

LOXEAL INSTANT ADHESIVE 77 (preliminary)

Description

Toughened high viscosity Ethyl-Cyanoacrylate adhesive with improved flexibility and impact resistance. Suitable for bonding rubbers, metals and plastics. Good temperature resistance up to 120°C.

Physical properties

Composition: ethyl cyanoacrylate modified
 Colour : black
 Viscosity (mPa s): 2000 – 4000 (at + 25°C)
 Specific weight (g/ml): ab. 1,10
 Gap to fill: till to 0,25 mm
 Flash point: + 87°C
 Shelf life : 6 months at + 20 °C in original unopened containers
 Temperature range: -55°C + 120°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)
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Plastics

* PVC:	15 - 70
* Phenolic Resin:	10 - 30
* ABS:	10 - 30

Metals

* Steel:	10 - 40
* Aluminium:	10 - 60
* Zinc:	10 - 60

Various substrates

* Neoprene/NBR :	10 - 30
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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 D 2095 (N/mm ²):	12 - 25
Shear strength ISO 4587 (N/mm ²):	13 - 25
Impact strength ASTM D 950 (N.mm/ mm ²):	13 - 18
Softening range:	160°C – 170°C
Electrical resistivity DIN 53482 (Ω.mm):	>10 ¹⁵
Dielectric strength ASTM D 149 (kV/mm):	25
Dielectric constant DIN 53483 (1MHz):	5,2

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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