

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

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.

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.

Curing – Handling strength and complete cure times will vary depending on acrylic adhesive used. For cure times, refer to appropriate acrylic adhesive data sheet.

Typical Properties*

	Accelerator 19	Accelerator 19 Black	Accelerator 19GB
Appearance	Off-White Paste	Black Paste	Off-White, Red or Grey Paste
Viscosity, cP @ 77°F (25°C) Brookfield Model HAT T-bar C, 5 rpm	150,000-450,000	100,000-400,000	100,000-400,000
Density			
lb/gal	12.15-12.7	12.0-13.1	12.35-13.2 – Off-White 12.4-13.15 – Red 12.95-13.7 – Grey
(kg/m ³)	(1456-1522)	(1438-1570)	(1480-1581) – Off-White (1486-1576) – Red (1552-1642) – Grey
Solids Content by Weight, %	99.08	99.07	99.07
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

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 nine months 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 Safety Data Sheet (SDS) 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.

Information provided herein is based upon tests believed to be reliable. In as much as LORD Corporation has no control over the manner in which others may use this information, it does not guarantee the results to be obtained. In addition, LORD Corporation does not guarantee the performance of the product or the results obtained from the use of the product or this information where the product has been repackaged by any third party, including but not limited to any product end-user. Nor does the company make any express or implied warranty of merchantability or fitness for a particular purpose concerning the effects or results of such use.

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LORD Corporation World Headquarters

111 Lord Drive
Cary, NC 27511-7923
USA

Customer Support Center (in United States & Canada)

+1 877 ASK LORD (275 5673)

www.lord.com

For a listing of our worldwide locations, visit LORD.com.

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