LORD® 7542 Urethane Adhesive

Description
LORD® 7542 adhesive is an equal-mix, two-component urethane adhesive system used to bond FRP, SMC and other plastics with little surface preparation. This adhesive will also bond primed metals. LORD 7542 adhesive system is available in a range of working times to accommodate a wide variety of process requirements.

Features and Benefits
- **Non-Flammable** – does not require explosion-proof equipment.
- **Environmentally Friendly** – does not contain ozone depleting chemicals.
- **Environmentally Resistant** – resists sunlight, weathering, humidity and salt spray.
- **Chemically Resistant** – solvent resistant when cured. Painting and most cleaning processes do not affect bond strength.

Application
- **Surface Preparation** – Surfaces should be free of grease, dirt and other contaminants. For plastics, clean the surface with a dry rag wipe or a rag dampened with solvent. For metals, prime or grit blast the surface, then solvent wash for optimum bond performance.
- **Mixing** – Mix LORD 7542-A resin with the appropriate curative at a 1:1 ratio, by volume. Handheld cartridges will automatically dispense the correct volumetric ratio of each component. Once mixed, the adhesive cures rapidly.
- **Applying** – Apply adhesive using handheld cartridges or automatic meter/mix/dispense equipment.
  - **Handheld Cartridges**
    1. Load the cartridge into the applicator gun and remove the end caps.
    2. Level the plungers by expelling a small amount of adhesive to ensure both sides are level.
    3. Attach mixing tip and expel a mixer’s length of adhesive.
    4. Apply adhesive to substrate and mate the parts within the working time of the adhesive. Clamp in position until adhesive reaches handling strength.

Typical Properties*

<table>
<thead>
<tr>
<th></th>
<th>7542-A</th>
<th>7542-B</th>
<th>7542-C</th>
<th>7542-D</th>
<th>7542-E</th>
</tr>
</thead>
<tbody>
<tr>
<td>Appearance</td>
<td>Dark Brown Liquid</td>
<td>Tan Liquid</td>
<td>Tan Liquid</td>
<td>Tan Liquid</td>
<td>Tan Liquid</td>
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<tr>
<td>Viscosity, cP @ 77°F (25°C)</td>
<td>1500-4500</td>
<td>7000-14,000</td>
<td>7000-14,000</td>
<td>5000-14,000</td>
<td>5000-18,000</td>
</tr>
<tr>
<td>Density</td>
<td>11.45-11.75 (1372-1408)</td>
<td>10.3-10.6 (1234-1270)</td>
<td>10.3-10.6 (1234-1270)</td>
<td>10.3-10.6 (1234-1270)</td>
<td>10.3-10.6 (1234-1270)</td>
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<tr>
<td>Flash Point (Closed Cup), °F (°C)</td>
<td>&gt;200 (&gt;93)</td>
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<td>&gt;200 (&gt;93)</td>
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*Data is typical and not to be used for specification purposes.
LORD provides valuable expertise in adhesives and coatings, vibration and motion control, and magnetically responsive technologies. Our people work in collaboration with our customers to help them increase the value of their products. Innovative and responsive in an ever-changing marketplace, we are focused on providing solutions for our customers worldwide . . . Ask Us How.

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