

## LOXEAL 33-28

### Description

Loxéal 33-28 is a 2-part medium viscosity polyurethane adhesive, primarily designed to bond to a variety of materials: composites (i.e. carbon fiber), metals, wood, ceramics and some plastics. Typical gel-time at room temperature is 15 to 20 minutes; parts repositioning is allowed by this time.

It provides a flexible film with good resistance to impacts, vibrations and thermal shocks. It is resistant to water, oils and hydrocarbons and to temperature up to +100°C with peaks at +120°C.

### Typical physical properties

Part:	A	B
Composition:	polyurethane resin	
Colour:	black	yellow
Viscosity (+25°C - mPa s):	4000-8000 thixo	3000-6000 thixo
Specific weight (g/ml):	1,28	1,43
Mixing ratio vol:	1:1	
Shelf life:	6months @+5°C/+25°C in original unopened packaging	

### Typical curing properties at +25°C

Handling time:	15-20 minutes**
Functional cure time:	24-48 hours
Colour after mixing:	black
Shear/tensile strength (ISO 4587):	10-15 N/mm <sup>2</sup>
Hardness (Shore D - ISO 868):	65-75
Elongation at break (DIN 53504):	15-20%
Temperature range:	-40°C/+100°C (peaks at +120°C)

\*\*Time detected on a 2g total mass mixture A+B

### Directions for use

- Surface preparation

For best results we recommend to scratch the surfaces with a tool and then to degrease and clean with Loxéal Cleaner 10 or Acetone and let dry for a few seconds.

- Mixing

The resin and the hardener need to be mechanically mixed before use in the ratio of weight and/or volume in compliance with technical specifications until a homogeneous colour is reached. Products are available in dual cartridges with static mixers (separately provided) allowing a direct and correct product application on the substrates to bond, completely discarding the first 3/5 cm of the extruded product. Avoid excess of product blend because heating produced by chemical reaction may cause risk and loss of product.

- Pot life

Pot life of the mixed product may vary from few minutes to some hours at room temperature according to the resin and the hardener used. Higher temperature and big quantities reduce 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

Keep product in a cool and dry room at no more than +25°C. To avoid contaminations do not refill containers with used product. For further information on applications, storage and handling contact Loxéal Technical Service

### Safety, handling and disposal

Consult Material Safety Data Sheet before use.

### Note

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