



7542

Equal-Mix, Urethane Adhesive for Speaker Assembly

Description

Lord® 7542 adhesive is a two-part high strength urethane adhesive used to bond a wide variety of loud speaker components. Lord 7542 adhesive bonds cloth, paper, plastics, foams, rubber and painted metal. Lord 7542 adhesive may be used for bonding foam and rubber speaker surrounds, speaker cones, spiders, dust caps, mounting gaskets, and painted metal stampings and castings. Lord 7542 adhesive can be either room temperature cured or heat cured for faster processing.

Features and Benefits

Tough High Strength Bonds - provides bonds that are strong and durable.

Proven Environmental and Chemical Resistance - resists solvents, weathering and aging.

Nonflammable - does not require expensive explosion-proof equipment.

Environmentally Friendly - will not deplete the ozone.

Contains No Solvent - provides 100% Solids. No VOC content.

Will Not Craze Plastics - bonds to plastics without crazing, attacking or lowering the strength of the plastic substrate.

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

Table 1: Typical Properties* of Lord 7542 Adhesive

	Lord 7542A	Lord 7542B
Appearance	Dark Brown	Tan
Consistency	Gravity-Feed Liquid	Gravity-Feed Liquid
Viscosity, cP at 25°C (77°F)	1,500 - 4,500	7,000 - 14,000
Density kg/m ³ lb/gal	1,372 - 1,408 11.45 - 11.75	1,234 - 1,270 10.3 - 10.6
Percent Solids by weight	100	100
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, at storage temperature 18°C - 29°C (65°F - 85°F).	

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

Table 2: Typical Properties of Cured Lord 7542A/B Adhesive*

Tensile Strength MPa (psi)	14.47 (2,100)
Elongation	80 - 100 %
Young's Modulus MPa (psi)	117.21 (17,000)

*Mixed 1:1 by volume, RT cure, ASTM D882-83A (modified).

Surface Preparation

Prior to mixing and applying Lord 7542 adhesive, the bond surface should be free of dirt, oil contamination and loose particles. For most plastics, cleaning the surface with a dry rag wipe or a rag dampened with solvent will suffice. Metal surfaces should be primed or grit blasted and solvent washed, followed by priming for optimum bond performance.

Mixing

The minimum recommended static mixer length is 24 elements long. Purge time is four to five minutes at 75°F (24°C).

Application

Lord 7542 adhesive is designed for use with Lord-Pak™ hand held cartridges or automated meter/mix/dispense equipment.

Curing

Lord 7542 adhesive has a working time of 4-5 minutes at 24°C (75°F). Handling strength will develop in approximately one hour at room temperature, 6-8 minutes at 60°C (140°F) and 1.5 minutes at 93°C (200°F). Full strength is achieved in approximately twice the cure time. Fresh air ventilation is required.

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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Clean Up

Uncured Adhesive

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.

Cured Adhesive

Heat the cured adhesive to 149°C (300°F) or above to soften. This will allow parts to be separated and adhesive to be more easily removed. Some success may be achieved with commercial adhesive strippers.

Packaging

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

Storage

Lord 7542 adhesive 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 18°C - 29°C (65°F - 85°F) in original, unopened containers.

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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