

Description

High impact strength instant adhesive. Suitable for rubber, plastic and metal joints. High temperature resistant and medium viscosity formulation for common gaps filling. Low setting time allows easy and correct positioning of the parts to be bonded.

Physical properties

Composition :	ethyl cyanoacrylate modified
Colour :	clear/colourless
Viscosity (+25°C - mPa s) :	600 - 1.000
Specific weight (g/ml) :	1,06
Gap to fill :	10 - 200 microns
Flash point :	+87°C
Shelf life :	12 months in original unopened packaging
Temperature range :	-50°C/+130°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>Fixture Time (seconds)</u>
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Plastics

* PVC :	40 - 60
* Phenolic Resin :	30 - 40
* ABS :	30 - 60

Metals

* Steel :	40 - 60
* Aluminium :	30 - 50
* Zinc :	80 - 120

Various substrates

* Neoprene/NBR :	5 - 20
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In case of too long setting time 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 (typical)

Tensile strength ISO 6922 (N/mm ²) :	18 - 25
Shear strength ISO 4587 (N/mm ²) :	13 - 18
Refraction index n ²⁰ D :	similar to glass
Electrical resistivity DIN 53482 (Ω mm) :	>10 ¹⁵
Dielectric strength ASTM D 149 (kV/mm) :	25
Dielectric constant DIN 53483 (1MHz) :	5,2

Directions for use

Clean and degrease parts to bond with Loxeal Cleaner 10. Excess of product either cured or not 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 +2°C/+7°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 before use.

Note

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