

**Description**

2-component no-mixing fast curing structural adhesive to be used with its specific Loxeal Activator for bonding metals, plastics, ceramics, woods. No-mixing required, apply Adhesive on one part and Activator on the other, assemble and press parts; fixing is achieved within few minutes.

It provides high impact resistance, good peeling and tensile strength, best resistance against gasoline, lubricants, water, heat resistant up to 120°C.

**Physical properties**

Composition : methacrylate resin  
Appearance : amber-like  
Viscosity (+25°C - mPa s) : 45.000 - 80.000 thixo  
Specific weight at +25°C (g/ml) : 1,1  
Flash point : > +87°C  
Temperature range : -30°C/+120° C  
Shelf life : 1 year at temp. < +25°C in original unopened packaging.

**Curing properties (typical)****Ref. : Activator 22**

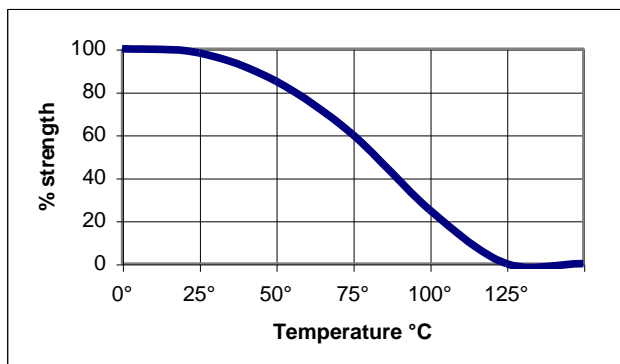
Setting time measure at + 20°C

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

**Environmental resistance**

The graph below shows the mechanical strength vs. temperature.

Specimen steel - ISO 4587

**Properties of cured adhesive (typical value)**

Ratio of use Adhesive/Activator :	100 :10 not critical
Shear strength (ISO 4587) :	18 - 30 N/mm <sup>2</sup>
Tensile strength (ISO 6922) :	15 - 25 N/mm <sup>2</sup>
Impact strength (ASTM D 950) :	15 - 25 kJ/m <sup>2</sup>

**Directions for use**

Clean and degrease surfaces to bond with Loxeal Cleaner 10. Apply enough product on one surface and apply Loxeal Activator 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 on both surfaces. Wait 24 hours to put pieces under stress conditions.

**Storage**

Keep product in a cool and dry room at a temperature not exceeding +25°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 before use.

**Note**

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