

CHEMICALLY ACTIVATED STRUCTURAL ADHESIVE**Description**

Loxéal 3439 is a fluid, fast curing structural acrylic adhesive to be used with its specific Loxéal Activator. No mixing required, it bonds ferrites, metals, ceramics. Typical fixture time in few seconds. Toughened, it achieves in very few minutes good shear and impact strengths. Ideal for high speed assembly production lines. Acid free.

Physical properties

* Composition :	urethane methacrylate
* Colour :	transparent
* Viscosity (+25°C - mPa s) :	600 - 1.000
* Specific weight at +25°C (g/ml) :	1,10
* Shelf life at + 25°C :	1 year in original unopened packaging

Curing properties at +25°C (typical)**Ref. Activator 20**

* Handling time :	20 - 50 seconds
* Gap filling :	0,05 to 0,20 mm
* Functional cure time :	10 - 20 minutes
* Full cure time :	24 hours
* Shear strength : (ISO 4587) :	20 - 30 N/mm ²
* Tensile strength (ISO 6922) :	15 - 25 N/mm ²
* Impact strength (ASTM D950) :	18 - 28 kJ/ m ²
* Temperature range :	-55°C/+165°C

Directions for use

Clean and degrease surfaces to be bonded with Loxéal Cleaner 10. Apply enough product on one surface and apply Loxéal Activator on the other surface.

Put together parts and press until adhesion is reached. Clean the excess of product with organic solvent. For gaps over 0,20 mm put Loxéal Activator on both surfaces. Wait 24 hours to place parts under stressed conditions.

Storage

Keep product in a cool and dry room not above +25°C (avoid direct light exposure). To avoid contaminations do not refill container with used product. For more information on applications, storage and handling contact Loxéal Technical Service

Safety and handling

Consult Material Safety Data Sheet before use.

Note

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