

LORD® 7150 A/B-FM Urethane Adhesive

Technical Data Sheet

LORD® 7150 A/B-FM adhesive is a two-part, foaming urethane adhesive used to bond cloth, paper, plastics, foams, rubber, painted metals and powder coated metals. LORD 7150 A resin is composed of isocyanate. LORD 7150 B-FM curative is composed of polyol.

This adhesive system can be either room temperature cured or heat cured for faster processing. Curing temperature affects the amount of foaming.

Features and Benefits:

Convenient – reduces material and labor costs by eliminating the need to prime many plastics.

Durable – creates high strength bonds to plastics without crazing, attacking or lowering the strength of the plastic substrate.

Non-Flammable – does not require explosion-proof equipment.

Environmentally Recommended – no VOC content; does not contain ozone depleting chemicals.

Chemically Resistant – solvent resistant when cured.

Environmentally Resistant – resists weathering and aging.

Application:

Surface Preparation – Surfaces should be free of grease, dirt and other contaminants. For most plastics, clean the surface with a dry rag wipe or a rag dampened with solvent. For metals, grit blast and solvent wash the surface, then prime for optimum bond performance.

Mixing – Mix resin with curative at a 1:1 ratio, by volume. Handheld cartridges will automatically dispense the correct volumetric ratio of each component. Once mixed, the adhesive cures rapidly.

Applying – Apply adhesive using handheld cartridges or automatic meter/mix/dispense equipment.

- Handheld Cartridges
 1. Load the cartridge into the applicator gun and remove the end caps.
 2. Level the plungers by expelling a small amount of material to ensure both sides are level.
 3. Attach mixing tip and expel a mixer's length of adhesive.
 4. Apply adhesive to substrate and mate the parts within the working time of the adhesive. Clamp in position until adhesive reaches handling strength.
- Meter/Mix/Dispense Equipment
Contact your Parker LORD representative if assistance is needed using this equipment.

Curing – LORD 7150 A/B-FM adhesive will cure to full strength in 24 hours at room temperature, 77°F (25°C). Cure rate can be accelerated when adhesive is cured at elevated temperatures.

Cleanup – Remove adhesive squeeze-out with a dry knife blade or similar device when the adhesive begins to harden. Take care to avoid disrupting the bondline.

Typical Properties*

	7150 A Resin	7150 B-FM Curative
Appearance	Black Liquid	White Liquid
Viscosity, cP @ 75°F (24°C)	3000-16,000	40,000-55,000
Density lb/gal (kg/m ³)	12.4-12.7 (1486-1522)	11.0-11.4 (1318-1366)
Flash Point (Closed Cup), °F (°C)	>200 (>93)	>200 (>93)

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



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Shelf Life/Storage:

Shelf life of each component is six months when stored in a clean, dry environment at 65-85°F (18-30°C) in original, unopened container.

After opening, protect adhesive from excessive exposure to moisture by installing desiccant cartridges and/or using dry nitrogen as an inert cover.

Cautionary Information:

Before using this or any Parker 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.

Typical Properties* of Resin Mixed with Curative

Mix Ratio by Volume, Resin to Curative	
by Volume	1:1
by Weight	1:0.88
Solids Content by Weight, %	100
Working Time, minutes @ 77°F (25°C)	5-10
Purge Time, minutes @ 77°F (25°C)	4
Time to Handling Strength, hours @ 73°F (23°C)	2-3
Foaming, %	
77°F (25°C) Cure Temperature	20
212°F (100°C) Cure Temperature	50

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Values stated in this document 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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