

PRODUCT INFORMATION



7520

Two-Pack, Equal Mix, Urethane Adhesive

Description

Lord® 7520 is a two-component, equal mix, urethane adhesive.

Lord 7520 adhesive offers structural integrity to assemblies made of wood, plastic (Hytrel®), metals (primed and nonprimed), foams (open and closed cell) and elastomers.

Features and Benefits

Contains No Solvent - 100% solids, non-flammable.

Variable Cure - cures completely at room temperature or more rapidly with modest heat.

Impact Resistant - provides impact resistance at temperatures ranging from -34°C to 115°C (-30°F to 240°F)

Versatile - bonds a wide variety of substrates.

Environmental Resistance - resists sunlight, weathering, humidity, and salt spray.

Surface Preparation

Prior to bonding, parts should be clean, dry and free from oil contamination. Cleaning with an organic solvent is usually sufficient. Abrasion of bond surfaces is not required in most cases; however, adhesion is often enhanced when the substrate surface is mechanically prepared.

Treat rubber type elastomers with Lord 7701 surface treatment prior to bonding. Urethane and Hytrel type elastomers can be cleaned with a ketone solvent or Lord 7701 surface treatment prior to bonding.

Glass and ceramic surfaces that have been primed with Lord AP134 primer exhibit superior environmental resistance. Cured rubber should first be primed with Lord 7701 surface treatment. Prime metal surfaces with Lord 7714 primer.

Mixing

Mix Lord 7520 resin with curative at a 1:1 ratio, by volume. Lord-Pak™ cartridges will automatically mix and dispense the proper amount for each application.

Table 1: Typical Properties* of Lord 7520 Adhesive

	Lord 7520A	Lord 7520B
Appearance	Brown	Off-white
Viscosity, cP LVT #4 @ 30 rpm, 25°C (77°F)	4,000 - 18,000	Thixotropic paste
Density kg/m ³ lb/gal	1210 10.1	1055 8.8
Percent Solids	100%	100%
Flash Point (closed cup)	>93°C (>200°F)	>93°C (>200°F)
Mix Ratio by volume by weight	1 1.2	1 1
Shelf Life, from date of shipment unopened container, storage @ 21°C - 27°C (70°F - 80°F)	6 months	6 months

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

Note: Lord 7520A is moisture sensitive. The shelf life of 7520A can be maintained if the head space of the can is capped with N₂ each time the can is opened.

Table 2: Typical Strength of Lord 7520 Adhesive*

	24 Hrs.		1 Wk. @ RT		1 Wk. in Salt Spray	
	MPa	psi	MPa	psi	MPa	psi
**SAE1010 CRS	15.1	2200	14.4	2100	10.3	1500
**Stainless Steel	17.2	2500	15.8	2300	9.6	1400
**Al 2024-T3	10.3	1500	13.1	1900	8.9	1300
**Al 6061-T6	11.7	1700	12.4	1800	6.5	950
General Purpose ABS	3.4	500 SB	3.3	480	3.7	540
Hi Impact ABS	4.1	600 SB	4.5	650 SB	4.5	648 SB

*Not to be used for specification purposes.

*All metals and FRP were grit blasted prior to bonding. Rubber treated with Lord 7701 surface treatment.

SB - Stock Break
psi - pound per square inch

Application

The mixed adhesive is somewhat non-sagging when applied in small ~3.2 mm (~1/8") diameter beads. Applying larger diameter beads and warmer application temperatures will cause the mixed adhesive to flow.

Curing

Lord 7520 adhesive has a working time of approximately 10 - 15 minutes. Handling strength will develop in 3 hours on most substrates, with full properties in 18 - 24 hours.

Clean Up

Remove excess adhesive from the bonded assemblies, mixing and application equipment before the adhesive cures. Isopropyl alcohol and other organic solvents are good cleaning aids.

Packaging

- 1/2 Pint Container (0.24 Liter)
- 1 Gallon Container (3.8 Liter)
- 5 Gallon Pail (19 Liter)
- 55 Gallon Container (208 Liter)
- Convenient Cartridges

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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Storage

Lord 7520 adhesive is moisture sensitive. For maximum shelf life, cap with dry nitrogen after opening. Shelf life of Lord 7520 adhesive is 6 months from date of shipment when stored at 21°C - 27°C (70°F - 80°F) in the original, unopened container.

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.

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