

LOXEAL 33-00 CHEMICALLY ACTIVATED ADHESIVE

Description

- * 2-component no-mixing fast curing structural adhesive.
 - * Bonds metals, plastics, ceramics, woods.
 - * Apply Adhesive on one part and Activator on the other, assemble and press parts; fixing is achieved within few minutes.
 - * No-mixing required, only contacting together.
 - * No waste material, maximum of reproducibly.
 - * High impact resistance, good peeling and tensile strength, best resistance against gasoline, lubricants, water, heat resistant up to 120°C.
 - * Low irritating, low odour, free of acrylic esters and solvents, not flammable.
- * Available Activators: 20 - 21 - 22

Physical properties

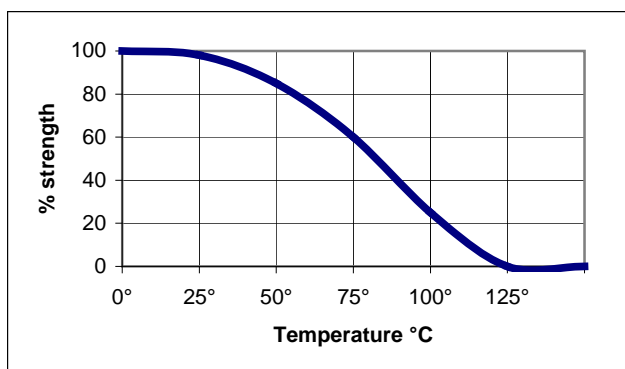
Composition	methacrylate resin
Appearance:	viscous transparent amber
Viscosity (25°C - mPa.s):	20.000 - 100.000 thixotropic
Specific weight at 25°C (g/ml):	1,1
Flash point:	> 80°C
Temperature range:	-50°C - +120° C
Shelf life:	1 year

Curing properties

Setting time measure with Activator 20 at 20°C	
Gap 0,05 mm:	< 2 minutes
Gap 0,25 mm:	10 minutes
Gap 0,50 mm:	20 minutes
Functional strength:	30 – 60 minutes
Full strength:	24 hours
Joint gap filling:	0,10 – 0,50 mm

Environmental resistance

The graph below shows the mechanical strength vs. temperature.
Specimen steel – ASTM 1002/DIN 10283



Properties of cured adhesive (typical value)

Shear strength (ASTM D-1002):	18 - 30 N/mm ²
Tensile strength (ASTM D 2095):	15 - 25 N/mm ²
Impact strength (ASTM D 950):	15 - 25 N.mm/ mm ²

Directions for use

Clean and degrease surfaces to bond with Loxeal Cleaner 10. Apply enough product on one surface and apply Loxeal Activator 20 on the other surface. Put together surfaces and put pressure until adhesion is reached. Clean the excess of product with organic solvent. For gaps over 0,50 mm put Loxeal Activator 20 on both surfaces. Wait 24 hours to put pieces under stress conditions.

Storage

Keep product in a cool and dry room at +28°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 Material Safety Data Sheet

Note

The data contained herein, obtained in Loxeal laboratories, are given for information only. Loxeal cannot assume responsibility for the results obtained by others which methods are not under Loxeal control. It is the user's responsibility to determine suitability for the user's purpose of any product mentioned herein. Loxeal disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Loxeal products. Loxeal specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits.