LOXEAL ENGINEERING ADHESIVES
UNI EN ISO 9001 - UNI EN ISO 14001
Registered Quality and Environment Management System Company

Technical Data Sheet

LOXEAL INSTANT ADHESIVE 25

Description

Medium to high viscosity, medium setting speed, instant adhesive based on ethyl cyanoacrylate.
Designed for bonding of plastic, rubber, metal, ceramic.

Physical properties

Composition :	ethyl cyanoacrylate
Colour :	clear/colourless
Viscosity (+25°C - mPa s) :	350 - 450
Specific weight (g/ml) :	1,10
Gap to fill :	10 - 150 microns
Flash point :	see MSDS
Temperature range :	-50°C/+80°C

Shelf life : 12 months in original unopened packaging

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 :	3 - 10
* Phenolic Resin :	5 - 20
* ABS :	10 - 30
Metals	
* Steel :	10 - 30
* Aluminium :	5 - 15
* Zinc :	30 - 90
Various substrates	
*Neoprene/NBR :	< 5

Proprieties of cured material (typical)

Tensile strength ISO 6922 ($N//mm^2$) :	15 - 23
Shear strength ISO 4587 ($N//mm^2$) :	13 - 20
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 950 (kV/mm) :	25
Dielectric constant DIN 53483 (1MHz) :	5,2

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.

LOXEAL Srl - Via Marconato 2 - 20811 - CESANO MADERNO (MB) - Italy - Tel +39 (0)362 5293.1 - Fax +39 (0)362 524225 - www.loxeal.com