

# LORD® 663/Accelerator 17 Acrylic Adhesive

## Description

LORD® 663/Accelerator 17 adhesive is a two-component acrylic adhesive system used to bond composites including DCPD (dicyclopentadiene) resin and modified DCPD resin based FRP (fiber reinforced plastic). LORD 663/Accelerator 17 adhesive can also cross-bond composites to many metals.

LORD 663/Accelerator 17 adhesive utilizes a unique patented technology to create exceptionally strong bonds with excellent surface cure and minimal surface preparation.

## Features and Benefits

**Versatile** – bonds difficult-to-bond composites, such as DCPD-based FRP, with minimal surface preparation.

**Environmentally Resistant** – resists dilute acids, alkalis, solvents, water immersion, moisture and weathering.

**Gap Filling Capability** – fills gaps as large as 25.4 mm (1.0 inch).

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

## Application

**Surface Preparation** – Surfaces should be free of grease, dirt and other contaminants. Some surfaces may require abrading for optimum performance.

**Mixing** – Using automatic meter/mix/dispense equipment, mix LORD 663 adhesive with LORD Accelerator 17 at a ratio of 10:1, by volume. Once mixed, the adhesive begins to cure.

**Applying** – Apply adhesive using automatic meter/mix/dispense equipment. Contact your LORD representative if assistance is needed using this equipment.

**Curing** – Cure begins immediately once adhesive and accelerator are mixed. Handling strength is achieved within 130-160 minutes. Complete cure will take 24 hours at room temperature, depending on temperature and bondline thickness. Adhesive will cure to a tack-free surface.

**Cleanup** – Clean equipment and tools prior to the adhesive cure with solvents such as isopropyl alcohol, acetone or methyl ethyl ketone (MEK).

## Typical Properties\*

	<b>663</b>	<b>Accelerator 17</b>
Appearance	White/Off-white/ Blue Tint Paste	Off-white Liquid
Viscosity, cP Brookfield RVT T-TD, 5 rpm	125,000 - 350,000	10,000 - 100,000
Density kg/m <sup>3</sup> (lb/gal)	1055 - 1174 (8.8 - 9.8)	1150 - 1246 (9.6 - 10.4)
Flash Point, °C (°F)	15 (59)	>93 (>200)

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

# LORD TECHNICAL DATA

## Shelf Life/Storage

Shelf life is one year when stored below 27°C (80°F) in original, unopened container. Storage temperatures of 4-10°C (40-50°F) are recommended. If stored cold, allow product to return to room temperature before using. Protect from exposure to direct sunlight.

LORD 663 acrylic adhesive is flammable. Do not store or use near heat, sparks or open flame.

## 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 Adhesive Mixed with Accelerator

Mix Ratio, Adhesive to Accelerator

by Weight	10:1
by Volume	10:1
Solids Content, %	100
Working Time, min @ 23°C (70°F) 1" diameter bead	45-75
Time to Handling Strength**, min 100 psi Lap Shears in 30 mil x 1" x 1"	130-160

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

\*\*Time may change if bondline dimension and temperature vary.

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 Corporation World Headquarters

111 Lord Drive  
Cary, NC 27511-7923  
USA

### Customer Support Center (in United States & Canada)

+1 877 ASK LORD (275 5673)

[www.lord.com](http://www.lord.com)

For a listing of our worldwide locations, visit [LORD.com](http://LORD.com).

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