



LORD® Structural Adhesives for Service Work Trucks

SELECTOR GUIDE

Applications for Service Work Trucks

Using LORD® adhesives to bond truck bodies during manufacturing, rather than welding or fastening, can reduce labor costs and cycle time. In addition, LORD adhesives increase throughput, reduce material costs and weight, and improve strength. What makes us different is our exceptional technical support dedicated to ensure your every design need is met. Our adhesives bond to various substrates including coated, painted, bare metal substrates, plastics and composites. We offer multiple cure speeds to fit your application requirements. We also offer glass beads for bondline control to prevent over-clamping.



1 Sidewall Bonding:
Improve Aesthetics with Rivet Removal and Weld Reduction

2 Roof Bonding:
Accelerate Assembly Times While Improving Performance and Customer Perception

3 Panel Bonding:
Improve Warranty and Quality by Eliminating Corrosion and Leaks

4 Bonded HVAC Units:
Bond and Seal in One Step to Enhance Work Flow and Design

5 Door Closures:
Improve Appearance, Dimensional Stability and Stiffness



PRODUCT		SUBSTRATES					TYPICAL PROPERTIES*					
		Bare Metal	Composite	Painted Metal	Plastics	Cross Bonding	Specialty	Work Time @ 75°F (24°C)	Mix Ratio by Volume, Adhesive to Accelerator	Time to Handling Strength @ 75°F (24°C)	Accelerator(s)	Mixed Appearance
LORD® 7800 FAST-CURE URETHANE ADHESIVE	A/C						3 min.	1:1	12 min.	N/A	Black	<ul style="list-style-type: none"> • 2x Faster Processing Time • Equal Mix Ratio • Sag Resistance • No Odor
	A/D	✓	✓	✓	✓	✓	6 min.	1:1	25 min.			
LORD® 7542 URETHANE ADHESIVE	A/B (UL)						4-7 min.	1:1	1-2 hr.	N/A	Varies** (Black or Brown)	<ul style="list-style-type: none"> • Structural Bonding • Lower Viscosity for Easy Dispensing • Non Flammable
	A/C (UL)	✓	✓	✓	✓	✓	11-15 min.	1:1	2 hr.			
	A/D (UL)						20-30 min.	1:1	3 hr.			
	A/E (UL)						50-60 min.	1:1	4 hr.			
LORD® 7545 URETHANE ADHESIVE	A/G						1.5 min.	1:1	10 min.	N/A	Varies** (Off-white or Black)	<ul style="list-style-type: none"> • Bonds FRP, SMC, Plastics and Prepared Metals • Non-sag • Non Flammable
	A/B						3-5 min.	1:1	30 min.			
	A/C	✓	✓	✓	✓	✓	6-8 min.	1:1	60 min.			
	A/D						11-18 min.	1:1	90 min.			
	A/E						22-38 min.	1:1	2-3 hr.			
	A/F						45-65 min.	1:1	4-5 hr.			
LORD® 7555 URETHANE ADHESIVE/ SEALANT	A/C		✓	✓	✓	✓	3-5 min. @ 77°F (25°C)	1:1	1 hr. @ 77°F (25°C)	N/A	White Paste	<ul style="list-style-type: none"> • Bonds & Seals Plastics and Prepared Metals • Non-sag, non-yellowing • Paint & Finish Immediately
	A/E						45 min. @ 77°F (25°C)	1:1	5-6 hr. @ 77°F (25°C)			
LORD® 7610DTM DIRECT-TO-METAL ADHESIVE/SEALANT		✓	✓	✓	✓	✓	25-35 min. @ 77°F (25°C)	N/A	6-12 hr. @ 77°F (25°C)	N/A	White, Black or Grey Paste	<ul style="list-style-type: none"> • Single Component • No Mix • UV Resistant
LORD® ACRYLIC ADHESIVE WITH ACCELERATOR 19	403 (UL)						2-4 min.	4:1	4-6 min.	19, 19 Black, 19GB, 19GB Red, 19GB Grey	Tan Paste**	<ul style="list-style-type: none"> • Easy to Dispense • Withstands E-Coat & Powder Coat • Cold Impact
	406 (UL)	✓	✓	✓	✓	✓	6-10 min.	4:1	12-17 min.			
	410 (UL)						20-45 min.	4:1	60-120 min.			
LORD® 810 LOW READ-THROUGH (LRT) ACRYLIC ADHESIVE WITH LORD ACCELERATOR 20GB		✓	✓	✓	✓	✓	8-12 min. @ 70°F (21°C)	2:1	20-25 min. @ 70°F (21°C)	20GB	Grey Paste	<ul style="list-style-type: none"> • Ideal for Thin, Glossy and ACM Materials • Withstands E-Coat & Powder Coat
LORD® ACRYLIC ADHESIVE WITH LORD ACCELERATOR 25GB	850 (FAST)	✓	✓	✓	✓	✓	6-10 min.	10:1	18-24 min.	25GB	Red Paste	<ul style="list-style-type: none"> • Toughened • High Impact • Fatigue Resistant • Low Temp Environment • Withstands E-Coat & Powder Coat
	852 (SLOW)						20-25 min.	10:1	50-70 min.			
MAXLOK® ACRYLIC ADHESIVE WITH MX ACCELERATOR	T3						3-5 min. @ 77°F (25°C)	4:1	6-8 min. @ 77°F (25°C)	MX	Grey Paste	<ul style="list-style-type: none"> • Bondline Control • Glass Beads • High Impact • High Peel • Withstands E-Coat & Powder Coat
	T6 (UL)	✓	✓	✓	✓	✓	6-9 min. @ 77°F (25°C)	4:1	20-24 min. @ 77°F (25°C)			
	T18						18-24 min. @ 77°F (25°C)	4:1	48-72 min. @ 77°F (25°C)			

Refer to LORD Structural Adhesives Guide for full product information.

Refer to LORD UL-Approved Adhesives for Sign and Electrical Enclosure Bonding for listing of specific UL-Approved products.

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

**Mixed appearance will vary based on accelerator/curative used.

Applications for Service Work Trucks

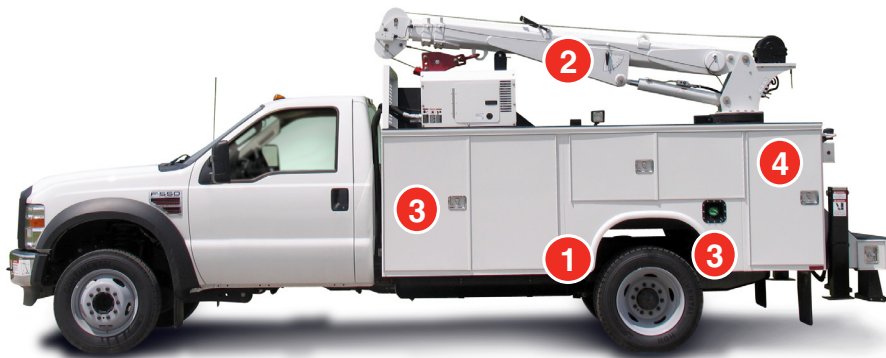


1 Seam Sealing:
Protect Against Corrosion and Cargo Damage, Direct-to-Metal Options Reduce Cost and Improve Throughput

2 Plastic Bonding:
Bond to Many Types of Plastics and Composites and Cross Bond to Metals Which Allows for Light Weighting and Sleek Designs.

3 Metal Bonding:
Save Time and Money with Production Efficiencies and Reduced Re-work

4 Rivet/Weld Reduction:
Eliminate Leaks, Stress Cracks and Durability Issues While Reducing Manufacturing and Warranty Costs



LORD and Maxlok are trademarks of LORD Corporation or one of its subsidiaries.

LORD provides valuable expertise in adhesives and coatings, vibration and motion control, and magnetically responsive technologies. Our people work in collaboration with our customers to help them increase the value of their products. Innovative and responsive in an ever-changing marketplace, we are focused on providing solutions for our customers worldwide.



Ellsworth Adhesives
W129 N10825 Washington Drive
Germantown, WI 53022
USA
+1 877 454-9224
www.ellsworth.com

