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/m³)	 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.

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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