

## Description

Two-components toughened medium viscosity and low odor acrylic adhesive. Mixing ratio 1:1  
Fixture time with static mixer usually in a range of 5-8 minutes. Specifically design for bonding plastics, it provides good adhesion to metals, ceramics, fiberglass, wood and their combinations too.  
Fast curing at room temperature, it provides high shear and peeling strength.

## Physical properties

|                            | Part A   | Part B                |
|----------------------------|--|-----------------------|
| Chemical compos. :         | urethane methacrylate                            | urethane methacrylate |
| Appearance :               | white / ivory                                    | green/blue            |
| Viscosity (+25°C - Pa s) : | 30 - 40 thixo                                    | 4 - 5                 |
| Gap filling (mm) :         |  | 0,50                  |
| Mixing ratio (A+B) :       |  | 1:1                   |
| Shelf life :               | 6 months in original unopened packaging at +25°C |                       |

## Curing properties at +25°C (typical value)

|                                      |                 |                   |
|--------------------------------------|-----------------|-------------------|
| Handling time :                      | 5 - 8           | minutes **        |
| Initial fixture time :               | 10 - 12         | minutes           |
| Colour after mixing :                | greenish smooth |                   |
| Shear strength (ISO 4587 at +25°C) : |                 |                   |
| PVC :                                | 4 - 5           | N/mm <sup>2</sup> |
| PC :                                 | 4 - 6           | N/mm <sup>2</sup> |
| PMMA :                               | 3 - 5           | N/mm <sup>2</sup> |
| PA :                                 | 2 - 3           | N/mm <sup>2</sup> |
| ABS :                                | 2 - 4           | N/mm <sup>2</sup> |
| Phenolic based :                     | 4 - 7           | N/mm <sup>2</sup> |
| Steel :                              | 15 - 20         | N/mm <sup>2</sup> |
| Aluminum :                           | 15 - 20         | N/mm <sup>2</sup> |
| Zinc :                               | 15 - 20         | N/mm <sup>2</sup> |
| Hardness Shore D (ISO 868) :         | 55 - 65         |                   |
| Temperature range :                  | -40°C/+120°C    |                   |

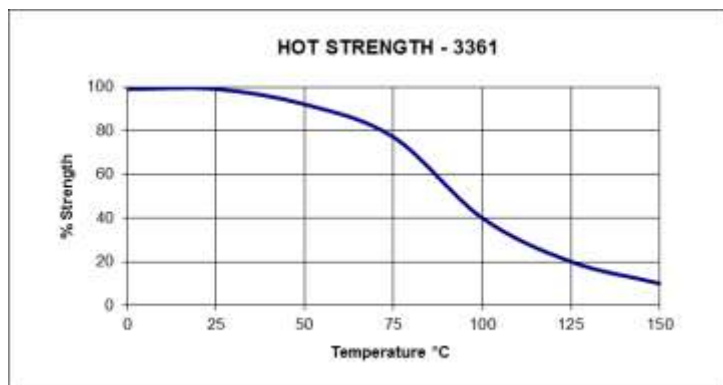
\*\* Time detected using 2 g of Part A +Part B with mixing nozzle

Substrate failure can be achieved depending on plastic type and its intrinsic properties and treatments.

## Environmental resistance

### Hot strength

The graph below shows the mechanical strength vs. temperature.  
Steel specimen – ISO 4587



## Directions for use

- Surfaces preparation**  
For best results we recommend to scratch the surfaces with a tool and then to degrease and clean with Loxeal Cleaner 10 or Acetone and let dry for a few seconds.
- Mixing**  
The resin and the hardener need to be mechanically mixed before use in the ratio of weight and/or volume in compliance with technical specifications until an homogeneous colour is reached. Products are available in dual cartridges with static mixers (separately provided) allowing a direct and correct product application on the substrates to bond, completely discarding the first 3/5 cm of the extruded product. Avoid excess of product blend because heating produced by chemical reaction may cause risk and loss of product.
- Pot life**  
Pot life of the mixed product may vary from few minutes to some hours at room temperature according to the resin and the hardener used. Higher temperature reduces the pot life. Apply product at temperature higher than +15°C.
- Assembly**  
Parts to be bonded shall be assembled immediately after product application and kept close until full polymerization without providing any mechanical stress.
- Cleaning**  
Excess of product can be removed with Acetone or any other solvent based cleaner compatible with the substrates to bond. Application tools and dosing systems shall be cleaned before the product is hardened. Cured product can be removed only mechanically.

## Storage

Keep product in a cool and dry room at no more than +20°C. To avoid contaminations do not refill containers with used product. For further information on applications, storage and handling contact Loxeal Technical Service

## Safety and handling

Consult Material Safety Data Sheet before use.

**Note**

The data contained herein, obtained in Loxeal laboratories, are given for information only; if specifics are required, please contact Loxeal Technical Department. Loxeal ensures abiding quality of supplied products according to its own specifics. Loxeal cannot assume responsibility for the results obtained by others which methods are not under Loxeal control. It is user's responsibility to determine suitability for 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.

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