

### Description

Fast curing, high strength Ultra Violet curing adhesive. Specially designed for glass and crystal bonding in manufacturing of decorative tableware, household, furnishing accessories, bonbonnières and gift articles. For its good optical clarity is ideal for bonding of precious crystals.

### Physical properties

Composition : methacrylate ester  
 Colour : clear/colourless  
 Viscosity (+25°C - mPa s) : 2.200 - 2.900  
 Specific weight (g/ml) : 1,1  
 Curing time UV (365 nm) : 6 - 10 seconds  
 Gap to fill : 0,03 mm / 1,5 mm  
 Flash point : > +100°C  
 Shelf life : 1 year at +25°C in original unopened packaging

### Curing properties

To obtain the best features, clean and dry parts to bond. The polymerisation UV is belonging to the intensity of the UV lamp, to the distance from the UV light source, to the bondline gap and to the light transmittance of the substrate the light shall pass through. We recommend high intensity UV light sources with minimum radiation between 365 nm and 420 nm at 100mW/cm<sup>2</sup>. curing time may vary according to adhesive gap.

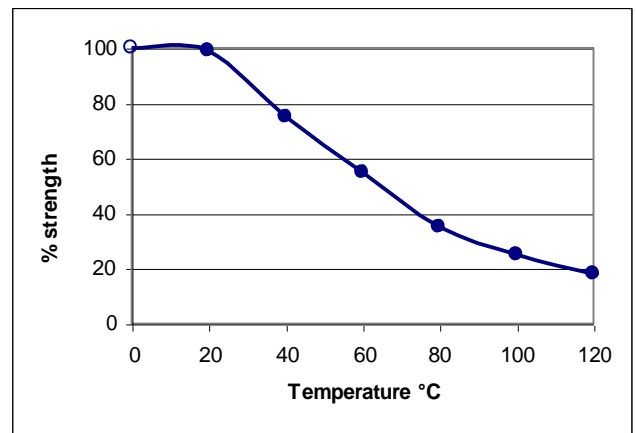
### Properties of cured adhesive

\* Tensile strength (ASTM D-2095-69) : 10 - 14 N/mm<sup>2</sup>  
 \* Hardness (Shore D) : 50 - 65  
 \* Elongation at break : 80 - 100%  
 \* Temperature range : -55°C/+120°C  
 \* Refractive index : 1,49  
 \* Light transmittance : > 98%  
 \* Coefficient of thermal expansion : 85 x 10<sup>-6</sup> mm/mm/°C  
 \* Dielectric constant (+25°C 1000 Hz) : 4  
 \* Dielectric strength : 10 -12 kV/mm

### Environmental resistance

The graph below shows the mechanical strength vs. temperature.

Specimen steel and glass (ISO 6922).



### Chemical resistance

Aged under conditions below after 24 hours from polymerisation at indicated temperature.

Substance	°C	Resistance after 100 h	Resistance after 500 h	Resistance after 1000 h
Alcohol	25	excellent	excellent	excellent
Gasoline	25	excellent	excellent	good
Relative humidity 90%	40	low	low	low
Refrigerant gases	25	excellent	excellent	excellent

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

**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 more information on applications, storage and handling contact Loxeal Technical Service

**Safety and handling**

Consult Material 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.