**Adhesive Selection**

Use the chart below to choose the proper adhesive for sign bonding applications. For more detailed information on these adhesives and surface preparation, call the Parker LORD Customer Support Center.

<table>
<thead>
<tr>
<th>Trade Name</th>
<th>Surface Preparation</th>
<th>Adhesive Selection</th>
</tr>
</thead>
<tbody>
<tr>
<td>Trade Name</td>
<td>Surface Preparation</td>
<td>Adhesive Selection</td>
</tr>
<tr>
<td>Trade Name</td>
<td>Surface Preparation</td>
<td>Adhesive Selection</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Surface Prepariation</th>
<th>Adhesive Selection</th>
</tr>
</thead>
<tbody>
<tr>
<td>White-Wood</td>
<td>Porous: Wipe with clean dry cloth</td>
</tr>
<tr>
<td>Lexan</td>
<td>Absorbent cloth</td>
</tr>
<tr>
<td>Ceramic/Stone</td>
<td>Gatorblanks(©)</td>
</tr>
<tr>
<td>Porous: Wipe with clean dry cloth</td>
<td></td>
</tr>
<tr>
<td>Foam Board</td>
<td>Signlok 8 10</td>
</tr>
<tr>
<td>Paper/Foam</td>
<td>Signlok 10</td>
</tr>
<tr>
<td>Precision Board</td>
<td>Foam-Cor</td>
</tr>
<tr>
<td>Urethane Foam</td>
<td>Foam-X</td>
</tr>
<tr>
<td>TrimCap</td>
<td>Last-A-Foam</td>
</tr>
<tr>
<td>Jewelite</td>
<td>Gatorfoam</td>
</tr>
<tr>
<td>Acrylic*</td>
<td>Foam Cor</td>
</tr>
<tr>
<td>Acrylite</td>
<td>Signlok 4xx (N/A 320/322)</td>
</tr>
<tr>
<td>PETG Sheet</td>
<td>Signlok 8 10</td>
</tr>
<tr>
<td>Board</td>
<td>Signlok 4xx</td>
</tr>
<tr>
<td>PVC Foam</td>
<td>Signlok 4xx</td>
</tr>
<tr>
<td>Glass**</td>
<td>Signlok 4xx</td>
</tr>
<tr>
<td>Composite</td>
<td>Signlok 4xx</td>
</tr>
<tr>
<td>Aluminum</td>
<td>Signlok 4xx</td>
</tr>
<tr>
<td>Steel</td>
<td>Signlok 4xx</td>
</tr>
<tr>
<td>Stainless Steel</td>
<td>Signlok 4xx</td>
</tr>
<tr>
<td>Shop painted or other finishes: remove by sanding prior to bonding</td>
<td></td>
</tr>
<tr>
<td>Prefinished</td>
<td>Lords AP-134 Surface Enhancer/Surface Modifier</td>
</tr>
<tr>
<td>Factory painted metal or polished): LORD AP-134 Surface Enhancer/Surface Modifier</td>
<td></td>
</tr>
<tr>
<td>Prepared metal by scuffing/abrating followed by a solvent wipe</td>
<td></td>
</tr>
<tr>
<td>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 coefficient of thermal expansion.</td>
<td></td>
</tr>
<tr>
<td>* Indicates that the adhesive is part of a family of adhesives. Contact Parker LORD Customer Support Center, 877 ASK LORD (275 5673), for more information.</td>
<td></td>
</tr>
</tbody>
</table>

For more information, visit www.lord.com.
LORD Structural Adhesives offer advantages over welding and mechanical fastening. They bond dissimilar materials, provide improved appearance, insulate against galvanic corrosion and offer excellent environmental resistance. Adhesive bonding provides cost savings due to reduced labor costs and assembly time.

LORD® Signlok™ adhesives provide right-sized packaging to fit most jobs and eliminate waste, are UL approved, and have a long shelf life that reduces costs.
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### Metal Bonding Adhesives

<table>
<thead>
<tr>
<th>Metal Bonding Adhesives</th>
<th>Features</th>
<th>Applications</th>
</tr>
</thead>
<tbody>
<tr>
<td>Metal Bonding Adhesives</td>
<td>Fast Cure</td>
<td>Bond and Seal in One Step</td>
</tr>
<tr>
<td>Metal Bonding Adhesives</td>
<td>Slow Cure</td>
<td>Corner Key Installation</td>
</tr>
<tr>
<td>Metal Bonding Adhesives</td>
<td>Medium Cure</td>
<td>Seals Light Leaks &amp; Seam Sealer</td>
</tr>
</tbody>
</table>

### Plastic Bonding Adhesives

**Plastic Bonding Adhesives**

For optically clear bonding, gap filling or bonding wood or other porous substrates, the LORD 7500 series offers tough, flexible adhesives in a variety of speeds. The LORD 7501/20 series offers perfect structural bonding to materials to polyurethane foams.

<table>
<thead>
<tr>
<th>Plastic Bonding Adhesives</th>
<th>Features</th>
<th>Applications</th>
</tr>
</thead>
<tbody>
<tr>
<td>Plastic Bonding Adhesives</td>
<td>Non-flammable</td>
<td>Bonds to Bare Metal</td>
</tr>
<tr>
<td>Plastic Bonding Adhesives</td>
<td>UV Resistant</td>
<td>Flexible Material Bonding</td>
</tr>
<tr>
<td>Plastic Bonding Adhesives</td>
<td>Easy to Use</td>
<td>Thin Gauge Material</td>
</tr>
</tbody>
</table>

### Dispensing Equipment

**Dispensing Equipment**

- **Manual 335 mL Cartridge Dispensing Guns**
  - Manual Dispensing Gun: 3004036
  - Plunger (4 x): 3004479 (one plunger strip with gun)
  - Plunger (4 x): 3004479 (required for LORD 400 Series 50 mL cartridges)

- **Manual 50 mL Cartridge Dispensing Guns**
  - Manual Dispensing Gun: 300112
  - Plunger (4 x): 3004479
  - Plunger (4 x): 3004479

- **Manual 375 mL Cartridge Dispensing Guns**
  - Manual Dispensing Gun: 3004456
  - Manual Dispensing Gun: 3004477

- **Manual 20 mL Cartridge Dispensing Guns**
  - Manual Dispensing Gun: 3004479
  - Plunger (4 x): 3004479

- **Manual CX (404 mL) Cartridge Dispensing Guns**
  - Manual Dispensing Gun: 3004479
  - Manual Dispensing Gun: 3004479

### Specialty Adhesives

**Specialty Adhesives**

- NO-MIX ADHESIVES
  - For use adhesives - metal or white metal and accelerator into separate surfaces. Mix when ready for fast set.

- LORD AP-154 Adhesive Enhancer/Surface Modifier
  - 4 oz Bottle: 3004460
  - Gallon: 3004469

**Technical Data**

- Technical Data reported at 70-77°F (21-25°C).
- Technical Data reported at 70-77°F (21-25°C).
- Technical Data reported at 70-77°F (21-25°C).
- Technical Data reported at 70-77°F (21-25°C).
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- Technical Data reported at 70-77°F (21-25°C).

**Cross Bonding Adhesives**

- Cross Bonding Adhesives
  - A/B System
  - Aesthetic Assemblies
  - Decorative Parts
  - Trimcap

**Metal Bonding Adhesives**

- Metal Bonding Adhesives
  - Fast Cure
  - A/B System
  - Aesthetic Assemblies
  - Decorative Parts
  - Trimcap

**Plastic Bonding Adhesives**

- Plastic Bonding Adhesives
  - Non-flammable
  - UV Resistant
  - Easy to Use
  - Thin Gauge Material

**Dispensing Equipment**

- Dispensing Equipment
  - Manual 335 mL Cartridge Dispensing Guns
    - Manual Dispensing Gun: 3004036
    - Plunger (4 x): 3004479 (one plunger strip with gun)
    - Plunger (4 x): 3004479 (required for LORD 400 Series 50 mL cartridges)
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    - Manual Dispensing Gun: 300112
    - Plunger (4 x): 3004479
    - Plunger (4 x): 3004479
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    - Manual Dispensing Gun: 3004456
    - Manual Dispensing Gun: 3004477
  - Manual 20 mL Cartridge Dispensing Guns
    - Manual Dispensing Gun: 3004479
    - Plunger (4 x): 3004479
  - Manual CX (404 mL) Cartridge Dispensing Guns
    - Manual Dispensing Gun: 3004479
    - Manual Dispensing Gun: 3004479

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    - Plunger (4 x): 3004479 (required for LORD 400 Series 50 mL cartridges)
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    - Manual Dispensing Gun: 300112
    - Plunger (4 x): 3004479
    - Plunger (4 x): 3004479
  - Manual 375 mL Cartridge Dispensing Guns
    - Manual Dispensing Gun: 3004456
    - Manual Dispensing Gun: 3004477
  - Manual 20 mL Cartridge Dispensing Guns
    - Manual Dispensing Gun: 3004479
    - Plunger (4 x): 3004479
  - Manual CX (404 mL) Cartridge Dispensing Guns
    - Manual Dispensing Gun: 3004479
    - Manual Dispensing Gun: 3004479

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- Specialty Adhesives
  - NO-MIX ADHESIVES
  - For use adhesives - metal or white metal and accelerator into separate surfaces. Mix when ready for fast set.
  - LORD AP-154 Adhesive Enhancer/Surface Modifier
    - 4 oz Bottle: 3004460
    - Gallon: 3004469
Use the chart below to choose the proper adhesive for sign bonding applications. For more detailed information on these adhesives and surface preparation, call the Parker LORD Customer Support Center.

<table>
<thead>
<tr>
<th>Surface Type</th>
<th>Surface Preparation</th>
<th>Adhesive Selection</th>
</tr>
</thead>
<tbody>
<tr>
<td>Steel*</td>
<td>Coarse grit sanding or grinder, wipe with IPA to remove sanding dust</td>
<td>Signlok 204</td>
</tr>
<tr>
<td>Aluminum/Steel*</td>
<td>Sand with scuff pad or 120-grit paper, solvent wipe</td>
<td>Signlok 8 10</td>
</tr>
<tr>
<td>Composite</td>
<td>Non-porous (Smooth/Fine grit paper, solvent wipe</td>
<td>Signlok 4xx</td>
</tr>
<tr>
<td>Aluminum</td>
<td>Non-porous (Smooth/grit paper, solvent wipe</td>
<td>Signlok 4xx</td>
</tr>
<tr>
<td>Aluminum/Prefinished Metal</td>
<td>Wipe with clean dry cloth</td>
<td>Signlok 4xx</td>
</tr>
<tr>
<td>Aluminum/Composite</td>
<td>Wipe with clean dry cloth</td>
<td>Signlok 4xx</td>
</tr>
<tr>
<td>Aluminum/Poly-Metal</td>
<td>Wipe with clean dry cloth</td>
<td>Signlok 4xx</td>
</tr>
<tr>
<td>Aluminum/NuAlum</td>
<td>Wipe with clean dry cloth</td>
<td>Signlok 4xx</td>
</tr>
<tr>
<td>Aluminum/Duraplex</td>
<td>Wipe with clean dry cloth</td>
<td>Signlok 4xx</td>
</tr>
<tr>
<td>Aluminum/Alumalite</td>
<td>Wipe with clean dry cloth</td>
<td>Signlok 4xx</td>
</tr>
<tr>
<td>Aluminum/Implex</td>
<td>Wipe with clean dry cloth</td>
<td>Signlok 4xx</td>
</tr>
<tr>
<td>Aluminum/Gatorfoam</td>
<td>Wipe with clean dry cloth</td>
<td>Signlok 4xx</td>
</tr>
<tr>
<td>Aluminum/Komatex</td>
<td>Wipe with clean dry cloth</td>
<td>Signlok 4xx</td>
</tr>
<tr>
<td>Stainless Steel</td>
<td>Non-porous (Smooth/wipe with isopropyl alcohol to remove sanding dust</td>
<td>Signlok 4xx</td>
</tr>
<tr>
<td>Stainless Steel</td>
<td>Porous (Scuff with scuff pad or 120-grit paper, solvent wipe</td>
<td>Signlok 4xx</td>
</tr>
<tr>
<td>Stainless Steel</td>
<td>Porous (Contact LORD 7542 for more information</td>
<td>Signlok 4xx</td>
</tr>
<tr>
<td>Stainless Steel</td>
<td>Porous (Contact LORD for more information</td>
<td>Signlok 4xx</td>
</tr>
<tr>
<td>Stainless Steel</td>
<td>Porous (Contact LORD for more information</td>
<td>Signlok 4xx</td>
</tr>
</tbody>
</table>

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

For use in clear bonding, gap-filling or bonding wood or other porous substrates, the LORD 7530 series often tough, flexible adhesives in a variety of grades. The LORD 7530/A (clear) or bonding intensive materials to polyurethane/fiberglass.

Technical Data

**Product**
- **Plastic Bonding Adhesives**

**Applications**
- **Metal Bonding Adhesives**
- **Plastic Bonding Adhesives**
- **Cross Bonding Adhesives**
- **Specialty Adhesives**

**Product Features**
- **Aesthetic Assemblies**
- **Expansion**
- **Subject to Thermal**
- **Larger, Outdoor Assemblies**
- **Cross Bonding** (Metal to Plastic)

**Technical Data Accessories**
- **Technical Data reported at 70-77°F (21-25°C).**

**Dispensing Equipment**
- **Manual 335 mL Cartridge Dispensing Guns**
- **Manual 8 mL Cartridge Dispensing Guns**
- **Manual 50 mL Cartridge Dispensing Guns**
- **Manual 30 mL Cartridge Dispensing Guns**
- **Manual 20 mL Cartridge Dispensing Guns**

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**Metal Bonding Adhesives**

- **Metal Frame Assembly**
- **Channel Letter Assembly**
- **Other Uses**

**Dispensing Equipment**

- **Manual 335 mL Cartridge Dispensing Guns**
- **Manual 8 mL Cartridge Dispensing Guns**
- **Manual 50 mL Cartridge Dispensing Guns**
- **Manual 20 mL Cartridge Dispensing Guns**
- **Manual 30 mL Cartridge Dispensing Guns**
Adhesive Selection

Use the chart below to choose the proper adhesive for sign bonding applications. For more detailed information on these adhesives and surface preparation, call the Parker LORD Customer Support Center.

<table>
<thead>
<tr>
<th>Surface</th>
<th>Surface Preparation</th>
<th>Adhesive *</th>
<th>Description *</th>
<th>Applications *</th>
<th>Notes *</th>
</tr>
</thead>
<tbody>
<tr>
<td>Steel</td>
<td>Scuff with scuff pad or 120-grit paper, solvent wipe</td>
<td>7550**</td>
<td>Peelable acrylic adhesive</td>
<td>Non-structural bonding</td>
<td>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 enhance bond strength.</td>
</tr>
<tr>
<td>Aluminum</td>
<td>Scuff with scuff pad or 120-grit paper, solvent wipe</td>
<td>7542**</td>
<td>Peelable acrylic adhesive</td>
<td>Non-structural bonding</td>
<td>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 enhance bond strength.</td>
</tr>
<tr>
<td>Wood</td>
<td>Wipe with clean dry cloth</td>
<td>320/322 †</td>
<td>Peelable acrylic adhesive</td>
<td>Non-structural bonding</td>
<td>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 enhance bond strength.</td>
</tr>
<tr>
<td>Concrete</td>
<td>Wipe with clean dry cloth</td>
<td>320/322 †</td>
<td>Peelable acrylic adhesive</td>
<td>Non-structural bonding</td>
<td>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 enhance bond strength.</td>
</tr>
<tr>
<td>Porous</td>
<td>Wipe with clean dry cloth</td>
<td>7542**</td>
<td>Peelable acrylic adhesive</td>
<td>Non-structural bonding</td>
<td>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 enhance bond strength.</td>
</tr>
<tr>
<td>Non-porous</td>
<td>Wipe with clean dry cloth</td>
<td>7610DTM</td>
<td>Structural adhesive</td>
<td>Structural bonding</td>
<td>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 enhance bond strength.</td>
</tr>
<tr>
<td>Urethane Foam</td>
<td>Wipe with clean dry cloth</td>
<td>7542**</td>
<td>Peelable acrylic adhesive</td>
<td>Non-structural bonding</td>
<td>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 enhance bond strength.</td>
</tr>
<tr>
<td>Urethane Foam</td>
<td>Wipe with clean dry cloth</td>
<td>7610DTM</td>
<td>Structural adhesive</td>
<td>Structural bonding</td>
<td>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 enhance bond strength.</td>
</tr>
<tr>
<td>Flexible Foam</td>
<td>Wipe with clean dry cloth</td>
<td>7610DTM</td>
<td>Structural adhesive</td>
<td>Structural bonding</td>
<td>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 enhance bond strength.</td>
</tr>
<tr>
<td>Flexible Foam</td>
<td>Wipe with clean dry cloth</td>
<td>7542**</td>
<td>Peelable acrylic adhesive</td>
<td>Non-structural bonding</td>
<td>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 enhance bond strength.</td>
</tr>
</tbody>
</table>

* Adhesive Trade Names are trademarks or registered trademarks of the adhesive supplier.

** 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 enhance bond strength.

† Requires solvent cleaning prior to bonding to remove oils and fats. For non-porous substrates use 320/322 grit paper and solvent wipe.

‡ Requires solvent cleaning prior to bonding to remove oils and fats. For non-porous substrates use 320/322 grit paper and solvent wipe.

§ Requires solvent cleaning prior to bonding to remove oils and fats. For non-porous substrates use 320/322 grit paper and solvent wipe.

** Peelable acrylic adhesive is recommended for use on large, non-structural, non-heat sensitive substrates where removal of bond lines is expected. Peelable acrylic adhesive is also recommended for use on large, non-structural, non-heat sensitive substrates where removal of bond lines is expected.

For more on specifying peelable acrylates, contact us at lord.com or call 877 ASK LORD (275 5673).

Parker LORD
Engineered Materials Group
111 LORD Drive
Cary, NC 27511-7923
USA
Phone: 1 877 ASK LORD (275 5673)
www.lord.com

SPECIAL THANKS TO:
SignComp for the Sign Industry Selector Guide