

**Description**

Loxéal 30-55 is a structural acrylic adhesive to be used with its specific Loxéal Activator, designed primarily for bonding metal to metal, ferrite, ceramics and some thermoplastics. This adhesive may be used in a variety of structural bonding applications due to its versatile capabilities. Structural adhesive 30-55 provides high tensile strength while maintaining excellent product flexibility; this results in tough and durable bonds with outstanding impact and peeling resistance. Curing is effected in few minutes at room temperature.

**Physical properties**

Base resin :	Modified acrylic
Appearance :	amber-like
Viscosity (+25°C - Pa s)	
- spindle 7 @ 20 RPM :	50 - 120
- spindle 7 @ 2,5 RPM :	30 - 60
Specific gravity (25°C) :	1,0 g/ml
Flash point, TCC :	+87°C
Shelf life : 1 year (max storage temp. +25°C) in original unopened packaging.	

**Curing properties (typical)**

Ref. : Activator 20

Fixture time with @ +20°C. :

Gap 0,05 mm :	< 2 min.
Gap 0,25 mm :	10 min.
Gap 0,50 mm :	20 min.
Functional strength :	30 - 60 min.
Final strength :	24 hours

**Heat cure**

Heat can be used to perform the curing when surfaces conditioning with primer (Activator 20) is not desirable. Typical heat curing conditions consist of heating parts and maintaining the bond line at temperature given below for the time specified. Optimum conditions for heat cure should be determined on actual assemblies.

Bond line Temperature / Curing time :

+120°C :	20 min.
+150°C :	10 min.
+175°C :	5 min.

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

Ratio of use Adhesive/Activator :	100 :10 not critical
Shear strength (ISO 4587) :	12 - 25 N/mm <sup>2</sup>
Tensile strength (ISO 6922) :	15 - 25 N/mm <sup>2</sup>
Peeling strength (ISO 4578) :	3,5 - 5 N/25mm
Impact strength (ASTM D-950) :	15 - 25 kJ/m <sup>2</sup>
Coefficient of thermal expansion (ATM D696) :	80 x10 <sup>-6</sup> 1/K
Thermal conductivity (ASTM C277) :	0,1 W/mK
Dielectric constant (ASTM D150) :	4,6 Mhz
Volume resistivity (ASTM D257) :	2.10 <sup>13</sup> Ohm.cm
Dielectric strength (ASTM D149) :	30 - 50 KV/mm
Temperature resistance :	-40°C /+120°C.

**Directions for use**

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

**Storage**

Keep product in a cool and dry room at no more than +25°C. To avoid contaminations do not refill containers 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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