

# LORD® Accelerator 19 and 19GB

## Description

LORD Accelerator 19 and 19GB are mix-in curatives designed for use with LORD acrylic adhesives. LORD Accelerator 19 and 19GB, when mixed with LORD 200, 400 or 500 series acrylic adhesives, create adhesive systems that will bond a variety of prepared or unprepared metals and plastics.

LORD Accelerator 19GB allows precise control of adhesive bondline thickness due to its content of glass beads, 0.01" (0.025 cm) diameter.

## Features and Benefits

**Convenient** – provides room temperature cure with all LORD acrylic adhesives.

**Environmentally Friendly** – contains no solvent, non-flammable and virtually odorless.

**Environmentally Resistant** – resists common environmental conditions when used with LORD acrylic adhesives.

**Temperature Resistant** – improves high temperature resistance of LORD 200, 400 and 500 series acrylic adhesives.

## Application

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

**Mixing** – Confirm the proper mix ratio of acrylic adhesive to accelerator by consulting the appropriate LORD acrylic adhesive data sheet. Thoroughly mix the proper amount of adhesive and accelerator until uniform in color and consistency. Be careful not to whip excessive air into the adhesive system.

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 use any adhesive that has begun to cure.

**Applying** – Apply adhesive to substrate surfaces using handheld cartridges or automatic meter/mix/dispense equipment. Mate the parts within the working time of the adhesive. Clamp in position until handling strength is achieved.

## Typical Properties\*

	<b>Accelerator 19</b>	<b>Accelerator 19 Black</b>	<b>Accelerator 19GB</b>
Appearance	Off-White Paste	Black Paste	Off-White, Red or Gray Paste
Viscosity, cP @ 77°F (25°C) Brookfield Model HAT	150,000-450,000 T-bar C, 10 rpm	100,000-400,000 T-bar C, 5 rpm	100,000-400,000 T-bar C, 10 rpm
Density lb/gal	11.9-12.9	12.0-13.1	12.6-13.5 – Off-White 12.4-13.15 – Red 12.95-13.7 – Gray
(kg/m <sup>3</sup> )	(1426-1546)	(1438-1570)	(1510-1618) – Off-White (1486-1576) – Red (1552-1642) – Gray
Solids Content by Weight, %	100	100	100
Flash Point (Seta), °F (°C)	>200 (>93)	>200 (>93)	>200 (>93)

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

# LORD TECHNICAL DATA

**Curing** – Cure begins immediately once accelerator and acrylic adhesive are mixed. Handling strength and complete cure times will vary depending on acrylic adhesive used. For cure times, refer to appropriate acrylic adhesive data sheet.

**Cleanup** – Clean equipment and tools prior to the adhesive cure with hot water and detergent or an organic solvent such as methyl ethyl ketone (MEK). Once adhesive is cured, heat the adhesive to 400°F (204°C) or above to soften the adhesive. This allows the parts to be separated and the adhesive to be more easily removed.

## Shelf Life/Storage

Shelf life is six months from date of shipment when stored at 60-80°F (16-27°C) in original, unopened container.

## 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 technical data sheet 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 Support Center.

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