

Description

High viscosity single-part, epoxy adhesive, suitable for bonding metal surfaces, ferrites, ceramics as well as composite materials. It has been designed to be non-sagging, (even at elevated temperatures), allowing the product to be used in gaps and on vertical surfaces. Typical cure profile is in the range of +130°C/+150°C. Fast curing could be obtained by induction on Fe materials. It provides high impact, peeling and tensile strength.

Physical properties

| | | |
|----------------------------------|---------------------------------|--|
| Composition : | epoxy resin | |
| Colour : | grey | |
| Viscosity (+25°C - Pa s) : | 800 - 3.800 | |
| Specific weight (+25°C - g/ml) : | 1,5 | |
| Gap filling : | 3 mm | |
| Shelf life : | 12 months between +2°C and +7°C | |

Curing performance

| | | |
|---------------|--------|----------|
| Curing time : | | |
| Temperature : | +130°C | ≥ 45 min |
| | +150°C | ≥ 30 min |
| Induction : | | < 3 min |

Curing time is affected by type of substrate (heat transmission), and by gap to be filled. It will also depend on time needed by the adhesive to reach this temperature - for example, large assemblies or crowded oven will require longer to reach full cure.

Alternative methods for fast curing include induction, infrared lamps and hot air guns.

Curing properties (typical values)

| | |
|---------------------------------------|---------------------------|
| Shear strength (ISO 4587) : | 20 - 30 N/mm ² |
| Shear strength (ISO 4587) at +150°C : | > 12 N/mm ² |
| Shore D Hardness : | 75 - 85 |
| Temperature range : | -40°C +180°C |

Surface preparation

Clean and degrease with Loxeal Cleaner 10 before applying the adhesive.

Some metals such as aluminium, copper and its alloys will benefit from light abrasion with emery cloth (or similar), to remove the oxide layer.

Directions for use

- The adhesive should be dispensed from the cartridge via the nozzle supplied.
- Apply the adhesive to one surface avoiding to entrap air.
- Assemble parts applying enough pressure to ensure the adhesive spreads to cover the complete area to be bonded.
- Use a jig / clamp to prevent parts moving during polymerisation.

Storage

Store refrigerated at temperature between +2°C/+7°C. To avoid contaminations do not refill containers with used product. For further information on applications, storage and handling contact Loxeal Technical Service.

Safety and handling

Consult Material Safety Data Sheet before use.

Note

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