



7540

Equal-Mix, Urethane Adhesive

Description

Lord® 7540 is a two-component, equal-mix urethane adhesive used to bond polycarbonate and other plastic substrates. It cures at room temperature, or can be accelerated with heat.

Features and Benefits

Primerless Adhesion - reduces material and labor cost by eliminating the need to prime many difficult to bond plastics.

Contains No Solvent - 100% solids.

Will Not Craze Plastics - forms structural bonds to plastics such as polycarbonate without crazing or attacking the plastic, thus maintaining the integrity of the substrate.

Chemically Resistant - resists solvents once it has cured. Painting and most cleaning processes do not affect bond strength.

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

Impact Resistance - provides impact resistance at temperatures ranging from -34°C to 116°C (-30°F to 240°F).

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

Typical Properties* of Lord 7540 Adhesive

	Lord 7540A	Lord 7540B
Viscosity, cP @ 22°C (72°F)	70,000 - 250,000	8,500 - 20,000
Density Kilograms/Liter lb/gal	1.43 11.9	1.22 10.2
Flash Point, closed cup	>93°C (>200°F)	>93°C (>200°F)
Mix Ratio by volume	1	1
Shelf Life	6 months from date of shipment, unopened container, storage at 21°C - 27°C (70°F - 80°F).	

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

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.

For bonding cured rubber, use Lord 7701 surface treatment on the rubber surface before joining. For bonding glass, Lord AP-134 primer should be used.

Curing

Lord 7540 adhesive has a working time of about seven minutes. Handling strength will develop in 40 minutes on most substrates with full properties in 18-24 hours.

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, sans-serif font. The letter "O" is stylized with a circular cutout in the center.