

LOXEAL INSTANT 67

Description

The Loxeal IS 67 is an alcoxy-ethyl based cyanoacrylate adhesive with low odour and low blooming effect. It is not irritating and it is especially suitable for use in poorly ventilated or closed work areas.

Loxeal IS 67 is ideal for bonding a wide range of materials such as metals, plastics and elastomers. It avoids the blooming formation near the bonding area ensuring an excellent aesthetic finish in applications that require it. The typical setting time allows the adjustment of the parts during assembly.

Typical Physical Properties

Composition:	alcoxy-ethyl cyanoacrylate
Colour:	clear/colourless
Viscosity (+25°C - mPa s):	1300
Specific weight (g/ml):	1,1
Gapfill:	10 - 200 microns
Flash point:	see the Safety Data Sheet
Temperature range:	-50°C/+100°C
Shelf life:	12 months in original unopened packaging

Typical Curing properties

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

Substrate Fixture Time (seconds)

Plastics	
* PVC	20 - 60
* Phenolic Resin	10 - 40
* ABS	20 - 60
Metals	
* Steel	30 - 70
* Aluminium	10 - 20
* Zinc	60 - 180

Various substrates

* Neoprene/NBR :	5 - 10
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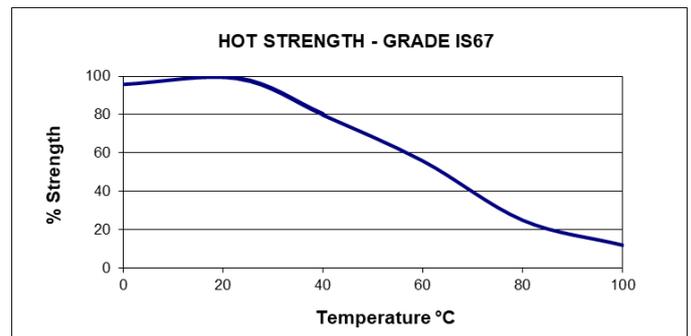
Typical Proprieties of the Cured Adhesive

Tensile strength, Steel, ISO 6922 (N/mm ²):	25
Shear strength, Steel, ISO 4587 (N/mm ²):	20
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):	3

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
Motor oil	40	good	discrete	discrete
Alcohol	25	excellent	excellent	excellent
Gasoline	25	excellent	discrete	discrete
Relative humidity 90%	40	discrete	low	null
Refrigerating gases	25	low	low	null

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

Directions for use

• Surface preparation

For best results lightly scratch the surfaces of metal and plastic substrates (not recommended for polyolefins).

Degrease and clean with a cleaner suitable for the substrate (i.e. Loxeal Cleaner 10 or Acetone or Isopropyl Alcohol).

For the bonding of low surface energy plastics such as Polyolefins, PTFE, silicone rubbers and some types of rubber, apply Loxeal Primer 7 on the surface and wait for the solvent to evaporate.

• Assembling

Apply the adhesive on one surface and couple the parts as soon as the deposition is complete.

Press and hold the parts in place for the time necessary for the fixing. Do not apply stress to the joint before functional strength is achieved.

To polymerize the adhesive outside the joint area, use Loxeal Activator 9 to speed up the reaction of the adhesive exposed to the air.

• Cleaning

Remove any surplus of adhesive outside the bonding area.

It's important to clean the mixing equipment before the adhesive has cured. Once the adhesive is cured, it is necessary mechanical action to remove it.

It is also possible to remove the cured cyanoacrylate by using Loxeal CR1 or CR2 following the instructions reported in their respective TDS.

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 and disposal

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.