

LORD® 310 EPOXY ADHESIVE

Technical Data Sheet

LORD® 310 adhesive is a modified, thixotropic, two-component epoxy adhesive system used to bond many types of prepared metals, prepared rubber, urethane and plastics. Originally formulated for primerless adhesion to SMC, LORD 310 adhesive is used to bond disk drives, down-hole oil field equipment, automotive body panels and spoilers, and vibration damping mounts. LORD 310 adhesive can be either room temperature cured or heat cured for faster processing.

Features and Benefits

Durable: provides load bearing properties equal to or greater than the materials being bonded.

Environmentally Recommended: contains no solvent, nonflammable and virtually odorless.

Environmentally Resistant: resists moisture, sunlight, salt spray and thermal cycling.

Temperature Resistant: performs at temperatures from -40°F to +400°F (-40°C to +204°C); resists postbakes up to 400°F (204°C); resists outgassing up to 225°F (107°C).

Chemically Resistant: resists dilute acids, alkalis, solvents, oils and hydrocarbons; anti-corrosion processes including phosphatizing and ELPO (e-coat) coatings do not affect adhesive or its bond strength.

Excellent Engineering Properties: provides low shrinkage, good creep properties and low water absorption.

Application

Surface Preparation: Remove soil, grease, oil, fingerprints, dust, mold release agents, rust and other contaminants from the surfaces to be bonded by solvent degreasing or alkaline cleaning.

On metal surfaces which are free of oxidation, use an isopropyl alcohol wipe. If necessary, use an abrasive material to remove tarnish. Always follow abrasion by a second cleaning to ensure removal of loose particles.

When bonding cured rubber, allow LORD 7701 adhesion enhancer/surface modifier to flash off before applying LORD 310 adhesive. Prime glass and ceramic surfaces with LORD AP-134 adhesion enhancer/surface modifier to promote adhesion.

Handle prepared surfaces carefully to avoid contamination. Assemble as soon as possible.

Mixing: Thoroughly mix the proper amount of resin and hardener until uniform in color and consistency. Be careful not to whip excessive air into the adhesive system. Handheld cartridges will automatically dispense the correct volumetric ratio of each component.

Heat buildup due to an exothermic reaction between the two components will shorten the working time of the adhesive. Mixing smaller quantities will minimize heat buildup. Do not use any adhesive that has begun to cure.

Typical Properties*

	310-A Resin	310-B Hardener	310-B Black Hardener
Appearance	Off-white Paste	Grey Paste	Black Paste
Viscosity, cP @ 77°F (25°C) Brookfield HBF Helipath, T-C Spindle, 5 rpm	400,000 - 820,000	230,000 - 690,000	200,000 - 700,000
Density lb/gal (kg/m ³)	11.7 - 12.85 (1402 - 1540)	10.0 - 11.0 (1198 - 1318)	10.3 - 11.0 (1234 - 1318)
Flash Point (Closed Cup), °F (°C)	>200 (>93)	>200 (>93)	>200 (>93)

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

Applying: Apply the mixed adhesive to bond surfaces using automatic meter/mix/dispense equipment, handheld cartridges or any convenient tool such as a stiff brush, spatula or trowel. For general use, a film thickness of approximately 0.02 inch (0.51 mm) is recommended. To control bondline thickness, a small amount of solid glass beads can be added into the mixed adhesive.

Join the parts in such a way as to avoid entrapped air. Apply only enough pressure to ensure good wetting of the adhesive on both surfaces. Squeezing a little adhesive out at the edges is usually a sign of proper assembly. It is not necessary to clamp the assembly unless movement during adhesive cure is likely. Maximum adhesion will occur only with parts which mate well without the need for excessive clamping pressure during cure. Excessive clamping may squeeze too much adhesive from the bond area which can result in a poor bond.

Curing: LORD 310 adhesive will cure to full strength in 24 hours, provided that the adhesive, substrates and ambient temperature are 65°F (18°C) or higher.

Higher temperatures will provide faster cure times; however, the bondline temperature should not exceed 325°F (162°C). Elevated temperature cure produces the highest bond strengths and impact resistance. Firm recommendations of cure times and temperatures depend on material composition and heating methods.

Once the adhesive has cured, it can be filed, sanded, machined or otherwise handled in the same way as a light metal. Paint, lacquers, enamels and other coatings can be applied to cured adhesive.

Typical Cured Properties*

Tensile Strength at Break, psi (MPa) ASTM D882-83A, modified	4650 (32)
Elongation, % ASTM D882-83A, modified	2
Young's Modulus, psi (MPa) ASTM D882-83A, modified	245,000 (1689)
Glass Transition Temperature (T _g), °F (°C) ASTM E1640-99, by DMA	140 (60)

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Typical Properties* of Resin Mixed with Hardener

	310-A/310-B	310-A/310-B Black
Mix Ratio, Resin to Hardener		
General Purpose, -40°F to 400°F (-40°C to 204°C) Mixed Stress Joint Design		
by Volume	1:1	1:1
by Weight	1.15:1	1.15:1
High Temperature, 50°F to 400°F (10°C to 204°C) Shear Joint Design		
by Volume	1.5:1	1.5:1
by Weight	1.7:1	1.7:1
Low Temperature, -40°F to 100°F (-40°C to 38°C) Peel Stress Joint Design		
by Volume	1:1.5	1:1.5
by Weight	1:1.5	1:1.5
Solids Content, %	100	100
Working Time, minutes @ 75°F (24°C) 54g mass	30-60	30-60
Time to Handling Strength, hours	6-8	6-8
Mixed Appearance	Grey Paste	Black Paste
Cured Appearance	Grey	Black

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Bond Performance*

Substrates	CRS to CRS	AL to AL	SMC to SMC	NR to CRS	SBR to SBR
	Lap Shear, psi (MPa)	Lap Shear, psi (MPa)	Lap Shear, psi (MPa)	45° Peel, pli (N/mm)	T-Peel, pli (N/mm)
Test @ Room Temperature	2520 (17.4)	1710 (11.8)	630 (4.3)	55 (9.6)	57 (10.0)
Failure Mode	C	A	FT	R	50R/C
Test @ Hot Strength, 180°F (82°C)	1590 (10.9)	1290 (8.9)	570 (3.9)	18 (3.1)	10 (1.8)
Failure Mode	A	A	FT	8R/A	A
Test after 7 days in H ₂ O @ 130°F (54°C) Test after 24 hours	2540 (16.9)	1950 (13.4)	670 (4.6)	55 (9.6)	95 (16.6)
Failure Mode	C	A	FT	R	56R/C
Test after 14 days Salt Spray Exposure Test immediately	2380 (16.4)	1850 (12.7)	670 (4.6)	50 (8.8)	73 (12.8)
Failure Mode	20C/A	A	FT	93R/A	33R/C
Test after 14 days @ 100°F (38°C), 100% RH Test immediately	2790 (19.2)	2450 (16.9)	640 (4.4)	58 (10.2)	63 (11.0)
Failure Mode	50C/A	50C/A	98FT/A	R	93R/C
Test @ -30°F (-34°C)	2370 (16.3)	1550 (10.7)	690 (4.7)	72 (12.6)	122 (21.4)
Failure Mode	A	A	FT	R	540R/C

Substrate

Surface Treatment

Cold Rolled Steel (CRS) and Aluminum (AL)	MEK Wipe, Grit Blast, MEK Wipe
Sheet Molded Compound (SMC)	320-grit Sandpaper, Dry Rag Wipe
Styrene Butadiene Rubber (SBR)	Primed with LORD 7701 Surface Treatment
Natural Rubber (NR)	Primed with LORD 7701 Surface Treatment

Bonded Parameters	Bond Area	Film Thickness	Cure	Mix Ratio
Metal Lap Shears	1.0"x0.5"	0.010"	72 hr @ RT	1:1 by Volume
SMC Lap Shears	1.0"x1.5"	0.030"	72 hr @ RT	1:1 by Volume
45° Peels	1.0"x1.0"	0.020"	72 hr @ RT	1:1 by Volume
T-Peels	1.0"x3.0"	0.020"	72 hr @ RT	1:1 by Volume

Failure Mode Definition

Abbreviation

Adhesive Failure	A
Cohesive Failure	C
Fiber Tear	FT
Rubber Failure	R
Stock Break	SB

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Cleanup: Clean excess adhesive on the bonded assembly, as well as the equipment, prior to the adhesive cure with hot water and detergent or an organic solvent such as ketones. Once adhesive has cured, heat the adhesive to 400°F (204°C) or above to soften the cured adhesive. This allows the parts to be separated and the adhesive to be more easily removed. Some success may be achieved with commercial epoxy strippers.

Shelf Life/Storage

Shelf life is two years from date of manufacture when stored at 60-80°F (16-27°C) in original, unopened container.

Cautionary Information

Before using this or any Parker 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.

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