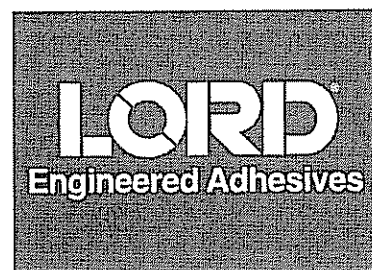


## PRODUCT INFORMATION

# Accelerator 4

## No-Mix Accelerator for Acrylic Adhesive



### Description

Lord® Accelerator 4 is a no-mix curative used with acrylic adhesive resins. Lord Accelerator 4 is not a stand alone adhesive; it must be used with acrylic adhesive resins. Lord Accelerator 4 can be used with Lord 200 and Lord 500 series acrylic adhesive resins.

### Features and Benefits

**Convenient Cure Properties** - cures at room temperature and can be used with all Lord acrylic adhesive resins.

**Extended Layover** - allows dried parts to be stored for 4 weeks at temperatures <27°C (<80°F), if kept out of direct sunlight and free from dust and contaminants.

**Flexible Application** - allows for brush, wipe, spray or dip applications. Can be applied to one or both surfaces to be bonded and dries in approximately one minute to an off-white crystalline film.

**Extended Work Time** - prevents assembly delays as adhesive does not cure until it comes in contact with dry coated accelerator parts.

**Environmental Resistance** - accompanies Lord acrylic adhesive resins to provide a bond which resists common environmental conditions.

---

### Typical Properties\* of Lord Accelerator 4 Curative

---

Appearance	Clear amber to white liquid
Viscosity, cP Brookfield Model LVT Spindle #3 @ 12 rpm @ 25°C (77°F)	<10
Density g/cm <sup>3</sup> lb/gal	10.2 - 10.7 1.22 - 1.28
Total Reactive Solids Content by weight	10%
Active Ingredient	Organic peroxide
Flash Point	>93°C (>200°F)
Shelf Life	Six months from date of shipment, 4°C - 21°C (40°F - 70°F), unopened container.

---

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

## Surface Preparation

See the product bulletin instructions for the adhesive being used with this accelerator.

## Application

Apply Lord Accelerator 4 by brush, wipe, spray, or dip methods to one or both surfaces to be bonded. Lord Accelerator 4 applied to one surface will cure bondline thicknesses up to 635 microns (25 mils).

For bondline thicknesses of 508 - 1016 microns (20 - 40 mils), apply Lord Accelerator 4 to both surfaces. It is suggested to use a thin coat of Lord Accelerator 4. Once dry, place the adhesive resin on the other surface to be bonded, and join the parts.

Lord Accelerator 4 will dry in approximately one minute to an off-white crystalline film. If Lord Accelerator 4 does not dry within five minutes, dispose of the material in compliance with regulations.

Coated parts can be stored for 4 weeks at temperatures <27°C (<80°F), if kept out of direct sunlight and free from dust and contaminants.

## Clean Up

Uncured - Clean up excess adhesive on the bond assembly, as well as the mixing and application equipment before the adhesive sets up. Use hot water and detergent or an organic solvent; ketones have been shown to work best.

Cured - Heat to 204°C (400°F) or higher to soften the adhesive. This will allow the parts to be separated and the adhesive to be more easily removed.

## Packaging

- 1 Ounce Bottle (0.03 Liter)
- 8 Ounce Bottle (0.24 Liter)
- 1 Gallon Container (3.8 Liter)
- 55 Gallon Drum (208 Liter)

## Storage

For maximum shelf life, ship and store Lord Accelerator 4 curative in the original container between 4°C - 21°C (40°F - 70°F). Temperatures above this range will shorten the shelf life. Optimum storage temperatures are between 4°C - 10°C (40°F - 50°F).

## 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.

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

Information provided herein is based upon tests believed to be reliable. Inasmuch as Lord Corporation has no control over the manner in which others may use this information, it does not guarantee the results to be obtained. In addition, Lord Corporation does not guarantee the performance of the product or the results obtained from the use of the product or this information where the product has been repackaged by any third party including but not limited to any product end user. Nor does the company make any express or implied warranty of merchantability, or fitness for a particular purpose concerning the effects or results of such use.

Lord is a registered trademark of Lord Techmark, Inc., a subsidiary of Lord Corporation  
©Lord Corporation Printed in USA DS3477 (Rev 2 4/04)

**RUDOLPH BROS. & CO.**  
P.O. BOX 425  
CANAL WINCHESTER, OH 43110  
(614) 833-0707  
ORDER FAX 1-800-600-9508

**LORD**