LORD® Maxlok™ MX/T3, MX/T6 and MX/T18 Acrylic Adhesives

LORD® Maxlok™ MX/T3, MX/T6 and MX/T18 acrylic adhesives replace welding, brazing, riveting and other mechanical fastening methods especially over a wide range of temperature environments subject to high impact or high peel loads.

**Features & Benefits**

**Versatile** – bonds a wide range of unprepared metals with minimal substrate preparation.

**Temperature Resistant** – performs at temperatures from -40 to +300°F (-40 to +149°C).

**Environmentally Resistant** – resists dilute acids, alkalis, solvents, greases, oils, moisture, salt spray and weathering; provides excellent resistance to indirect UV exposure.

**UL Rated** – Maxlok MX/T6 adhesive system is UL 746C certified.

**Precise Bondline** – allows precise control of adhesive bondline thickness due to its content of glass beads, 0.01” (0.025 cm) diameter.

**Non-Sag** – remains in position when applied on vertical or overhead surfaces, allowing for greater process flexibility.

<table>
<thead>
<tr>
<th>Part #</th>
<th>Description</th>
<th>SAP #</th>
<th>Cartridge Size</th>
<th>Case Qty</th>
<th>Net Weight/Container</th>
</tr>
</thead>
<tbody>
<tr>
<td>MX/T3</td>
<td>LORD Maxlok T3 Acrylic Adhesive with MX Accelerator</td>
<td>3022875</td>
<td>50 mL</td>
<td>12</td>
<td>0.132</td>
</tr>
<tr>
<td></td>
<td></td>
<td>3019950</td>
<td>375 mL</td>
<td>12</td>
<td>1.059</td>
</tr>
<tr>
<td>MX/T6</td>
<td>LORD Maxlok T6 Acrylic Adhesive with MX Accelerator</td>
<td>3019632</td>
<td>50 mL</td>
<td>12</td>
<td>0.132</td>
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<tr>
<td></td>
<td></td>
<td>3019621</td>
<td>375 mL</td>
<td>12</td>
<td>1.059</td>
</tr>
<tr>
<td>MX/T18</td>
<td>LORD Maxlok T18 Acrylic Adhesive with MX Accelerator</td>
<td>3021934</td>
<td>50 mL</td>
<td>12</td>
<td>0.132</td>
</tr>
<tr>
<td></td>
<td></td>
<td>3019922</td>
<td>375 mL</td>
<td>12</td>
<td>1.059</td>
</tr>
</tbody>
</table>
APPLICATION

Surface Preparation – remove grease, loose contamination or poorly adhering oxides from metal surfaces. Normal amounts of mill oils and drawing compounds usually do not present a problem in adhesion. Most plastics require a simple cleaning before bonding. Some may require abrading for optimum performance.

Mixing – mix Maxlok adhesive with the proper amount of Maxlok MX accelerator. Handheld cartridges will automatically dispense the correct volumetric ratio of each component. Even color distribution visually indicates a thorough mix. Once mixed, the adhesive cures rapidly.

Typical Properties* of Adhesive Mixed with Accelerator

<table>
<thead>
<tr>
<th></th>
<th>MX/T3</th>
<th>MX/T6</th>
<th>MX/T18</th>
</tr>
</thead>
<tbody>
<tr>
<td>Mix Ratio by Volume, Accelerator to Adhesive</td>
<td>1:4</td>
<td>1:4</td>
<td>1:4</td>
</tr>
<tr>
<td>Solids Content, %</td>
<td>100</td>
<td>100</td>
<td>100</td>
</tr>
<tr>
<td>Working Time, min @ 77°F (25°C)</td>
<td>3-5</td>
<td>6-9</td>
<td>18-24</td>
</tr>
<tr>
<td>Time to Handling Strength, min @ 77°F (25°C)</td>
<td>6-8</td>
<td>20-24</td>
<td>48-72</td>
</tr>
<tr>
<td>Mixed Appearance</td>
<td>Grey Paste</td>
<td>Grey Paste</td>
<td>Grey Paste</td>
</tr>
<tr>
<td>Tensile Strength at Break, psi (MPa)</td>
<td>2800 (19.3)</td>
<td>2800 (19.3)</td>
<td>2800 (19.3)</td>
</tr>
</tbody>
</table>

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

Metal Bond Performance**

<table>
<thead>
<tr>
<th></th>
<th>Aluminum to Aluminum</th>
<th>HDG to HDG</th>
<th>EZG to EZG</th>
</tr>
</thead>
<tbody>
<tr>
<td>Lap Shear @ Room Temperature, psi (MPa) Failure Mode</td>
<td>2760 (19) C</td>
<td>2410 (16.6) C</td>
<td>2190 (15.1) C</td>
</tr>
<tr>
<td>T-Peel, pli (N/mm) Failure Mode</td>
<td>41 (7.2) C</td>
<td>53 (9.3) C</td>
<td>54 (9.5) C</td>
</tr>
</tbody>
</table>

Plastic/Composite Bond Performance**

<table>
<thead>
<tr>
<th></th>
<th>ABS to ABS</th>
<th>FRP to FRP</th>
</tr>
</thead>
<tbody>
<tr>
<td>Lap Shear @ Room Temperature, psi (MPa) Failure Mode</td>
<td>520 (3.6) SB</td>
<td>1280 (8.8) FT</td>
</tr>
</tbody>
</table>

**Bond performance data was obtained using LORD Maxlok MX/T6 adhesive. Please contact LORD Corporation regarding the use and/or performance of using other adhesive/accelerator combinations (+1 877 ASK LORD).

Failure Mode Definition

- Adhesive Failure (A)
- Cohesive Failure (C)
- Fiber Tear (FT)
- Stock Break (SB)

For more information visit us at LORD.com or call +1 877 ASK LORD (275 5673) to speak with a customer representative.