

Description

Loxéal 33-28 is a 2-part room temperature polyurethane adhesive, primarily designed to bond to a variety of materials: composites (i.e. carbon fiber), metals, wood, ceramics and some plastics. Typical gel-time at room temperature is 15 to 20 minutes; repositioning is allowed within this time.

It provides a tough and semi-flexible film with good resistance to impacts, vibrations and thermal shocks; bond lines maintain a good resistance to water, oils and hydrocarbons.

Temperature resistance up to +100°C with peaks at +120°C.

Physical properties

Composition :	polyurethane resin	
Part :	A	B
Colour:	black	yellow
Viscosity (+25°C - mPa s) :	4.000 - 8.000 thixo	3.000 - 6.000 thixo
Specific weight (g/cm ³) :	1,20 - 1,30	1,40 - 1,50
Mixing ratio vol. :	1 : 1	
Shelf life (at +25°C) :	12 months in original unopened packaging	

Curing properties at +25°C (typical)

Handling time :	15 - 20	minutes**
Functional cure time :	24 - 48	hours
Colour after mixing :	black	
Shear/tensile strength (ISO 4587) :	10 - 15	N/mm ²
Hardness (Shore D - ISO 868) :	65 - 75	
Elongation at break (DIN 53504) :	15 - 20%	
Temperature range :	-40°C/+100°C (peaks at +120°C)	

**Time detected on a 2g total mass mixture A+B

Directions for use**1. Surfaces preparation**

For best results we recommend to scratch the surfaces with a tool and then to degrease and clean with Loxéal Cleaner 10 or Acetone and let dry for a few seconds.

2. 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 a 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.

3. 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.

4. Assembly

Parts to be bonded shall be assembled immediately after product application and kept close until full polymerization without providing any mechanical stress.

5. 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 +25°C. To avoid contaminations do not refill containers with used product. For further information on applications, storage and handling contact Loxéal Technical Service

Safety and handling

Consult Material Safety Data Sheet before use.

Note

The data contained herein, obtained in Loxéal laboratories, are given for information only; if specifics are required, please contact Loxéal Technical Department. Loxéal ensures abiding quality of supplied products according to its own specifics. Loxéal cannot assume responsibility for the results obtained by others which methods are not under Loxéal control. It is user's responsibility to determine suitability for user's purpose of any product mentioned herein. Loxéal disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Loxéal products. Loxéal specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits.