

# LORD 606/6GB Acrylic Adhesive

LORD 606 adhesive when mixed with LORD Accelerator 6GB creates a fast-setting adhesive system that will bond composites including DCPD (dicyclopentadiene) resin and modified DCPD resin based FRP (Fiber reinforced plastic). This mixed adhesive can also cross-bond composites to many metals.

LORD 606 adhesive in combination with LORD Accelerator 6GB utilise a unique patented technology to create exceptionally strong bonds with excellent surface cure and minimal surface preparation.

LORD Accelerator 6GB allows precise control of the adhesive bondline thickness due to its content of glass beads. For further detailed information on LORD Accelerator 6GB, refer to the applicable data sheet.

### Features and Benefits

- \* **Versatile** - Bonds difficult-to-bond composites, such as DCPD based FRP, and a wide range of metals with minimal surface preparation.
- \* **Environmentally Resistant** - resists dilute acids, alkalis, solvents, water immersion, moisture and weathering.
- \* **Non-Sag** - Remain in position when applied on vertical or overhead surfaces, allowing for greater process flexibility.

### Application

- \* **Surface Preparation** - Surfaces should be free of grease, dirt and other contaminants. Some surfaces may require abrading for optimum performance.
- \* **Mixing** - Mix LORD 606 adhesive with the proper amount of LORD accelerator 6GB. Handheld cartridges will automatically dispense the correct volumetric ratio of each component. Even colour distribution visually indicates a thorough mix. Once mixed, the adhesive cures rapidly.
- \* **Applying** - Apply adhesive using handheld cartridges or automatic meter/mix/dispense equipment.
  - > Handheld Cartridges:
    - 1- Load the cartridge into the applicator gun and remove the end caps.
    - 2- Level the plungers by expelling a small amount of adhesive to ensure both sides are level.
    - 3- Attach mixing tip and expel a mixer's length of adhesive.
    - 4- Apply adhesive to substrate and mate the parts within the working time of the adhesive. Clamp in position until adhesive reaches handling strength.
- \* **Curing** - Cure begins immediately once adhesive and accelerator are mixed. Handling strength is achieved within 16-24 minutes. Complete cure requires 8-24 hours depending on temperature and bondline thickness. Mating surfaces must be held in contact during the entire cure period. Adhesive will cure to a tack-free surface.
- \* **Clean Up** - Clean equipment and tools prior to the adhesive cure with solvents such as isopropyl alcohol, acetone or methyl ethyl ketone (MEK). Once adhesive is cured, heat the adhesive to 204°C or above to soften the adhesive. This allows the parts to be separated and the adhesive to be more easily removed. Some success may be achieved with commercial epoxy strippers.

Part Number	Description
EA606	Adhesive - Lord 606-6GB 485ml Handheld Cartridge
EA6.3-21SA	Mixing Nozzle (Suit 485ml)
EA51-10:1	Applicator Gun (Suit 485ml)
EA606-50	Adhesive - Lord 606-6GB 50ml Handheld Cartridge
3022524	Mixing Nozzle (Suit 50ml)
3019428	Applicator Gun (Suit 50ml)

