



# LORD® Structural Adhesives for Service Work Trucks

SELECTOR GUIDE

**LORD**  
AskUsHow™

Using LORD® adhesives to bond truck bodies during manufacturing, rather than welding or fastening, can reduce labor costs and cycle time. In addition, LORD adhesives increase throughput, reduce material costs and weight, and improve strength. What makes us different is our exceptional technical support dedicated to ensure your every design need is met. Our adhesives bond to various substrates including coated, painted, bare metal substrates, plastics and composites. We offer multiple cure speeds to fit your application requirements. We also offer glass beads for bondline control to prevent over-clamping.



PRODUCT	SUBSTRATE		TYPICAL PROPERTIES*				
	Metal-to-Metal		Work Time	Mix Ratio by Volume, Adhesive to Accelerator	Time to Handling Strength	Accelerator	Mixed Appearance
	Metal-to-Composite						
	Metal-to-Plastic	Composite					
LORD 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
LORD 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
LORD 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 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 850 ACRYLIC ADHESIVE (FAST) WITH ACCELERATOR 25GB	✓		6-10 min. @ 70°F (21°C)	10:1	18-24 min. @ 70°F (21°C)	A25GB	Red Paste
LORD 852 ACRYLIC ADHESIVE (SLOW) WITH ACCELERATOR 25GB	✓		20-25 min. @ 70°F (21°C)	10:1	50-70 min. @ 70°F (21°C)	A25GB	Red 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)	N/A	White, Black or Grey Paste
LORD 7555 A/C URETHANE ADHESIVE/ SEALANT (FAST)	✓		3-5 min. @ 77°F (25°C)	1:1	1 hr. @ 77°F (25°C)	N/A	White Paste
LORD 7555 A/E URETHANE ADHESIVE/ SEALANT (SLOW)	✓		45 min. @ 77°F (25°C)	1:1	5-6 hr. @ 77°F (25°C)	N/A	White Paste

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

# Applications for Service Work Trucks



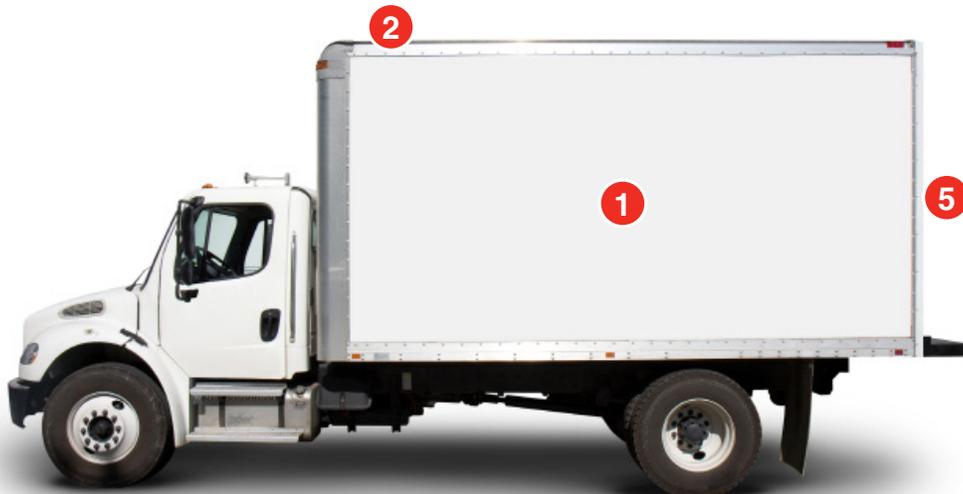
**1 Sidewall Bonding:**  
Improve Aesthetics with Rivet Removal  
and Weld Reduction

**3 Panel Bonding:**  
Improve Warranty and Quality by  
Eliminating Corrosion and Leaks

**2 Roof Bonding:**  
Accelerate Assembly Times While  
Improving Performance and Customer  
Perception

**4 Bonded HVAC Units:**  
Bond and Seal in One Step to Enhance  
Work Flow and Design

**5 Door Closures:**  
Improve Appearance, Dimensional  
Stability and Stiffness



# Applications for Service Work Trucks

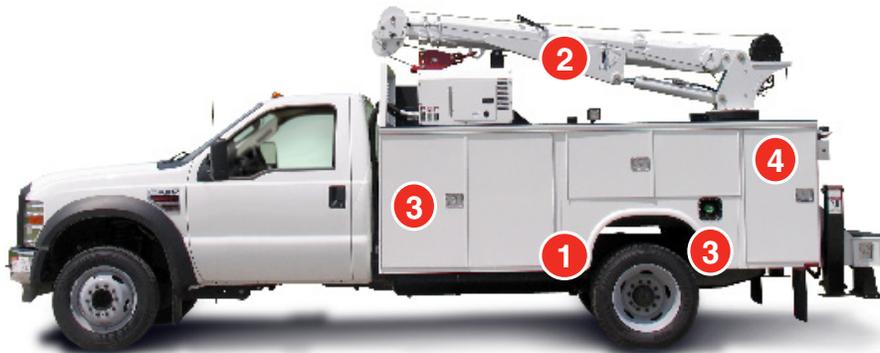


**1 Seam Sealing:**  
Protect Against Corrosion and Cargo Damage,  
Direct-to-Metal Options Reduce Cost and  
Improve Throughput

**3 Metal Bonding:**  
Save Time and Money with Production  
Efficiencies and Reduced Re-work

**2 Plastic Bonding:**  
Bond to Many Types of Plastics and  
Composites and Cross Bond to Metals Which  
Allows for Light Weighting and Sleek Designs.

**4 Rivet/Weld Reduction:**  
Eliminate Leaks, Stress Cracks and  
Durability Issues While Reducing  
Manufacturing and Warranty Costs



LORD, Maxlok and "Ask Us How" are trademarks of LORD Corporation or one of its subsidiaries.

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.

**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).

**LORD**  
Ask Us How™