

## LOXEAL INSTANT ADHESIVE 48

### Description

Loxéal INSTANT 48 is a gel, fluid ethyl cyanoacrylate adhesive, suitable for bonding of rubber, plastics, woods and ceramics. Designed to be easily dispensed by dosing systems. Its delayed fixture time allows parts repositioning; it provides temperature resistance up to +120°C.

### Typical physical properties

Composition:	modified ethyl cyanoacrylate
Colour:	transparent
Viscosity (+25°C - Pa s):	2.000 - 2.500 thixo
Specific weight (g/ml):	1,05
Max. gap to fill:	0,5 mm
Shelf life:	12 months in original unopened packaging
Temperature range:	-50°C/+120°C

### Typical curing properties

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

Phenolic Resin:	< 30 s
Steel:	< 30 s
Neoprene/NBR:	< 30 s

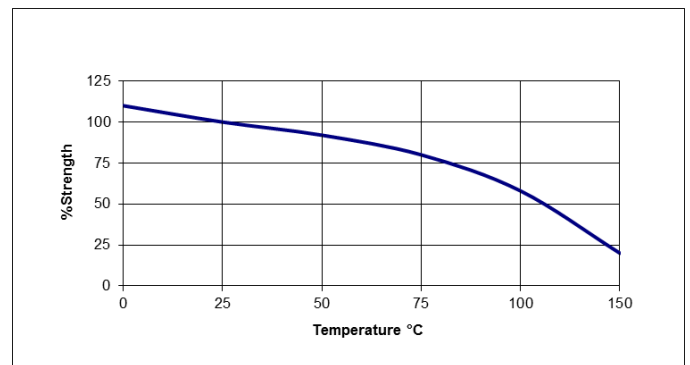
In case of too long setting time, we recommend to use Loxéal Activator 9. In case of usage with PE, PP, Silicone rubbers or PTFE Loxéal Primer 7 is always recommended.

### Typical proprieties of cured material

Shear strength ISO 4587 (N/mm <sup>2</sup> ):	13 - 18
Coefficient of thermal expansion:	90 x 10 <sup>-6</sup> mm/mm/°C
Dielectric strength ASTM D 149 (kV/mm):	25
Coefficient of thermal conductivity:	0,1 W/(m.K)

### Environmental resistance

The graph below shows the mechanical strength of the product (%) vs. temperature. Specimen steel - ISO 4587



### 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. Loxéal 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 Loxéal Primer 7 on the surface and wait for the solvent to evaporate.

#### • Assembling

Shake the bottle before use. 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. In presence of large gaps between the parts, the cure speed is decreased. It is possible to use Activator 9 in order to increase the speed of curing. To polymerize the adhesive outside the joint area, use Loxéal 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 Loxéal 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, 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.

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