



# 206

## Increased Working Time, Acrylic Adhesive for Metals and Plastics

### Description

Lord® 206 is a long working time acrylic which provides excellent adhesion to minimally prepared metals and plastics.

### Features and Benefits

**Convenient Cure Properties** - achieves ultimate strength at room temperature; handling strength in 45 minutes. Working time of 12 - 14 minutes reduces adhesive waste.

**Cost Efficient** - requires minimal substrate preparation, thus reducing labor cost. Ease of application reduces re-work cost. Less labor-intensive than welding.

**Environmental and Chemical Resistance** - thermo-setting; resists dilute acids, alkalis, solvents, greases, oils, moisture, and weathering. Performs at temperatures from -40°C to 149°C (-40°F to 300°F). Excellent UV exposure resistance.

**Versatile** - allows for use with both Mix-In and No-Mix accelerators. Insensitive to minor deviations from correct mix ratio.

**Typical Properties\* of Lord 206 Acrylic Adhesive**

	Lord 206	Accelerator 4	Accelerator 17	Accelerator 19
Appearance	Off-white liquid	Slightly hazy to clear amber liquid	Off-white to slightly yellow liquid	Off-white paste
Viscosity, cP Brookfield @ 25°C (77°F)	20,000 - 80,000 (Spindle 7 at 20 rpm HAT)	10 (Spindle 1 at 30 rpm LVT)	10,000 - 100,000 (Spindle 4 at 12 rpm LVT)	150,000 - 450,000 (T-bar @ 10 rpm)
Density kg/m <sup>3</sup> lb/gal	1019 - 1043 8.5 - 8.7	1222 - 1246 10.2 - 10.4	1162 - 1210 9.7 - 10.1	1426 - 1546 11.9 - 12.9
Flash Point (Closed Cup)	19°C (66°F)	>93°C (>200°F)	>93°C (>200°F)	>93°C (>200°F)
Working Time of Mix System at 24°C (75°F)	12 - 14 Minutes	—	—	—
Handleable Bonds at 24°C (75°F)	45 Minutes	—	—	—
90 Percent of Ultimate Strength	2 Hours	—	—	—
Full Properties	24 Hours	—	—	—
Mix Ratio by Volume	10 Parts	No-Mix	1 Part	5 Parts
Shelf Life from date of shipment, 24°C (75°F), unopened container	6 Months	6 Months	6 Months	6 Months

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

## Using Lord 206 Adhesive

### Substrate Preparation

Metals should be free of grease, loose contamination or poorly adhering oxides. Normal amounts of mill oils and drawing compounds usually do not present problems in adhesion. Some engineering plastics should be cleaned, primed or abraded for optimum performance, but this must be determined for each material.

**No-Mix System** - Application may be made by spraying, rolling, or brushing Lord Accelerator 4 onto one or both surfaces. Optimum bond line thickness is 127 - 254 microns (5 - 10 mils) of acrylic adhesive. If the bond line is less than 635 microns (25 mils) thick, application to one substrate is usually sufficient. For bond lines of 635 - 1270 microns (25 - 50 mils), both substrates should be coated. Adhesive may be applied as soon as the accelerator is dry, one to three minutes at 24°C (75°F) or up to several weeks thereafter. Parts stored after coating should be kept in a clean, dry area without exposure to ultraviolet light or temperatures in excess of 24°C (75°F).

Refer to Procedure I illustrations for easy-to-follow application instructions using the No-Mix system.

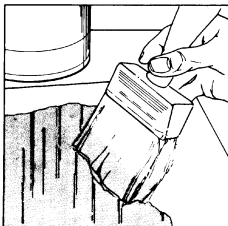
**Mix-In System** - Mix Lord 206 resin with the proper amount of Mix-In accelerator. Working time of the mixed system is approximately 12 to 14 minutes at 24°C (75°F). A handleable bond will develop in 45 minutes.

Procedure II illustrates instructions for using the Mix-In system.

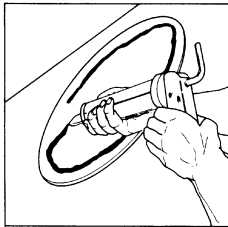
**Dispense Equipment** - Contact your Lord representative for recommended No-Mix and Mix-In dispense equipment. When using such equipment, all wetted parts must be made of stainless steel, and all hoses should be steel braided Teflon.

**Cure** - Adhesive cure will begin on contact with the accelerator. Fixture parts as soon as possible after adhesive application, and in less than 10 minutes.

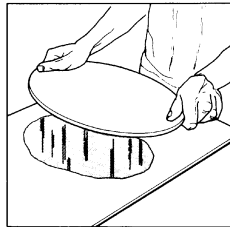
### Procedure I - No-Mix System



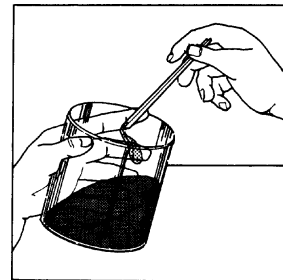
1. Apply accelerator.



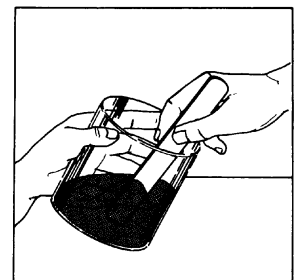
2. Apply adhesive.



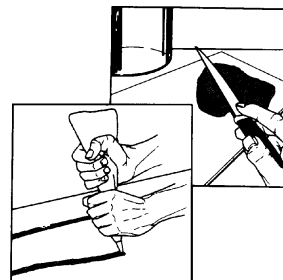
3. Assemble components.



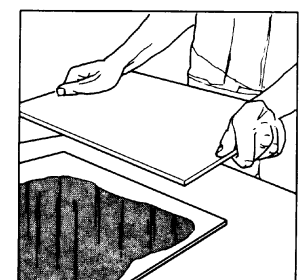
1. Pour accelerator into container containing adhesive.



2. Mix accelerator and adhesive.



3. Apply accelerator-adhesive mixture.



4. Assemble components.

## Shipping and Storage

Ship and store Lord acrylic adhesives at temperatures below 27°C (80°F). Temperatures greater than 32°C (90°F) shorten the stability of Lord acrylic adhesive and accelerators. For maximum shelf life, store at 4°C - 10°C (40°F - 50°F).

## Cautionary Information

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

*For industrial/commercial use only.* Must be applied by trained personnel only. Not to be used in household applications. Not for consumer use.

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.

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The logo for LORD, featuring the word "LORD" in a bold, black, sans-serif font. The letter "O" is stylized with a white circle inside it.