

Description

Instant adhesive based on methyl cyanoacrylate, high viscosity and high strength. Especially recommended for bonding metals, rigid materials, ceramics and rubber and plastic on a metal support. High viscosity allows to fill large gaps and its slow fixture time enables the eventual repositioning of parts.

Physical properties

Composition :	methyl cyanoarylate
Colour :	clear/colourless
Viscosity (+25°C - mPa s) :	1.200 - 1.800
Specific weight (g/ml) :	1,19
Gap to fill :	10 - 200 microns
Flash point :	see MSDS
Shelf life :	1 year in original unopened packaging
Temperature range :	-50°C/+80°C

Curing properties

Curing rate depends on the substrate used, on the gap, on the temperature and on the environmental humidity.

<u>Substrate</u>	<u>Fixture Time (seconds)</u>
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Plastics

* PVC :	30 - 90
* Phenolic Resin :	10 - 40
* ABS :	20 - 50

Metals

* Steel :	30 - 60
* Aluminium :	40 - 80
* Zinc :	30 - 90

Various substrates

* Neoprene/NBR :	< 10
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In case of too long setting time we recommend to use Loxeal Activator 9. In case of usage with PE, PP, Silicone rubbers or PTFE Loxeal Primer 7 is always recommended.

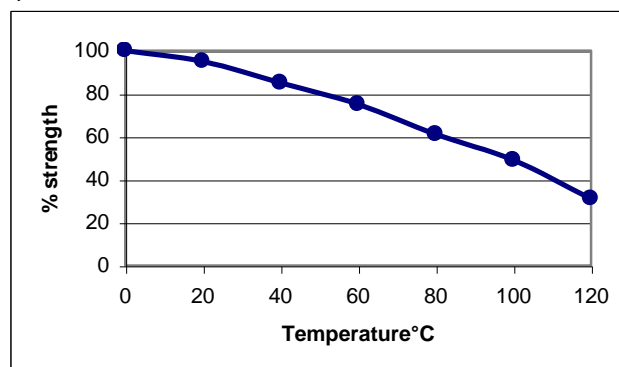
Proprieties of cured material (typical)

Tensile strength ISO 6922 (N/mm ²) :	25 - 30
Shear strength ISO 4587 (N/mm ²) :	20 - 25
Softening range :	+160°C/+170°C
Refraction index n ²⁰ _D :	similar to glass
Electrical resistivity DIN 53482 (Ω mm) :	>10 ¹⁵
Dielectric strength ASTM D 149 (kV/mm) :	25
Dielectric constant DIN 53483 (1MHz) :	5,2

Environmental resistance

The graph below shows the mechanical strength of the product (%) vs. temperature.

Specimen steel - ISO 4587



Chemical resistance

Aged at indicated temperature under conditions below after 24 hours from polymerisation.

Substance	°C	Resistance after 100 h	Resistance after 500 h	Resistance after 1000 h
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Motor oil	40	excellent	excellent	excellent
Alcohol	25	excellent	excellent	excellent
Gasoline	25	excellent	excellent	excellent
Relative humidity 90%	40	discrete	low	low
Refrigerating gases	25	excellent	excellent	excellent

* For information on resistance with other chemicals, contact Loxeal Technical Service

Directions for use

Clean and degrease parts to bond with Loxeal Cleaner 10. Excess of product either cured or not can be removed with Loxeal CA Remover.

Storage

We recommend to store product in a cool and dry place at temperature non exceeding +20°C. For better and enhanced shelf life, keep product in a refrigerator at +2°C/+7°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 the Safety Data Sheet before use.

Note

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

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