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

Technical Data Sheet

LOXEAL INSTANT ADHESIVE 27

Description

High viscosity instant adhesive based on ethyl cyanoacrylate. Designed for bonding of plastic, rubber, metal, ceramic.
Its slow fixture time allows adjustment of parts during assembly.

Physical properties

Composition :	ethyl cyanoacrylate
Colour :	clear/colourless
Viscosity (+25°C - mPa s) :	1.200 - 1.800
Specific weight (g/ml) :	1,10
Gap to fill :	10 - 200 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 :	20 - 50
* Phenolic Resin :	10 - 40
* ABS :	15 - 40
Metals	
* Steel :	20 - 50
* Aluminium :	10 - 30
* Zinc :	40 - 100
Various substrates	
*Neoprene/NBR :	< 5

Proprieties of cured material (typical)

Tensile strength ISO 6922 ($N//mm^2$) :	18 - 25
Shear strength ISO 4587 ($N//mm^2$) :	13 - 18
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

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

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