

LORD® Structural Adhesives

for Solar Panel Roof Mounting



Looking for non-penetrating solutions for the solar industry? Application of LORD adhesives for solar panel roof mounting is quick and easy.

Benefits:

- Reduces installation time
- Eliminates drilling and bolting
- Metal roof stays intact
- No water leakage
- No electricity required
- Protects roof warranty
- Improved aesthetics

LORD 810/20GB

Acrylic Adhesive Properties

- Two-component acrylic adhesive (2:1)
- Flexible, low-exotherm, low-shrinkage, structural adhesive
- Fast cure speed even in low temperatures
- Contains glass beads for precise bondline control

Typical Cure Properties

- 100% Solids
- Work Time: 8 minutes
- Time to Handling Strength: 15 minutes
- Tensile Strength: 841 psi (5.8 MPa)
- Elongation: 190%
- Tg: 43°C
- Shore Hardness (D): 40
- Mixed adhesive is grey in color



LORD 320/322

Epoxy Adhesive Properties

- High load bearing strength
- Contains no solvent, nonflammable & virtually odorless
- High temperature resistant: -40°C to 204°C
- Chemically resistant

Typical Cure Properties

- 100% Solids
- Work Time: 20-40 minutes
- Time to Handling Strength: 2-4 hours
- Tensile Strength: 4440 psi (30.6 MPa)
- Elongation: 3%
- Tg: 80°C
- Shore Hardness (D): --
- Mixed adhesive is grey in color



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Indian Institute of Technology (IIT) Tested



How to Apply

1. Mark the roof as per the solar panel installation for bracket bonding.
2. Grind / Abrade the coated roof bracket overlap area.
3. Apply the adhesive on the roof area as per the marking.
4. Mate the bracket with roof and leave it for 45-60 minutes.
5. Mount the solar panel on the bracket after 60 minutes.

IIT Testing Details

1. Corrosion test (Salt Spray test as per ASTM B 117)
2. UV resistance of bonded assembly as per ASTM G 154
3. Humidity test as per ASTM D 2247
4. Heat resistance test (-15°C to 50°C)
5. 200 km/hr wind speed simulation of bonded assembly
6. Lap Shear Strength as per ASTM D 1002
7. Water vapor permeability test as per ASTM D 1653, LORD 320/322



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