



7602

Single-Pack, Moisture Cure, Urethane Adhesive/Sealant

Description

Lord® 7602 is a single-pack, moisture cure, urethane adhesive/sealant that offers excellent adhesion to various plastics, wood, fabrics, cured elastomers, and prepared metals including precoated steel.

Features and Benefits

Chemical Resistance - provides resistance to painting and most cleaning processes without affecting bond strength.

Structural Integrity - bonds a wide variety of substrates, including Hytrel®.

Impact Resistance - provides resistance at temperatures -34°C to 115°C (-30°F to 240°F).

Single Component - requires no mixing.

Surface Preparation

Remove contaminants and foreign particles from parts to be bonded. A solvent wipe with Methyl Ethyl Ketone (MEK) or Isopropyl Alcohol (IPA) is sufficient. Substrate abrasion is not needed in most cases; however, adhesion is enhanced when the substrate is mechanically prepared.

For bonding cured rubber, use Lord 7701 surface treatment on the rubber surface before joining.

For bonding glass, use Lord AP-134 primer before bonding.

Mixing

Lord 7602 adhesive does not require mixing.

Typical Properties* of Lord 7602 Adhesive

Appearance	Off-white
Viscosity, cP Brookfield HAT, T-Bar B @ 5 rpm after mild agitation	50,000 - 250,000
Density kg/m ³ lb/gal	959 - 1079 8 - 9
Percent Solids	62% - 66%
Flash Point (Seta)	7°C (44°F)
Solvent	Acetone, MEK
Shelf Life	6 months from date of shipment, unopened container, 16°C - 32°C (60°F - 90°F) storage temperature.

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

Table 2: Typical Performance* of Lord 7602 Adhesive

Shear Strength	48 Hour Cure	96 Hour Cure
Grit Blasted CRS	526 psi - CF	781 psi - CF
Grit Blasted Aluminum	479 psi - CF	741 psi - CF
Low Profile FRP	506 psi - CF	651 psi - CF
Std. Profile FRP	506 psi - CF	793 psi - CF
180° Peel Strength		
Plasticized Vinyl	46 pli (shallow vinyl tear)	50 pli (deep vinyl tear)

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

psi = pound per square inch

CF = cohesive failure

pli = pounds per linear inch

All substrates, except vinyl, were grit blasted.

Application

Apply Lord 7602 adhesive by bead or with a plastic spreader or a metal trowel. A notched trowel can be used to spread an even coat over a large surface. A deep notch, 7.9mm (1/32"), is recommended. Join parts within 10 - 20 minutes of adhesive application.

Clean Up

Clean up Lord 7602 adhesive with isopropyl alcohol, acetone, or MEK prior to curing.

Packaging

- 0.1 Gallon Caulking Tubes (0.37 Liter)
- 1/2 Pint Container (0.24 Liter)
- 1 Gallon Container (3.8 Liter)
- 5 Gallon Pail (19 Liter)

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

Store Lord 7602 adhesive at 16°C - 32°C (60°F - 90°F). Lord 7602 adhesive reacts when exposed to moisture. Protect opened containers from moisture exposure by nitrogen purging the cans before resealing. Opened caulking tubes can be sealed in a plastic bag to protect from moisture contamination.

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.

For additional information, contact Lord Corporation at: 814/868-3611 ext. 3277, FAX: 814/864-3452 or write: Lord Corporation, 2000 West Grandview Blvd., P.O. Box 10038, Erie, PA 16514-0038.

