

Cross Bonding with LORD Sign Assembly Adhesives

	Trade Name †	Surface Preparation	Aluminum/Steel*	Prefinished Metal & Aluminum Composite Material (ACM)	Polycarbonate*	Acrylic*	Urethane Foam	PVC Foam Board	Ceramic/Stone	Wood
Aluminum/Steel*	—	Solvent wipe with isopropyl alcohol	Signlok 4xx Signlok 810 4xx/19 2xx	Signlok 4xx Signlok 810 4xx/19	Signlok 810	Contact LORD	7610DTM** 7542**	Signlok 4XX Signlok 810 4xx/19	320/322 †	7610DTM
Stainless Steel	—	Solvent wipe with isopropyl alcohol, mechanically abrade with 80-grit paper or grinder, wipe with IPA to remove sanding dust	Signlok 4xx Signlok 810 4xx/19 2xx	Signlok 4xx Signlok 810 4xx/19	Signlok 810	Contact LORD	7610DTM** 7542**	Signlok 4xx Signlok 810 4xx/19	320/322 †	7610DTM
Prefinished Metal & Aluminum Composite Material (ACM)	AlumaCorr™ NuAlum™ Poly-Metal™ Alumalite™ DiBond® Econolite™ MAXX™ Alucobond® Anodized Alucobond®	Factory painted metal or ACM panels: solvent wipe Shop painted or other finishes: remove by sanding prior to bonding	Signlok 4xx Signlok 810 4xx/19	Signlok 4xx Signlok 810 4xx/19	Signlok 810 7542 7610DTM	7542 7610DTM ⁿ	7542 7650 7610DTM	Signlok 4xx Signlok 810 4xx/19 7542 7650 7610DTM	320/322 †	7542 7650 7610DTM
Polycarbonate*	Lexan® Tuffak®	Solvent wipe with isopropyl alcohol	Signlok 810	7542 7610DTM	Signlok 4xx Signlok 810 4xx/19 7542 7610DTM	7542 7610DTM	7542 7650 7610DTM	7542 7650 7610DTM	7610DTM ⁿ	7542 7650 7610DTM
Acrylic*	Acrylite® Acrysteel® IGP Duraplex® Optix®SG Implex® Plexiglas®G	Scuff with scuff pad or 120-grit paper, solvent wipe with isopropyl alcohol	Contact LORD	7542 7610DTM 7650	7542 7610DTM 7550 ⁿ	7542 7610DTM	7542 7610DTM 7550 ⁿ	7542 7650 7610DTM	7610DTM ⁿ	7542 7650 7610DTM
TrimCap	Jewelite® SignATrim™	Scuff with scuff pad or 120-grit paper, solvent wipe with isopropyl alcohol	Signlok 4xx Signlok 810 4xx/19	7550 ⁿ 7542	7550 ⁿ	7550 ⁿ	7542 7550 ⁿ 7610DTM	7542 7650 7610DTM		7542 7550 ⁿ
Urethane Foam	Precision Board Last-A-Foam® Sign Foam 3® Design Board® CORAFoam®	Blow off surface with clean air or wipe with clean dry cloth	7650 7610DTM 7542	7542 7650 7610DTM	7542 7650 7610DTM	7542 7650 7610DTM	7542 7610DTM	7542 7650 7610DTM	7610DTM	7542 7650 7610DTM
PVC Foam Board	Komatex® Sintra®	Scuff with scuff pad or 120-grit paper, solvent wipe with isopropyl alcohol	Signlok 4xx Signlok 810 4xx/19	Signlok 4xx Signlok 810 4xx/19 7542 7650 7610DTM	7542 7650 7610DTM	7452 7650 7610DTM	7542 7610DTM	Signlok 4xx 4xx/19 7542 7650 7610DTM	7610DTM ⁿ	7542 7650 7610DTM
Paper/Foam Board	Foam-X® Recovery Foam-Cor®	Wipe with clean dry cloth	7542** 7650**	7542 7650	7542	7542	7542	7542	7610DTM	7610DTM
PETG Sheet	Spectar™ PETG	Solvent wipe with isopropyl alcohol	7542** Signlok 4xx Signlok 810 4xx/19	7542** Signlok 4xx Signlok 810 4xx/19	7542	7542	7542	7542	7610DTM	7610DTM
Polystyrene Foam Board	Gatorfoam® Gatorblanks® Gatorplast® Ultra	Wipe with clean dry cloth Solvent wipe with isopropyl alcohol	Signlok 4xx (N/A Gatorblanks®) Signlok 810 (N/A Gatorblanks®) 4xx/19 (N/A Gatorblanks®) 7542** 7610DTM 7650**	Signlok 4xx Signlok 810 4xx/19 7542 7610DTM 7650	7542 7550 ⁿ	7542 7610DTM 7650	7542 7610DTM 7650	7542 7610DTM	7610DTM	7610DTM
Vinyl Laminate	White-Wood® Maxx-Board®	Wipe with clean dry cloth, scuff Solvent wipe with isopropyl alcohol	Signlok 4xx Signlok 810 4xx/19 7542** 7610DTM 7650	Signlok 4xx Signlok 810 4xx/19 7542** 7610DTM 7650	7542 7650	7542 7610DTM 7650	7542 7610DTM	7542 7610DTM	7610DTM	7610DTM
Wood	—	Wipe with clean dry cloth	320/322 †	7542 320/322 † 7650	7542 7650 7610DTM	7542 7650 7610DTM	7542 7610DTM	7542 7650 7610DTM	7610DTM ⁿ	7542 320/322 7650
Ceramic/Stone	—	Porous: Wipe with clean dry cloth Non-porous (Smooth/polished): LORD AP-134 Adhesion Enhancer/Surface Modifier required	320/322 †	320/322 †	7610DTM ⁿ	7610DTM ⁿ	7610DTM ⁿ	7610DTM ⁿ	320/322	7610DTM ⁿ
Cured Concrete	—	Wipe with clean dry cloth	7610DTM 320/322 †	320/322 † 360 7610DTM	7610DTM	7610DTM	N/A	N/A	320/322	7610DTM 320/322
Glass**	—	LORD AP-134 Adhesion Enhancer/Surface Modifier required	Signlok 4xx 4xx/19	Signlok 4xx 4xx/19	N/A	7610DTM	7610DTM	7610DTM	7610DTM	7610DTM

xx Represents numbers for the family of adhesive to be utilized. Contact LORD Customer Support Center, 877 ASK LORD (275 5673).

† All substrate Trade Names are trademarks or registered trademarks of the substrate supplier.

** Coefficient of thermal expansion is a major consideration when cross-bonding these substrates. Acrylic adhesives should not be used to attach large thermoplastic parts due to the differences in thermal expansion.

*** Additional surface preparation recommended: Metals should be painted or primed. Glass, Ceramic and Stone should be primed with LORD AP-134 Adhesion Enhancer/Surface Modifier to promote adhesion, 120 minutes to hydrolyze.

† Prepare metal by scuffing/abrading followed by a solvent wipe.

† For non-structural bonding (assemblies where adhesive is used for aesthetic attachment in minimum stress areas).

 Signlok 403, Signlok 406, LORD 201, 4xx/19 and 7542 are UL recognized.

Each substrate and adhesive should be tested for the specific use in which it will be expected to perform. The information reported here is from laboratory studies and is intended only to provide general information regarding the ability of material to be bonded with LORD® Structural Adhesives.

Dispensing Equipment

				
Container Size	225 mL	50 mL	CX	No-mix adhesives—brush or trowel resin and accelerator onto separate surfaces. Mate when ready for fast set.
Manual Dispensing Gun	3001120	3001112	3004487	
Plunger (2:1)	—	3009588 (one plunger ships with gun)	—	
Plunger (4:1)	—	3004479	—	
Pneumatic Dispensing Gun	3001129	—	—	
Mixing Tip	3001173	3004476	3001179	

For more information visit us at LORD.com/Sign or call +1 877 ASK LORD (275 5673) to speak with a customer representative.



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