

## Cross Bonding with LORD Sign Assembly Adhesives

	Trade Name <sup>†</sup>	Surface Preparation	Aluminum/Steel*	Prefinished Metal & Aluminum Composite Material (ACM)	Polycarbonate*	Acrylic*	Urethane Foam	PVC Foam Board	Ceramic/Stone	Wood
<b>Aluminum/Steel*</b>		Solvent wipe with isopropyl alcohol	Signlok 4xx Signlok 810 4xx/19 2xx	Signlok 4xx Signlok 810 4xx/19	Contact LORD	Contact LORD	7610DTM** 7542**	Signlok 4XX Signlok 810 4xx/19	320/322 †	7610DTM 320/322 †
<b>Stainless Steel</b>		Solvent wipe with isopropyl alcohol, mechanically abrade with 80-grit paper or grinder, wipe with IPA to remove sanding dust	Signlok 4xx Signlok 810 4xx/19 2xx	Signlok 4xx Signlok 810 4xx/19	Contact LORD	Contact LORD	7610DTM** 7542**	Signlok 4xx Signlok 810 4xx/19	320/322 †	7610DTM 320/322 †
<b>Prefinished Metal &amp; Aluminum Composite Material (ACM)</b>	AlumaCorr™ NuAlum™ Poly-Metal™ Alumalite™ DiBond® Econolite™ MAXX™ Alucobond® Anodized Alucobond®	Factory painted metal or ACM panels: solvent wipe Shop painted or other finishes: remove by sanding prior to bonding	Signlok 4xx Signlok 810 4xx/19	Signlok 4xx Signlok 810 4xx/19	Signlok 4xx 4xx/19 7542 7610DTM	7542 7610DTM <sup>n</sup>	7542 7650 7610DTM	Signlok 4xx Signlok 810 4xx/19 7542 7650 7610DTM	320/322 †	7542 7650 7610DTM
<b>Polycarbonate*</b>	Lexan® Tuffak®	Solvent wipe with isopropyl alcohol	Contact LORD	7542 7610DTM	Signlok 4xx 4xx/19 7542 7610DTM	7542 7610DTM	7542 7650 7610DTM	7542 7650 7610DTM	7610DTM <sup>n</sup>	7542 7650 7610DTM
<b>Acrylic*</b>	Acrylite® Acrysteel® IGP Duraplex® Optix®SG Implex® Plexiglas®G	Scuff with scuff pad or 120-grit paper, solvent wipe with isopropyl alcohol	Contact LORD	7542 7610DTM 7650	7542 7610DTM 7550 <sup>n</sup>	7542 7610DTM	7542 7610DTM 7550 <sup>n</sup>	7542 7650 7610DTM	7610DTM <sup>n</sup>	7542 7650 7610DTM
<b>TrimCap</b>	Jewelite® SignATrim™	Scuff with scuff pad or 120-grit paper, solvent wipe with isopropyl alcohol		7550 <sup>n</sup> 7542	7550 <sup>n</sup>	7550 <sup>n</sup>	7542 7550 <sup>n</sup> 7610DTM	7542 7650 7610DTM		7542 7550 <sup>n</sup>
<b>Urethane Foam</b>	Precision Board Last-A-Foam® Sign Foam 3® Design Board® CORAFoam®	Blow off surface with clean air or wipe with clean dry cloth	7650 7610DTM 7542	7542 7650 7610DTM	7542 7650 7610DTM	7542 7650 7610DTM	7542 7610DTM	7542 7650 7610DTM	7542 7610DTM	7542 7650 7610DTM
<b>PVC Foam Board</b>	Komatex® Sintra®	Scuff with scuff pad or 120-grit paper, solvent wipe with isopropyl alcohol	Signlok 4xx Signlok 810 4xx/19	Signlok 4xx Signlok 810 4xx/19 7542 7650 7610DTM	7542 7650 7610DTM	7452 7650 7610DTM	7542 7610DTM	Signlok 4xx 4xx/19 7542 7650 7610DTM	7542 7610DTM <sup>n</sup>	7542 7650 7610DTM
<b>Paper/Foam Board</b>	Foam-X® Recovery Foam-Cor®	Wipe with clean dry cloth	7542** 7610DTM 7650**	7542 7650	7542 7610DTM	7542	7542 7610DTM	7542 7610DTM	7542 7610DTM	7542 7610DTM
<b>PETG Sheet</b>	Spectar™ PETG	Solvent wipe with isopropyl alcohol	7542** Signlok 4xx Signlok 810 4xx/19	7542** Signlok 4xx Signlok 810 4xx/19	7542 7610DTM	7542	7542 7610DTM	7542 7610DTM	7542 7610DTM	7542 7610DTM
<b>Polystyrene Foam Board</b>	Gatorfoam® Gatorblanks® Gatorplast® Ultra	Wipe with clean dry cloth Solvent wipe with isopropyl alcohol	Signlok 4xx (N/A Gatorblanks®) Signlok 810 (N/A Gatorblanks®) 4xx/19 (N/A Gatorblanks®) 7542** 7610DTM 7650**	Signlok 4xx Signlok 810 4xx/19 7542 7610DTM 7650	7542 7550 <sup>n</sup>	7542 7610DTM 7650	7542 7610DTM 7650	7542 7610DTM	7542 7610DTM	7542 7610DTM
<b>Vinyl Laminate</b>	White-Wood® Maxx-Board®	Wipe with clean dry cloth, scuff Solvent wipe with isopropyl alcohol	Signlok 4xx Signlok 810 4xx/19 7542** 7610DTM 7650	Signlok 4xx Signlok 810 4xx/19 7542** 7610DTM 7650	7542 7650	7542	7542 7610DTM 7650	7542 7610DTM	7542 7610DTM	7542 7610DTM
<b>Wood</b>		Wipe with clean dry cloth	320/322 †	7542 320/322 † 7650	7542 7650 7610DTM	7542 7650 7610DTM	7542 7610DTM	7542 7650 7610DTM	7542 7610DTM <sup>n</sup> 320/322	7542 320/322 7610DTM 7650
<b>Ceramic/Stone</b>		Porous: Wipe with clean dry cloth Non-porous (Smooth/polished): LORD AP-134 Adhesion Enhancer/Surface Modifier required	320/322 †	320/322 †	7542 7610DTM <sup>n</sup>	7542 7610DTM <sup>n</sup>	7542 7610DTM <sup>n</sup>	7610DTM <sup>n</sup>	320/322	7542 7610DTM <sup>n</sup>
<b>Cured Concrete</b>		Wipe with clean dry cloth	7610DTM 320/322 †	320/322 † 360 7610DTM	7542 7610DTM	7542 7610DTM			320/322	7610DTM 320/322
<b>Glass**</b>		LORD AP-134 Adhesion Enhancer/Surface Modifier required	Signlok 4xx 4xx/19	Signlok 4xx 4xx/19 7542		7542 7610DTM	7610DTM	7610DTM	7542 7610DTM	7542 7610DTM

xx Represents numbers for the family of adhesive to be utilized. Contact LORD Customer Support Center, 877 ASK LORD (275 5673).

† All substrate Trade Names are trademarks or registered trademarks of the substrate supplier.

\* Coefficient of thermal expansion is a major consideration when cross-bonding these substrates. Acrylic adhesives should not be used to attach large thermoplastic parts due to the differences in thermal expansion.

\*\* Additional surface preparation recommended: Metals should be painted or primed. Glass, Ceramic and Stone should be primed with LORD AP-134 Adhesion Enhancer/Surface Modifier to promote adhesion, 120 minutes to hydrolyze.

† Prepare metal by scuffing/abrading followed by a solvent wipe.

<sup>n</sup> For non-structural bonding (assemblies where adhesive is used for aesthetic attachment in minimum stress areas).

 Signlok 403, Signlok 406, Signlok 810, LORD 201, LORD 4xx/19 and LORD 7542 are UL recognized.

Each substrate and adhesive should be tested for the specific use in which it will be expected to perform. The information reported here is from laboratory studies and is intended only to provide general information regarding the ability of material to be bonded with LORD® Structural Adhesives.

## Dispensing Equipment

					
<b>Container Size</b>	225 mL	50 mL	CX	375 mL	LORD 7610DTM Cartridge
<b>Manual Dispensing Gun</b>	3001120	3001112	3004487	3004857	–
<b>Plunger (2:1)</b>	–	3009588 (one plunger ships with gun)	–	–	–
<b>Plunger (4:1)</b>	–	3004479	–	–	–
<b>Pneumatic Dispensing Gun</b>	3001129	–	–	3004856	3023577
<b>Mixing Tip</b>	3001173	3004476	3001179	3004657	Nozzle= 3015312

No-mix adhesives—brush or trowel resin and accelerator onto separate surfaces. Mate when ready for fast set.

For more information visit us at [LORD.com/Sign](http://LORD.com/Sign) or call +1 877 ASK LORD (275 5673) to speak with a customer representative.



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