

Description

Instant adhesive based on methyl cyanoacrylate, medium viscosity and high strength. Especially recommended for assembling rigid materials like rubber-metal or metal-plastic, its slow setting time allows the eventual repositioning of parts.

Physical properties

Composition :	methyl cyanoacrylate
Colour :	clear/colourless
Viscosity (+25°C - mPa s) :	80 - 150
Specific weight (g/ml) :	1,10
Gap to fill :	10 - 100 microns
Flash point :	see MSDS
Shelf life :	12 months in original unopened packaging
Temperature range :	-50°C/+80°C

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 :	30 - 70
* Phenolic Resin :	10 - 30
* ABS :	10 - 30
Metals	
* Steel :	20 - 40
* Aluminium :	30 - 60
* Zinc :	30 - 60

Various substrates

* Neoprene/NBR :	< 10
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In case of too long setting time we recommend to use Loxeal Activator 9. In case of usage with PE, PP, Silicone rubbers or PTFE Loxeal Primer 7 is always recommended.

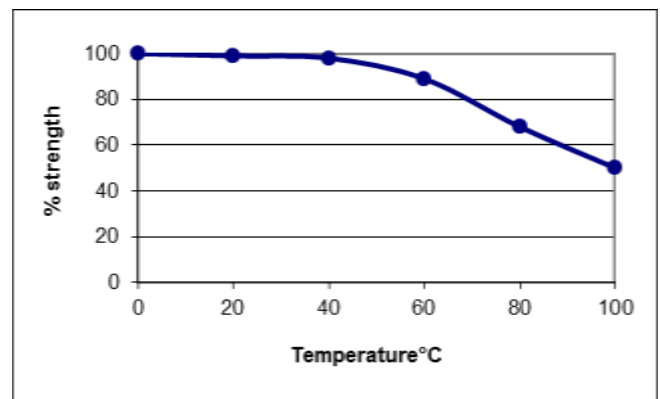
Proprieties of cured material (typical)

Tensile strength ISO 6922 (N/mm ²) :	25 - 30
Shear strength ISO 4587 (N/mm ²) :	20 - 25
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 149 (kV/mm) :	25
Dielectric constant DIN 53483 (1MHz) :	5,2

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

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

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.

Description

Very fast curing instant adhesive on basis of ethyl cyanoacrylate.
Low viscosity, designed for fast bonding of EPDM, foam rubber, difficult to bond rubber, soft/plastic.

Physical properties

Composition : ethyl cyanoacrylate
Colour : clear/colourless
Viscosity (+25°C - mPa s) : 5 - 10
Specific weight (g/ml) : 1,10
Gap to fill : 10 - 40 microns
Flash point : see MSDS
Shelf life : 12 months in original unopened packaging
Temperature range : -50°C/+80°C

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 : 2 - 10

* Phenolic Resin : 5 - 15

* ABS : 2 - 10

Metals

* Steel : 10 - 20

* Aluminium : 2 - 10

* Zinc : 30 - 90

Various substrates

*Neoprene/NBR : < 2

* Rubber : 2 - 5

* EPDM : < 5

In case setting time is unacceptably long, we recommend the use of Loxeal Activator 9. IN case of usage with PE ,PP, Silicone rubbers or PTFE Loxeal Primer 7 is always recommended.

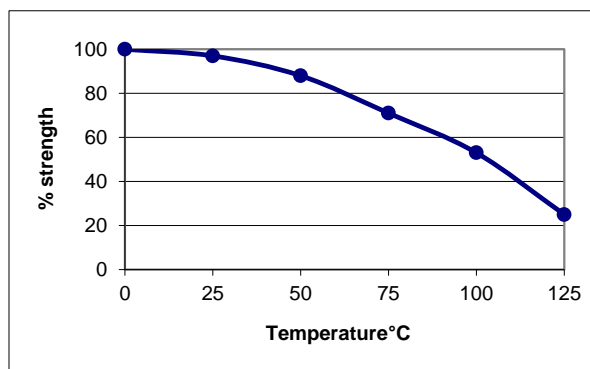
Proprieties of cured material (typical)

Tensile strength ISO 6922 (N/mm²) : 12 - 25
Shear strength ISO 4587 (N/mm²) : 13 - 18
Softening range : +160°C/+170°C
Refraction index n^{20D} : similar to glass
Electrical resistivity DIN 53482 (Ω mm) : >10¹⁵
Dielectric strength ASTM D 149 (kV/mm) : 25
Dielectric constant DIN 53483 (1MHz) : 5,2

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.

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Motor oil	40	excellent	excellent	excellent
Alcohol	25	excellent	excellent	excellent
Gasoline	25	excellent	excellent	excellent
Relative humidity 90%	40	discrete	discrete	low
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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.

Description

General purpose, surface insensitive medium viscosity instant adhesive based on ethyl cyanoacrylate.

Insensitive to acidic surfaces, it is recommended for bonding of leather, wood and metals.

Proven temperature strength up to +120°C with peaks for short times up to +150°C.

NSF registered as acceptable for use as an instant adhesive (**category P1**) in and around food processing area. Registration No.154017.

Physical properties

Composition:	modified ethyl cyanoacrylate
Colour:	clear
Viscosity (+25°C - mPa s):	80 - 150
Specific weight (g/ml):	1,06
Gap to fill:	10 - 150 microns
Flash point:	see MSDS
Shelf life:	12 months in original unopened packaging
Temperature range:	-50°C/+120°C

Curing properties

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

Substrate Fixture Time (seconds)

Woods

* Fir	45 - 90
* Balsa	2 - 5
* Teak	5 - 20
* Baywood	10 - 30
* Pine	5 - 20
* Oak	90 - 180
Chipboard	30 - 90

Plastics

* PVC	2 - 10
* Phenolic Resin	2 - 10
* ABS	2 - 10

Metals

* Steel	5 - 20
* Aluminium	2 - 10
* Zinc	10 - 20

Various substrates

* Neoprene/NBR	< 5
* Fabric	2 - 20
* Leather	5 - 15
* Ceramic	5 - 30
* Paper	1 - 5

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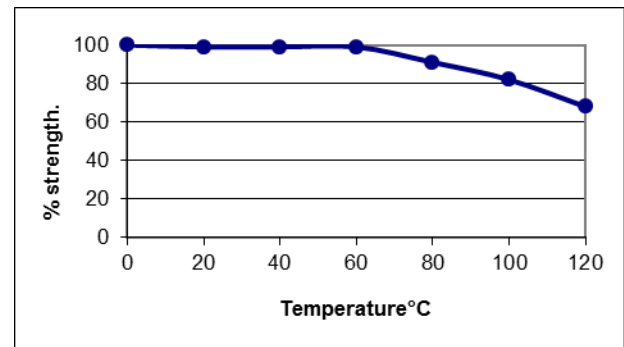
Proprieties of cured material (typical)

Tensile strength ISO 6922 (N/mm ²):	15 - 25
Shear strength ISO 4587 (N/mm ²):	15 - 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 149 (kV/mm):	25
Dielectric constant DIN 53483 (1MHz):	5,2

Environmental resistance

The graph below shows the mechanical strength of the product (%) vs. temperature.

Specimen steel - ISO 4587



Chemical resistance

After 24 hours of polymerisation at indicated temperature.

Substance	°C	Resistance after 100 h	Resistance after 500 h	Resistance after 1000 h
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Motor oil	40	excellent	excellent	excellent
Alcohol	25	excellent	excellent	excellent
Gasoline	25	excellent	excellent	excellent
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