

LORD® SIGNLOK™ ADHESIVES

LORD® Signlok™ adhesives control costs, reduce waste, and enhance productivity and performance by replacing welding, riveting and other traditional mechanical fasteners.

Features & Benefits

LORD Signlok 403, 406, 810S and 204

- 90% full cure within one hour
- Available in a range of work times accommodating a variety of process requirements
- Utilizes one set of dispensing equipment for a variety of products and jobs
- 18 month shelf life*; reduces cost of discarding out-of-date material
- Contains glass beads** to enable precision bondline control and manage waste

LORD Signlok 7550

- Flexible, fast work time urethane
- Clear product for letter track and trimcap applications and other non-structural plastic bonding
- Right-size packaging for larger jobs

*Excluding Signlok 810S and Signlok 204

**Excluding Signlok 204



Product	Part #	Features	Applications
LORD Signlok 403 Fast	3031522	Right-Sized Packaging Powder Coating	Replace Welding and Mechanical Fastening Channel Letter Assembly
LORD Signlok 406 Medium	3031524	Extended Shelf Life Glass Beads for Precision Bondline UV & Corrosion Resistance for Outdoor Assemblies Minimal Surface Preparation	Metal Box Frame Assembly Corner Key Installation Bond and Seal in One Step Seal for Light Leaks
LORD Signlok 810S Medium	3031523	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
LORD Signlok 204 Medium	3028420	Right-Sized Packaging High Bond Strength to most Metals Trusted Performance and Value Priced	Replace Welding and Mechanical Fastening
LORD Signlok 7550 Fast	3031702	Optically Clear Adhesive for Non-Structural Assemblies UV Resistant Self-leveling	Trimcap Aesthetic Assemblies Letter Track Potting, Encapsulation

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.



Product	Technical Data*						Accessories	
	Work Time	Handling Time	Full Cure	Mix Ratio	Color	Size	Dispensing Gun	Mixing Tip
LORD Signlok 403	2-4 minutes	4-6 minutes	24 hours	2:1	Tan	210 mL	3029937 3029936	3001173
LORD Signlok 406	6-10 minutes	12-17 minutes	24 hours	2:1	Tan	210 mL	3029937 3029936	3001173
LORD Signlok 810S	8-12 minutes	20-25 minutes	24 hours	2:1	Dark Grey	210 mL	3029937 3029936	3001173
LORD Signlok 204	4-6 minutes	22-26 minutes	24 hours	2:1	Tan	210 mL	3029937 3029936	3001173
LORD Signlok 7550	3-5 minutes	1 hour	72 hours	1:1	Optically Clear	210 mL	3029937 3029936	3001173

*Technical data reported at 70-77°F (21-25°C). Data is typical and not to be used for specification purposes.



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