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Lord Adhesives for Metal Assembly

Products	Applications	Working Time*	Handling Time*	Full Strength*	Viscosity	Comments
ACRYLIC ADHESIVES						
LORD 201/19	Bare metals, plastics and composites.	5-8 minutes	Fast, 12-16 minutes	2 hours Heat cure typically not recommended	Easy to dispense, Self-leveling	Minimal surface preparation, fast cure, good environmental resistance.
LORD 202/19	Bare metals, plastics and composites.	1-2 minutes	Very fast, 2-4 minutes	1 hour Heat cure typically not recommended	Easy to dispense, Self-leveling	Very fast curing, minimal surface preparation, good environmental resistance.
LORD 204/19	Bare metals, plastics and composites.	6-8 minutes	Fast, 12-16 minutes	2 hours Heat cure typically not recommended	Easy to dispense, Non-sag	Minimal surface preparation, fast cure, good environmental resistance.
LORD 403/19	Bare metals, plastics and composites.	2-4 minutes	Very fast, 4-6 minutes	1 hour Heat cure typically not recommended	Easy to dispense, Non-sag	High impact and peel resistance, especially in low temperature environments.
LORD 406/19	Bare metals, plastics and composites.	6-10 minutes	Fast, 12-17 minutes	2 hours Heat cure typically not recommended	Easy to dispense, Non-sag	High impact and peel resistance, especially in low temperature environments. Greater work time than Lord 403.
LORD 410/19	Bare metals, plastics and composites.	20-45 minutes	Medium, 1-2 hours	8-10 hours Heat cure typically not recommended	Easy to dispense, Non-sag	High impact and peel resistance, especially in low temperature environments. Greater work time than Lord 406.
EPOXY ADHESIVES						
LORD 305	Composites, prepared metals, wood and prepared rubber.	1-2 hours	Long, 8-16 hours	24-48 hours. Cure can be accelerated with heat. See Product Information Sheet.	Self-leveling	User friendly, long open time epoxy. Excellent environmental resistance.
LORD 310 A/B	Composites, prepared metals, wood and prepared rubber.	30-60 minutes	Medium/Long, 6-8 hours	24 hours. Cure can be accelerated with heat. See Product Information Sheet.	Non-sag	Excellent environmental resistance, 400°F heat resistance. Long work life.
LORD 320/322	Composites, prepared metals, wood and prepared rubber.	10-20 minutes	Medium, 2-4 hours	24 hours. Cure can be accelerated with heat. See Product Information Sheet.	Non-sag	Toughened epoxy with 400°F heat resistance. Quicker curing than 310 A/B.
URETHANE ADHESIVES						
LORD 7545	Composites and prepared metals.	Dependent on curative. See Product Information Sheet.	Dependent on curative. See Product Information Sheet.	Dependent on curative. See Product Information Sheet.	Non-sag	Equal-mix, paste system designed for cartridge dispensing. Designed to bond FRP and SMC. Appropriate for prepared metals and cross bonding.
LORD 7546	Large composite and prepared metal parts that require additional work time.	Dependent on curative. See Product Information Sheet.	Dependent on curative. See Product Information Sheet.	Dependent on curative. See Product Information Sheet.	Non-sag	Equal-mix, two-component adhesive with long open times at elevated temperatures and large bead diameters. Designed for bonding FRP, various thermoplastics and marine plywood.
LORD 7610	Composites and prepared metals; other sealing applications.	30-60 minutes	6-12 hours	72 hours	Non-sag	Single component sealant/adhesive.
CYANOACRYLATE ADHESIVES						
LORD CA7000	Bare metals and plastics to metal.	Several seconds	Very fast (20-25 seconds)	24 hours	Thin liquid	
LORD CA Gel	Non-structural composites, metals and trims	Several seconds	Very fast (12-50 seconds)	24 hours	Non-sag gel	Single component gel; gap filling.

* working time, handling time, and full cure are typical at 75°F (24°C)

** may be accelerated with heat