

LORD® ADHESIVE 661/6

high-temperature acrylic adhesive

Lord® 661 is a two-part acrylic adhesive used with Lord Accelerator 6 to bond FRP composites (Fibre Reinforced Plastic). It can also cross-bond composites to many metals.

Lord® 661 has been extensively tested for use in the marine industry. Ideally suited for the installation of insulation pins for passive fire protection.

It forms an exceptionally strong bond with minimum surface preparation. Its non-sag characteristics make it ideal for applications requiring thicker bond lines.

The working time has been formulated to meet most applications.

The excellent elevated temperature resistance of Lord 661 allows use of the adhesive in bonding perforated pins to FRP/GRP composite panels when applying structural fire protection insulation, acoustic, or thermal insulation.

SPECIFICATIONS

Colour	grey
Packaging	Available in 330ml dual pack cartridge. (Other sizes available on request) hand held packages
Shelf life and storage	<ol style="list-style-type: none"> For maximum shelf life, store Lord 661 Adhesive and Lord Accelerator 6 curative at 4°C to 27°C for 6 months in original unopened container. Do not store above 27°C Cooler storages are recommended, 4°C—10°C. If stored at these cooler temperatures allow the product to return to room temperature before using. Protect from exposure to ultraviolet light. Lord 661 adhesive is flammable. Do not allow open flames or other ignition sources in the area where the adhesive is being stored, mixed, or applied.
Clean up	Clean equipment and tools prior to adhesive cure with solvents such as isopropyl alcohol, acetone, or MEK.



applications

- Bonding metal pins to composites for mounting of fire protection and acoustic materials
- Bonding composite marine lining to the hull
- Bonding decals and finishing panels
- General FRP composite to FRP composite bonding

features

- Bonding versatility— steel, aluminum & FRP/GRP
- Gap filling capabilities
- Retains strength at elevated temperature
- Easy to use “no-fuss” applicator system
- Allows for a non-sag application when applied on vertical surfaces.

MATERIAL PROPERTIES

Product	Appearance	Consistency	Viscosity, cps Brookfield RVT T-D @ 5rpm	Density g/cm ³	Solids Content	Flash Point	Mix Ratio: By weight By volume	Shelf life
LORD 661	White/off-white/ blue tint	Paste	125,000 – 350,000	1.05-1.17	100%	15°C	10 6.9	6 months from date of ship- ment @ 4 to 27°C, in original unopened container
LORD ACCELERATOR 6	Off white		200,000 – 500,000	1.45-1.56		93.3°C	1 1	

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

APPLICATION PROPERTIES

Material	Working Time*	Typical Exotherm Temperature	Handling Strength** 0.69MPa Lap shears at 750mm x 2.5cm x 2.5cm	Full Strength
LORD 661/ ACC.6	15 mins ± 4 min	@ 25°C - 75°C-85°C	45-55 minutes	24 hours

* Given a 2.5cm diameter bead @32°C.

**Time may change if bondline dimension and temperature varies.

SURFACE PREPARATION

To obtain the strongest possible bond, the surface to be bonded should be dry, clean and free from dust, grit, loose material, oil and grease.

- When bonding to fiberglass, remove all waxes or release agents.
- When bonding to gel coated fiberglass, the surface requires sanding and thoroughly cleaned.
- The bond strength on painted surfaces will only be as good as the bond between the paint and the base medium.

CURING

Lord 661 acrylic resin cures at room temperature when used with Lord Accelerator 6 curative. The cure will begin immediately upon mixing. The adhesive will cure to a tack-free surface.

MIXING

Mix the acrylic resin with the accelerator curative at a mix ratio of 10:1, by volume. Set meter/mix/dispense equipment accordingly. Lord-PAKTM cartridges will automatically mix & dispense at the proper ratio.

METER/MIX DISPENSE EQUIPMENT

- This equipment is sold separately. Please contact your local Pyrotek representative.
- Load the cartridge into the applicator gun and re-move the end caps.
- Level the plungers by gunning a small amount of adhesive to ensure both sides are level.
- Attach mixing tip and gun out a mixer's length of adhesive.
- Apply adhesive to substrate, clamp and fixture until adhesive reaches handling strength.



Contact your Pyrotek representative if assistance is needed in using this equipment.

For further information
and contact details,
please visit our website
pyroteknc.com

Caveats: Specifications are subject to change without notice. The data in this document is typical of average values based on tests by independent laboratories or by the manufacturer and are indicative only. Materials must be tested under intended service conditions to determine their suitability for purpose. The conclusions drawn from acoustic test results are as interpreted by qualified independent testing authorities. Nothing here releases the purchaser/user from responsibility to determine the suitability of the product for their project needs. Always seek the opinion of your acoustic, mechanical and fire engineer on data presented by the manufacturer. Due to the wide variety of individual projects, Pyrotek is not responsible for differing outcomes from using their products. Pyrotek disclaims any liability for damages or consequential loss as a result of reliance solely on the information presented. No warranty is made that the use of this information or of the products, processes or equipment to which this Information Page refers will not infringe any third party's patents or rights. DISCLAIMER: This document is covered by Pyrotek standard Disclaimer, Warranty and © Copyright clauses. See pyroteknc.com/disclaimer.

