

STRUCTURAL CHEMICALLY ACTIVATED ADHESIVE

Description

Two-components adhesive curing by contact, does not require mixing.

Fixture time from 1 to 3 minutes. Suitable for bonding metals, ceramics, glass, wood, hard plastics; it is highly resistant to impact, peeling and tensile.

33-47A might be used also with Loxeal Activators 18 and 20.

Physical properties

	Part A	Part B
Chemical compos. : urethane methacrylate	urethane methacrylate	urethane methacrylate
Appearance :	viscous amber	viscous green
Viscosity (+25°C - Pa s) :	5 - 12	5 - 12
Specific weight (g/ml) :	1,10	1,10
Flash point :	> +93°C	> +93°C
Shelf life :	1 year in original unopened packaging at +20°C	

Curing properties (typical value)

* Mixing ratio (A+B) :	1+1 not critical (weight/volume)	
* Handling time :	1 - 3	minutes
* Thickness of joint (mm) : min. 0,05 - max 0,50 (0,10 - 0,30 optimal)		
* Functional strength :	30 - 60	minutes
* Final strength :	24	hours
* Shear strength (ISO 4587) :	8 - 20	N/mm ²
* Tensile strength (ASTM D2095) :	15 - 25	N/mm ²
* Peeling strength (ISO4578) :	3 - 5	N/25mm
* Impact strength (ASTM D-950) :	15 - 25	kJ/m ²
* CTE (ASTM D696) :	80 x 10 ⁻⁶ 1/K	
* Thermal conductivity (ASTM C177) :	0,1 W/m K	
* Dielectric constant (ASTM D150) :	4,6 (1 MHz)	
* Volume resistivity (ASTM D257) :	2 x 10 ¹³ Ω cm	
* Dielectric strength (ASTM D149) :	30 - 50 KV/mm	
* Temperature range :	-30°C/+120°C	

Directions for use

Clean and degrease surfaces to be bonded with Loxeal Cleaner 10.

Apply enough product on surfaces to fill joints.

Put together parts within few seconds and press until adhesion is reached. Clean the excess of product with organic solvent. Wait 24 hours to place parts under stressed conditions.

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

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