

**LOXEAL INSTANT ADHESIVE 17**

Description

Instant adhesive based on methyl cyanoacrylate, high viscosity and high strength. Especially recommended for bonding metals, rigid materials, ceramics and rubber and plastic on a metal support. High viscosity allows to fill large gaps and its slow setting time enables the eventual repositioning of parts.

**Physical properties**

Composition: methyl cianoacrylate  
 Colour : clear  
 Viscosity (25°C –mPa.s): 1.200 – 1.800  
 Specific weight (g/ml): 1,19  
 Gap to fill: 10 – 200 microns  
 Flash point: 87°C  
 Shelf life : 12 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.

Substrate Fixturing Time (seconds)

Plastics

\* PVC: 30 - 90  
 \* Phenolic Resin: 10 - 40  
 \* ABS: 20 - 50

Metals

\* Steel: 30 - 60  
 \* Aluminium: 40 - 80  
 \* Zinc: 30 - 90

**Various substrates**

\* Neoprene/NBR : < 10

In case setting time is unacceptably long, we recommend to use Loxeal Activator 9. IN case of usage with PE ,PP, Silicone rubbers or PTFE Loxeal Primer 7 is always recommended.

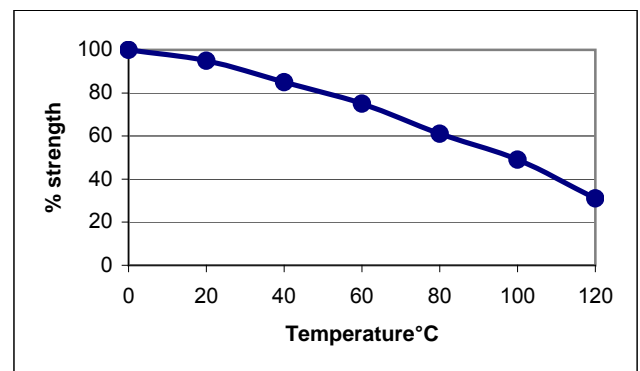
**Proprieties of cured material**

Tensile strength ASTM D2095 (N/mm<sup>2</sup>): 25 - 30  
 Shear strength ISO 4587 (N/mm<sup>2</sup>): 20 - 25  
 Impact strength ASTM D 950 (N.mm/ mm<sup>2</sup>): 10 - 15  
 Softening range: 160°C – 170°C  
 Refraction index n<sup>20D</sup>: 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
Motor oil	40	Excellent	Excellent	Excellent
Alcohol	25	Excellent	Excellent	Excellent
Gasoline	25	Excellent	Excellent	Excellent
Relative humidity 90%	40	Discrete	Low	Low
Refrigerating gases	25	Excellent	Excellent	Excellent

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\* 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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