



# Accelerator 26

## No-Mix Accelerator for Acrylic Adhesive

### Description

Lord® Accelerator 26 is a no-mix curative designed to be utilized with acrylic adhesive resins. Accelerator 26 has no chlorinated solvents. This product can be used with the Lord 200 and 500 series acrylic adhesive resins.

### Features and Benefits

**Convenient Cure Properties** - when used in conjunction with Lord adhesives, full properties are obtained at room temperature.

**Extended Layover** - once the accelerator has been applied and permitted to dry, the coated parts may be stored for 4 weeks if kept below 27°C (80°F), and out of direct sunlight.

**Flexible Application** - can be brushed, wiped, sprayed or dipped onto one or both of the surfaces to be bonded. It will dry in approximately 15 minutes to an off-white crystalline film.

**Extended Working Time** - assembly time is not limited since the adhesive does not begin to cure until it comes in contact with the surface coated with the dry accelerator.

**Excellent Environmental Resistance** - when used with Lord acrylic adhesive resins, the resulting bond resists common environmental conditions.

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### Typical Properties\* of Uncured Lord Accelerator 26

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Appearance	Clear Amber to White Liquid
Viscosity, cP Brookfield LVT #1 @ 30rpm	<10
Density pounds/gallon	7.5 - 8.5
Grams/cubic centimeter	0.9 - 1.0
Total Solids Content by Weight	10%
Flash Point	>43°C (>109°F)
Shelf Life**	6 Months

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

\*\*From date of shipment from Lord Corporation when stored in the original, unopened container.

## Surface Preparation

For heavily contaminated surfaces such as dirt, oil, or grease, use a solvent wipe prior to application of accelerator.

## Mixing

Lord Accelerator 26 requires no mixing prior to use.

## Application

Lord Accelerator 26 can be brushed, wiped, sprayed, or dipped on to one or both of the surfaces to be bonded. Lord Accelerator 26 applied to one surface will cure bondline thicknesses up to 0.015 inches. For bondlines greater than 0.015 and up to 0.030 inches, apply the accelerator to both surfaces. It is preferable to use a light coat of the accelerator.

The accelerator will dry in approximately 15 minutes. Once dry, place adhesive resin on the other surface to be bonded, and join the parts. A part coated with Lord Accelerator 26 can be stored for a number of weeks if kept below 27°C (80°F) and out of direct light, especially sunlight. Keep parts covered to avoid contamination.

## Curing

Drying time is a good qualitative check for Lord Accelerator 26. Fresh accelerator will dry to a white crystalline film within 15 minutes. As the accelerator ages, it will dry more slowly. If the accelerator does not dry within 60 minutes, it should be disposed of in compliance with applicable regulations.

Values stated in this bulletin 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 Service Department.

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## Clean Up

### *Uncured Adhesive*

It is important to clean up excess adhesive on the bonded assembly, as well as mixing and application equipment, before the adhesive cures. Use hot water and detergent or an organic solvent; ketones have been shown to work best.

### *Cured Adhesive*

Removing cured Lord adhesive is difficult due to its resistance to chemicals, solvents, and cleaning agents. Heating to 204°C (400°F) or greater will soften the adhesive, allowing the parts to be separated and the adhesive to be more easily removed.

## Storage Information

For maximum shelf life, ship and store Lord Accelerator 26 in the original container between 4°C (40°F) and 27°C (80°F), but preferably below 21°C (70°F). Exposure to temperatures greater than 27°C (80°F) will shorten shelf life and temperatures greater than 38°C (100°F) will severely shorten the shelf life.

## Cautionary Information

Before using this or any Lord product, refer to the Material Safety Data Sheet (MSDS) 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.

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