

LORD® 7556 Urethane Adhesive

Description

LORD® 7556 adhesive is an equal-mix, two-component clear urethane adhesive system used to bond Lexan®, ABS, polycarbonate and other plastics. This adhesive will also bond primed metals.

Features and Benefits

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

Environmentally Recommended – does not contain ozone depleting chemicals.

Environmentally Resistant – resists sunlight, weathering, humidity and salt spray.

Chemically Resistant – solvent resistant when cured. Painting and most cleaning processes do not affect bond strength.

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

Lexan is a trademark of SABIC Innovative Plastics.

Application

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

Mixing – Mix resin with the appropriate 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. Assemble parts within working time of the adhesive.

Curing – LORD 7556 adhesive will cure to full strength in 24 hours at 77°F (25°C).

Cleanup – Clean equipment and tools prior to the adhesive cure with solvents such as acetone or methyl ethyl ketone (MEK). Do not use alcohol. Once adhesive is cured, heat the adhesive to 300°F (149°C) or above to soften the adhesive. This allows the parts to be separated and the adhesive to be more easily removed. Some success may be achieved with commercial adhesive strippers.

Typical Properties*

	7556-A Resin	7556-B Curative	7556-C Curative
Appearance	Translucent Paste	Translucent Paste	Clear Liquid
Viscosity, cP @ 77°F (25°C)	40,000-160,000	95,000-300,000	80,000-300,000
Density			
lb/gal	9.64-10.04	9.2-9.6	9.2-9.6
(kg/m ³)	(1155-1203)	(1102-1150)	(1102-1150)
Flash Point (Closed Cup), °F (°C)	>200 (>93)	>200 (>93)	>200 (>93)

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

LORD TECHNICAL DATA

Shelf Life/Storage

Shelf life is six months when stored in a clean, dry environment at 70-80°F (21-27°C) in original, unopened container.

After opening, protect adhesive from excessive exposure to moisture by replacing protective cap on the cartridge.

Cautionary Information

Before using this or any 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

	7556-A/B	7556-A/C
Mix Ratio, by Volume		
Resin to Curative	1:1	1:1
Solids Content by Weight, %	100	100
Working Time, min	3-5 @ 77°F (25°C)	4-6 @ 90°F (32°C)
Time to Handling Strength, min	60 @ 77°F (25°C)	90-140 @ 73°F (23°C)

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Values stated in this technical data sheet 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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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.

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