

Supplied by

AMBERCOMPOSITES

7542

Equal-Mix, Urethane Adhesive

Applications

Lord 7542 is an equal-mix two component urethane adhesive system. Lord 7542 adhesive bonds FRP, SMC and other plastics with little surface preparation. This adhesive will also bond primed metals.

Features and Benefits

Nonflammable - Lord 7542 does not require expensive explosion-proof equipment and it will not deplete the ozone.

Environmentally and Chemically Resistant - Lord 7542 adhesive resists sunlight, weathering, humidity, and salt spray. This adhesive is solvent resistant once it has cured. Painting and most cleaning processes do not affect bond strength.

Surface Preparation

Remove dirt, oil contamination and loose particles prior application. For most plastics, cleaning the surface with a dry rag wipe or a rag dampened with solvent will suffice. Prime or grit blast metal surfaces, then follow with a solvent wash for optimum bond performance.

Application

This adhesive is designed for use with Lord-Pak™ hand held cartridges or automated meter/mix/dispense equipment. The minimum recommended static mixer length is 24 elements long. Purge time for Lord 7542 A/B is four to five minutes at 75°F (24°C).

Typical Properties of Lord 7542 A/B/C/D/E Adhesive*

	7542A	7542B	7542C	7542D	7542E
Appearance	Dark Brown	Tan	Tan	Tan	Tan
Consistency	Gravity-Feed Liquid	Gravity-Feed Liquid	Gravity-Feed Liquid	Gravity-Feed Liquid	Gravity-Feed Liquid
Viscosity (cps) @ 77°F (25°C)	1,700-3,600	5,000-12,000	5,000-12,000	5,000-12,000	5,000-12,000
Density					
lbs/gal	11.5-11.7	10.3-10.6	10.3-10.6	10.3-10.6	10.3-10.6
g/cc	1.40 ±.1	1.25 ±.1	1.25 ±.1	1.25 ±.1	1.25 ±.1
% Solids by Weight	100	100	100	100	100
Flash Point (closed cup)	>200°F (>93°C)	>200°F (>93°C)	>200°F (>93°C)	>200°F (>93°C)	>200°F (>93°C)
Mix Ratio by Volume	1	1	1	1	1
Shelf Life, from date of shipment @ 70°-80°F (21°-27°C), unopened container.	6 Months	6 Months	6 Months	6 Months	6 months

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

Application Properties of Lord 7542 Adhesive*				
	7542 A/B	7542 A/C	7542 A/D	7542 A/E
Working Time @ 75°F (24°C)	5 1/2 -7 min	11-15 min	20-30 min	60 min
Handling Strength @ 75°F (24°C)	1 hour	2 hr	3 hr	4 hours
@ 140°F (60°C)	6-8 min	-	-	-
@ 200°F (93°C)	1.5 -2 min	-	-	-
Full Strength @ 75°F (24°C)	12 hr	24 hr	24 hr	24 hr

*Given a 1/2 inch diameter bead.

Storage

Lord 7542 is moisture sensitive. For maximum shelf life, cap with dry nitrogen after opening. Shelf life of Lord 7542 adhesive is six months from date of shipment when stored at 40° to 80°F (4° to 27°C) in original, unopened containers.

Cautionary Information

Before using this or any other Lord product refer to the Material Safety Data Sheet (MSDS) and label for safe use and handling.

Supplied by

AMBERCOMPOSITES

94 Station Road, Langley Mill
 Nottingham, NG16 4BP United Kingdom
 T: +44 (0)1773 530899 F: +44 (0)1773 768687
 E: sales@ambercomposites.com
 www.ambercomposites.com

Values stated in this bulletin represent typical values as not all tests are run on each lot of material produced. For formalized product specifications for specific product end uses, contact the Customer Service Department.

Information provided herein is based upon tests believed to be reliable. Inasmuch as Lord Corporation has no control over the manner in which others may use this information, it does not guarantee the results to be obtained. In addition, Lord Corporation does not guarantee the performance of the product or the results obtained from the use of the product or this information where the product has been repackaged by any third party including but not limited to any product end user. Nor does the company make any express or implied warranty of merchantability, or fitness for a particular purpose concerning the effects or results of such use.

Lord is a registered trademark of Lord Techmark Inc., a subsidiary of Lord Corporation.
 Printed in USA ©1997, Lord Corporation DS7542AE 3/98

For additional information, contact Lord Corporation at: 814/868-3611 extension 3277, FAX: 814/864-3452 or write: **Lord Corporation, Chemical Products, 2000 West Grandview Blvd., P.O. Box 10038, Erie, PA 16514-0038**

LORD Chemical Products