

## Description

Loxéal 4428 is a thixotropic, two-components epoxy resin. Especially developed for composites bonding, it provides excellent impact and vibration as well as high temperature resistance. Its ease of mixing and applications allows its use on gap filling.

## Physical properties

Related to product extruded through the proper mixer nozzle\*. The predetermined ratio between the two components is 2:1\*

Part :	A	B
Composition :	epoxy resin	amine
Colour :	white	cream
Mixing ratio vol. :	2 : 1	
Viscosity (+25°C - Pa s) :	25 - 35	15 - 20
Specific weight (g/ml) :	1.13	1.10
Max. gap to fill :	5,0 mm	
Shelf life (at +25°C) :	1 year in original unopened packaging	

## Curing properties at +25°C (typical)

Usable/Pot life :	10 minutes**
Working strength :	1 hour
At +60°C:	15 minutes
Full cure :	72 hours
At +60°C :	1 hour
Colour after mixing :	off-white
Shear strength (at +25°C on steel ISO 4587) :	18 - 22 N/mm <sup>2</sup>
• FRP Glass/Polyester	6 - 10 N/mm <sup>2</sup>
• FRP Glass/Epoxy	20 - 26 N/mm <sup>2</sup>
• Carbon fiber	20 - 35 N/mm <sup>2</sup>
Peel strength (Al) :	150 - 200 N/25mm
Temperature range:	-40°C/+120°C

\*\*= time detected on a 3 g 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. Avoid excess of product blend because heating produced by chemical reaction may cause risk and loss of 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

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