



Accelerator 6

Accelerator for Acrylic Structural Adhesive

Description

Lord® Accelerator 6 is a mix-in curative used with acrylic adhesive resins. Lord Accelerator 6 curative is used with meter/mix/dispense equipment or prepackaged Lord-Pak™ cartridge systems. Lord Accelerator 6 is not a stand alone adhesive; it must be used with acrylic adhesive resins.

Features and Benefits

Convenient Cure Properties - cures at room temperature and can be used with Lord 661,662,and 663 acrylic adhesive resins.

Easy to Use - functions as a mix-in accelerator with Lord acrylic resins at a 10:1 mix ratio.

Contains No Solvent - provides 100% solids content, nonflammable, and virtually odorless.

Environmental Resistance - accompanies Lord acrylic adhesive resins to provide a bond which resists common environmental conditions.

Typical Properties* of Lord Accelerator 6

Appearance	Off-white paste
Viscosity, cP Brookfield RVT T-D @ 5 rpm	100,000 - 400,000
Density kg/m ³ lb/gal	1522 - 1594 12.7 - 13.3
Percent Solids	100%
Flash Point	>93°C (200°F)
Shelf Life	6 months from date of shipment, unopened container, 4°C - 27°C (40°F - 80°F) storage temperature.

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

Surface Preparation

See the product bulletin instructions for the adhesive being used with this accelerator.

Mixing

Mix-In

Confirm the proper mix ratio by consulting the technical bulletin for the Lord adhesive resin. Thoroughly mix the resin and accelerator components until uniform in color and consistency.

Automated

In conjunction with a Lord acrylic adhesive, Lord Accelerator 6 curative is 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. However, meter/mix/dispense equipment can be used when required.

Clean Up

Uncured - Clean up excess adhesive on the bond assembly, as well as the 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 - Heat to 204°C (400°F) or higher 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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Packaging

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

Storage

For maximum shelf life, ship and store Lord Accelerator 6 curative in the original container between 4°C - 27°C (40°F - 80°F). Optimum storage temperatures are between 4°C - 10°C (40°F - 50°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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