

Preliminary
LOXEAL AC5465 A+B
 (Polyolefins bonding)

Description

Two-components fast curing acrylic adhesive. It is specifically designed for bonding Polyolefins and substrates with low surface energy (PP, PE, PTFE), in combination with other plastics and metals as well.

Loxéal AC5465 does not require any surface treatment, thanks to its physical features, it allows to design 0-gap joints and to bond substrates with extremely small gaps. Its application provides a resistant and transparent bonding when used at 0-gap on transparent substrates.

It provides high shear and peeling strength.

Without solvent, mixing ratio 1:1

Typical physical properties

	Part A	Part B
Chemical composition:	methacrylate ester	methacrylate ester
Appearance:	translucent	transparent
Viscosity (+25°C - mPa s):	25000	12000
Mixing ratio (A+B):	1:1	
Shelf life:	6 months in unopened packaging at +2°C/+7°C	

Typical Curing properties at +25°C

Pot life:	6 minutes*
Fixture time:	12 minutes**
Full cure:	72 hours

Shear strength (after 72 hours at +25°C ISO 4587):

PP:	5 N/mm ²
PE:	3 N/mm ²
PTFE:	1,5 N/mm ²
PMMA:	6 N/mm ²
PETG:	6 N/mm ²
PP/Stainless steel	6 N/mm ²
PE/Stainless steel	4 N/mm ²

* Time detected using 6g of mixed product

** time needed until 0.1 N/mm² shear strength is achieved

Warnings

This adhesive is not approved for usage neither with pure nor with gaseous oxygen.

Directions for use

- **Surfaces preparation**
 For best results we recommend to degrease and clean substrates.
 Lightly scratch the surfaces (on metal substrates) with a tool and then to degrease and clean with a cleaner suitable to the substrate (i.e. Loxéal Cleaner 10 or Acetone)
- **Adhesive application**
 Products are available in dual cartridges packaging
 1. Open the cartridge and extrude a small quantity of adhesive, until the 2 parts come out homogeneously.
 2. Mix Part A and Part B by hand or using the static mixers (separately provided) after setting it on the cartridge. If mixing the 2 parts by hand, we recommend to pay attention to the mixing ratio given on the Technical Data Sheet.
 3. Apply the product, when using the static mixer, completely discard the first 3/4 cm of the extruded product.
 Avoid to mix big quantities of product because heating produced by chemical reaction may be dangerous and cause loss of product.
- **Pot life**
 Pot life of the mixed product varies according to the temperature. Higher temperature reduces the pot life. Apply product at temperature higher than +15°C.
- **Assembly**
 Parts to be bonded shall be assembled immediately after product application and kept close until full polymerization without providing any mechanical stress.
- **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

Store refrigerated at temperature between +2°C/+7°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

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.