



Accelerator 18

Black Accelerator for Acrylic Adhesives

Description

Lord® Accelerator 18 is a black mix-in curative used with fast-curing acrylic adhesive resins. The black color makes it easier to distinguish between the adhesive and accelerator portion when applying them “bead-on-bead” for impingement mixing.

Features and Benefits

Convenient Cure Properties - provides room temperature cure with all Lord acrylic resin systems. See specific acrylic adhesive resin bulletin for more details.

Easy to Mix - insensitive to variations in mix ratio. Can be used as a mix-in system at a 10:1 volumetric mix ratio with Versilok® acrylic adhesives. Accelerator 18 can also be used “bead-on-bead” with Lord 202 adhesive at ratios spanning 10:1 to 2:1.

Contains No Solvent - provides a 100% solids content. It is non-flammable and virtually odorless.

Environmental Resistance - resists common environmental conditions when used with Lord acrylic adhesive resins.

Typical Properties* of Lord Accelerator 18

Appearance	Black paste
Viscosity, cP Brookfield Model HAT	10,000 - 15,000
Density gram/cubic centimeter lb/gal	1.02 - 1.14 8.5 - 9.5
Solids Content by weight	100%
Flash Point	>93°C (>200°F)
Shelf Life	6 months from date of shipment, unopened container.

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

Mixing

Mix-In

Confirm the proper mix ratio by consulting the technical bulletin for the Lord adhesive resin. Thoroughly mix the proper amount of resin and accelerator until uniform in color and consistency. Do not whip excessive air into the adhesive.

Heat buildup due to an exothermic reaction between the two components will shorten the pot life of the adhesive. Mixing smaller quantities will minimize heat buildup. Do not use any adhesive that has begun to cure.

Impingement Mixing

In many instances, Lord Accelerator 18 can be applied bead-on-bead with the adhesive resin at a volumetric ratios from 10:1 to 2:1. The two components can then be mixed by rotating the substrates.

Automated

M/M/D equipment can be used if the particular adhesive usage justifies the investment.

Clean Up

Uncured Adhesive

Clean up excess adhesive on the bonded assembly, as well as mixing and application equipment, before the adhesive sets up. Use hot water and detergent or an organic solvent; ketones have been shown to work best.

Cured Adhesive

Heat the cured adhesive to 218°C (425°F) or greater to soften the adhesive. This will allow the parts to be separated and the adhesive to be more easily removed.

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

For maximum shelf life, store Lord Accelerator 18 in the original container at 4°C - 27°C (40°F - 80°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.

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