



# Accelerator 22

## Accelerator for Acrylic Adhesive

### Description

Lord® Accelerator 22 is a mix-in curative designed to be utilized with acrylic adhesive resins. This curative has a mix ratio of either 2:1 or 4:1 by volume. Both mix ratios are convenient for use with meter/mix/dispense equipment or pre-packaged Lord-Pak™ cartridge systems.

### Features and Benefits

**Convenient Cure Properties** - obtains maximum properties with modest post-cure heat exposure. Can be used with all Lord acrylic resin systems and cures at room temperature.

**Environmentally Resistant** - resists common environmental conditions. Accelerator 22 improves the high temperature resistance of Lord 200 and 500 series adhesives.

**Easy to Use** - provides a 2:1 or 4:1 mix ratio that is more easily regulated than previous 10:1 and 20:1 systems.

**Contains No Solvent** - provides a 100% solids content. Nonflammable, and virtually odorless.

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### Typical Properties\* of Lord Accelerator 22

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Appearance	Red paste
Viscosity, cP Brookfield Model HAT T-bar C @ 10 rpm	150,000 - 450,000
Density Grams/cubic centimeter lb/gal	1.39 - 1.51 11.6 - 12.6
Solids Content	100%
Flash Point	>93°C (>200°F)
Mix Ratio	See adhesive resin bulletin
Shelf Life	6 months

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

## Mixing

### *Mix-In*

Determine 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 working time of the adhesive. Mixing smaller quantities will minimize heat buildup. Do not attempt to use any adhesive that has begun to cure.

### *Automated*

In conjunction with Lord acrylic adhesives, Lord Accelerator 22 can be packaged in Lord-Pak dual cartridge systems for convenient, automated mixing and application. Lord-Pak cartridge systems eliminate the waste involved in hand mixing without the capital investment of meter/mix/dispense equipment. 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*

Removing cured Lord adhesive is difficult due to its resistance to chemicals, solvents, and cleaning agents. Heating to 204°C (400°F) or greater will soften the adhesive, allowing the parts to be separated and the adhesive to be more easily removed.

## Storage

For maximum shelf life, store Lord Accelerator 22 adhesive in the original container between 40°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.*

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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