



Accelerator 19

Accelerator for Acrylic Adhesives

Description

Lord® Accelerator 19 is a mix-in curative used with Lord acrylic adhesive resins. Lord Accelerator 19 curative is convenient to use with meter/mix/dispense equipment or prepackaged Lord-Pak™ cartridge systems.

Features and Benefits

Convenient Cure Properties - provides room temperature cure with all Lord acrylic resin systems.

Easy to Use - can be mixed with acrylic adhesives at mix ratios of 2:1 or 4:1, by volume.

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

Environmentally Resistant - resists common environmental conditions when used with Lord acrylic adhesive resins. Improves the high temperature resistance of Lord 200, 400, and 500 series acrylic adhesives.

Typical Properties* of Lord Accelerator 19 Curative

Appearance	Off-white paste
Viscosity, cP Brookfield Model HAT T-bar C @ 10 rpm	150,000 - 450,000
Density kg/m ³ lb/gal	1.42 - 1.54 11.9 - 12.9
Solids Content by weight	100%
Flash Point	>93°C (>200°F)
Mix Ratio	Use adhesive resin bulletin
Shelf Life	6 months from date of shipment, unopened container, 16°C - 27°C (60°F - 80°F) storage.

*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 acrylic 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.

Automated

In conjunction with Lord acrylic adhesive, Lord Accelerator 19 curative is available in Lord-Pak dual cartridges. Lord-Pak cartridge systems eliminate the waste involved in hand mixing without the capital investment of meter/mix/dispense (M/M/D) equipment. However, M/M/D equipment can be used if the particular adhesive usage justifies the investment. Contact Lord Corporation for further information on M/M/D.

Surface Preparation

Remove grease, loose contamination or poorly adhering oxides from metal surfaces. Normal amounts of mill oils and dressing compounds usually do not present a problem in adhesion. Most plastics require simple cleaning before bonding. Some may require abrading for optimum bond performance.

Application

Apply Lord acrylic adhesive system to substrate surfaces. Mate the assemblies within the working time of the adhesive. Clamp and fixture the assembly until handling strength is achieved.

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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Curing

Lord Accelerator 19 curative can be used with all Lord acrylic resin systems and is designed to cure at room temperature. Maximum properties can be obtained with a modest post cure heat exposure. For post cure time and temperature suggestions, consult the product bulletin for the specific acrylic adhesive resin.

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 204°C (400°F) or greater to soften the adhesive. This will allow the parts to be separated and the adhesive to be more easily removed.

Packaging

- 3 oz. Tubes
- 1/2 Pint Container (0.23 Liter)
- 1 Quart Container (0.95 Liter)
- 1 Gallon Container (3.8 Liter)
- 5 Gallon Pail (19 Liter)
- 55 Gallon Drum (208 Liter)
- Lord-Pak Cartridges

Storage

For maximum shelf life, store Lord Accelerator 19 curative in the original container at 4°C - 16°C (40°F - 60°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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