**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.

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**SPECIFICATIONS**

<table>
<thead>
<tr>
<th>Colour</th>
<th>grey</th>
</tr>
</thead>
<tbody>
<tr>
<td>Packaging</td>
<td>Available in 330ml dual pack cartridge. (Other sizes available on request) hand held packages</td>
</tr>
</tbody>
</table>
| Shelf life and storage | 1. 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  
2. Cooler storages are recommended, 4°C—10°C. If stored at these cooler temperatures allow the product to return to room temperature before using.  
3. Protect from exposure to ultraviolet light.  
4. 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 |

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**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

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**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

<table>
<thead>
<tr>
<th>Product</th>
<th>Appearance</th>
<th>Consistency</th>
<th>Viscosity, cps Brookfield RVT T-D @ 5rpm</th>
<th>Density g/cm³</th>
<th>Solids Content</th>
<th>Flash Point</th>
<th>Mix Ratio: By weight</th>
<th>Mix Ratio: By volume</th>
<th>Shelf life</th>
</tr>
</thead>
<tbody>
<tr>
<td>LORD 661</td>
<td>White/off-white/ blue tint</td>
<td>Paste</td>
<td>125,000 – 350,000</td>
<td>1.05-1.17</td>
<td>100%</td>
<td>15°C</td>
<td>10</td>
<td>6.9</td>
<td>6 months from date of shipment</td>
</tr>
<tr>
<td>LORD ACCELERATOR 6</td>
<td>Off white</td>
<td>Paste</td>
<td>200,000 – 500,000</td>
<td>1.45-1.56</td>
<td></td>
<td>93°C 3°C</td>
<td>1</td>
<td>1</td>
<td>in original unopened container</td>
</tr>
</tbody>
</table>

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

APPLICATION PROPERTIES

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

* 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.