pneumatic Dispensing Gun	3029936	–	–	3032023	–
Mixing Tip	3001173	3031303 (1:1); 3031281 (4:1)	3001173	3032007	Nozzle = 3015312

*4:1 plunger required for LORD 400 Series 50 mL cartridges.