

## LOXEAL INSTANT ADHESIVE 29

### Description

High viscosity instant adhesive based on ethyl cyanoacrylate. Designed for bonding plastic and rubber together or with metal. High viscosity allows to fill large gaps. The slow-setting time allows adjustment of parts during assembly.

### **Physical properties**

Composition:	ethyl cianoacrylate
Colour :	black
Viscosity (25°C –mPa.s):	500 - 1500
Specific weight (g/ml):	1,06
Gap to fill:	10 – 200 microns
Flash point:	87°C
Shelf life :	6 months at 20 °C
Temperature range	-50°C + 80°C

### **Curing properties**

Curing rate depends on the substrate used, on the gap, on the temperature and on the environmental humidity.

<u>Substrate</u>	<u>Fixturing Time (seconds)</u>
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<b>Plastics</b>	
* PVC:	20- 50
* Phenolic Resin:	10 - 40
* ABS:	15 - 40
<b>Metals</b>	
* Steel:	20 - 50
* Aluminium:	10 - 30
* Zinc:	40 -100

### **Various substrates**

* Neoprene/NBR :	5
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In case setting time is unacceptably long, we recommend the use of Loxeal Activator 9. IN case of usage with PE ,PP, Silicone rubbers or PTFE Loxeal Primer 7 is always recommended.

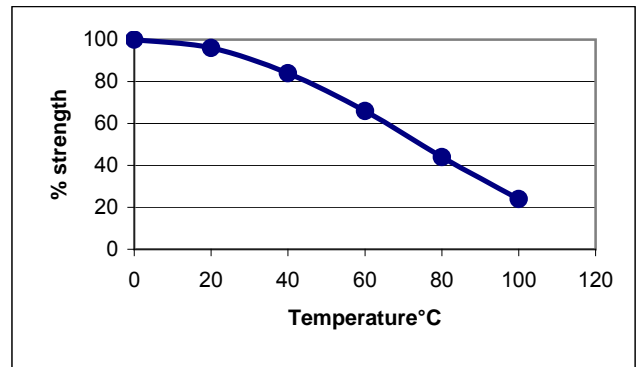
### **Proprieties of cured material**

Tensile strength ASTM D 2095 (N/mm <sup>2</sup> ):	18 - 25
Shear strength ISO 4587 (N/mm <sup>2</sup> ):	13 - 18
Impact strength ASTM D 950 (N.mm/ mm <sup>2</sup> ):	13 - 18
Softening range:	160°C – 170°C
Refraction index n <sup>20</sup> D:	similar to glass
Electrical resistivity DIN 53482 (Ω.mm):	>10 <sup>15</sup>
Dielectric strength ASTM D 149 (kV/mm):	25
Dielectric constant DIN 53483 (1MHz):	5,2

### **Environmental resistance**

The graph below shows the mechanical strength of the product (%) vs. temperature.

Specimen steel – ISO 4587



### **Chemical resistance**

After 24 hours of polymerisation at indicated temperature.

Substance	°C	Resistance after 100 h	Resistance after 500 h	Resistance after 1000 h
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Motor oil	40	Good	Good	Good
Alcohol	25	Excellent	Excellent	Discrete
Gasoline	25	Excellent	Discrete	Discrete
Relative humidity 90%	40	Discrete	Discrete	Low
Refrigerating gases	25	Good	Good	Good

\* For information on resistance with other chemicals, contact Loxeal Technical Service

### **Directions for use**

Clean and degrease parts to bond with Loxeal Cleaner 10. Excess of product can be removed with Loxeal CA Remover.

**Storage**

We recommend to store product in a cool and dry place at temperature non exceeding +20°C. For better and enhanced shelf life, keep product in a refrigerator at +3 /+8°C. To avoid contaminations do not refill containers with used product. For more information on applications, storage and handling contact Loxeal Technical Service

**Safety and handling**

Consult the Safety Data Sheet.

**Note**

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