



LORD® Structural Adhesives for Utility and Class Eight Trailers

SELECTOR GUIDE

LORD
AskUsHow™

LORD® Structural Adhesives provide trailer manufacturers with improved aesthetics and increased throughput with overall cost savings.

Our adhesives provide improved quality and an overall improvement in strength and durability, while reducing costs and cycle times. Unlike rivets, our engineered solutions deliver enhanced interior and exterior aesthetics tailored to meet your demanding manufacturing needs. Our proven solutions have supported the transportation market for 40 years!



PRODUCT	SUBSTRATE	TYPICAL PROPERTIES*				
	Metal-to-Metal	Work Time	Mix Ratio by Volume, Adhesive to Accelerator	Time to Handling Strength	Accelerator(s)	Mixed Appearance
	Metal-to-Composite Metal-to-Plastic Composite					
MAXLOK® T3 ACRYLIC ADHESIVE WITH MX ACCELERATOR	✓	3-5 min. @ 77°F (25°C)	4:1	6-8 min. @ 77°F (25°C)	MX	Grey Paste
MAXLOK® T6 ACRYLIC ADHESIVE WITH MX ACCELERATOR	✓	6-9 min. @ 77°F (25°C)	4:1	20-24 min. @ 77°F (25°C)	MX	Grey Paste
MAXLOK® T18 ACRYLIC ADHESIVE WITH MX ACCELERATOR	✓	18-24 min. @ 77°F (25°C)	4:1	48-72 min. @ 77°F (25°C)	MX	Grey Paste
LORD® 403 ACRYLIC ADHESIVE WITH ACCELERATOR 19	✓	2-4 min. @ 75°F (24°C)	4:1	4-6 min. @ 75°F (24°C)	A19, A19 Black, A19GB, A19GB Red, A19GB Grey	Tan Paste**
LORD® 406 ACRYLIC ADHESIVE WITH ACCELERATOR 19	✓	6-10 min. @ 75°F (24°C)	4:1	12-17 min. @ 75°F (24°C)	A19, A19 Black, A19GB, A19GB Red, A19GB Grey	Tan Paste**
LORD® 410 ACRYLIC ADHESIVE WITH ACCELERATOR 19	✓	20-45 min. @ 75°F (24°C)	4:1	60-120 min. @ 75°F (24°C)	A19, A19 Black, A19GB, A19GB Red, A19GB Grey	Tan Paste**
LORD® 810 LOW READ-THROUGH (LRT) ACRYLIC ADHESIVE WITH LORD ACCELERATOR 20GB	✓	8-12 min. @ 70°F (21°C)	2:1	20-25 min. @ 70°F (21°C)	A20GB	Grey Paste
LORD® 7610DTM DIRECT-TO-METAL ADHESIVE/SEALANT	✓	25 min. @ 77°F (25°C)	N/A	Skin Time: 15-45 min. @ 77°F (25°C), 50% RH	N/A	White, Black or Grey Paste

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

**Mixed appearance will vary based on accelerator used.

LORD® Structural Adhesives for Trailer Applications



1 Sidewall Bonding:
Fiberglass Reinforced Plywood,
Aluminum and Galvanized

3 Front Panel Bonding:
Fiberglass Reinforced Plywood,
Aluminum and Galvanized

2 Roof Bonding:
Fiberglass Reinforced Plywood, Aluminum,
Galvanized and Composites

4 Bonded HVAC Units:
Fiberglass Reinforced Plywood,
Aluminum and Galvanized



BEAD DIAMETER ESTIMATOR - INCHES (CM)

Required Bead Diameter: Use the table below to determine the required bead diameter from the dimensions of the adhesive joint.

BONDLINE WIDTH - IN (CM)							
		0.25 (0.60)	0.50 (1.80)	1.00 (2.50)	2.00 (5.10)	4.00 (10.20)	8.00 (20.30)
BONDLINE THICKNESS - IN (MM)	0.01 (0.25)	0.06 (0.14)	0.08 (0.20)	0.11 (0.29)	0.16 (0.41)	0.23 (0.57)	0.32 (0.81)
	0.02 (0.50)	0.08 (0.20)	0.11 (0.29)	0.16 (0.41)	0.23 (0.57)	0.32 (0.81)	0.45 (1.15)
	0.04 (1.00)	0.11 (0.29)	0.16 (0.41)	0.23 (0.57)	0.32 (0.81)	0.45 (1.15)	0.64 (1.62)
	0.08 (2.00)	0.16 (0.41)	0.23 (0.57)	0.32 (0.81)	0.45 (1.15)	0.64 (1.62)	0.90 (2.29)

BEAD LENGTH ESTIMATOR - FEET (M)

Linear Coverage: Use the table below to determine the length of adhesive bead that can be obtained from a cartridge of adhesives.

BEAD DIAMETER - IN (CM)							
		0.125 (0.30)	0.188 (0.48)	0.250 (0.60)	0.313 (0.80)	0.375 (0.95)	0.500 (1.30)
CARTRIDGE VOLUME (ML)	40	17 (5.00)	7.4 (2.20)	4.1 (1.30)	2.7 (0.80)	1.8 (0.60)	1.0 (0.30)
	50	21 (6.30)	9.2 (2.80)	5.2 (1.60)	3.3 (1.00)	2.3 (0.70)	1.3 (0.40)
	200	83 (25.20)	37 (11.20)	21 (6.30)	13 (4.00)	9 (2.80)	5.2 (1.60)
	375	155 (47.20)	69 (21.00)	39 (11.80)	25 (7.60)	17 (5.20)	10 (3.10)
	400	166 (50.40)	74 (22.40)	41 (12.60)	27 (8.10)	18 (5.60)	10 (3.10)
	485	201 (61.10)	89 (27.20)	50 (15.30)	32 (9.80)	22 (6.80)	13 (3.80)
	600	249 (75.60)	111 (33.60)	62 (18.70)	40 (12.10)	28 (8.40)	16 (4.70)

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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 ... Ask Us How.

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