LOXEAL®
ENGINEERING ADHESIVES
UNI EN ISO 9001 - UNI EN ISO 14001
Registered Quality and Environment Management System Company

Technical Data Sheet

LOXEAL UV 3355

Description

It forms in place gasket and seals by irradiation with low-intensity UV lamps.
It provides a flexible and soft film.
Forms gaskets with high resistance to compression, fixes and seals pre-assembled components on their outside surface, encapsulates small parts.
It is well suitable for creating seals and bonding of surfaces made of different materials and on surfaces with critical coefficients of thermal expansion too.

Physical properties

Chemical type:	acrylic ester
Colour:	transparent
Viscosity (+25°C - mPa s):	80.000 - 120.000 thixo
Specific weight (g/ml):	1,10
UV curing time (365 nm) (UV lamp of 3,5 mW/cm^2):	3 - 5 seconds

Shelf life: 12 months at +25°C in original unopened packaging

Curing properties

To obtain the best features, clean and dry parts to bond. The polymerization depends on the UV lamp radiation, on the distance from the lamp, on the thickness of the adhesive applied, on the light permeability of the pieces to bond and on geometry of the joint.
We recommend to use UV lights able to produce UV waves between 365 nm and 420 nm at 100mW/cm².
We recommend to cool the area irradiated with UV lamp while using thermoplastic materials.
Curing times may vary according to adhesive depth.

Properties of cured adhesive

*Tensile strength (DIN 53504):	5 - 10 N/mm²
*Elongation at break (DIN 53504):	> 130 %
* Refractive index:	1,484
* Light transmittance:	> 98%
*Hardness (Shore A):	50 - 70
*Temperature range:	-55°C/+150°C

Directions for use

1. Surface preparation (cleaning and surface humidity stabilization)
For best results, bond surfaces should be clean and grease-free. When bonding flat glasses and big-seized objects, clean and degrease the surfaces with Acetone, wiping with clean tissues. Allow bonding parts to dry with hairdryer and hot air (+70/+100 °C) for few seconds. Use an ultrasonic cleaning machine for small parts cleaning.

2. Lamps recommendations: use high pressure, mercury vapor, iron iodide or LED lamps with appropriate UV waves, usually at 365 nm for glass bonding and at 400-420 nm for plastic bonding. Check the emission with a UV Radiometer (mW/cm²) at the same distance as the bonding will occur. After mercury vapor and iron iodide lamps switching on, wait for the emission power to stabilize before bonding parts.

3. Bonding methods
A. Check glass or crystal's transparency to UVA rays (centered at 365 nm) using an UV Radiometer. Colored glasses may prevent or stop the adhesive's cure.
B. Float glass bonding: use the lamp to check surface "tin side". Use the opposite surface "atmosphere side" to achieve good bonding results.
C. Adhesive needs to be applied directly from unopened packaging in order to avoid contamination due to different packaging or refilling and never exposed to environment.
D. Minimize joint's stress cracking, avoiding any pressure (parts should be floating).

4. Parts fixture
a. Use an emission power superior than 5 mW/cm² (appositely moving the light source to a closer or farer distance) during fixture
b. Parts fixture (10 – 30 seconds): apply the adhesive from the center to the edge of the bonding area, not the opposite
c. To remove excess adhesive providing quality aesthetics, use a cutter or other mechanical tools. Notice that even after irradiation the part of the adhesive exposed to air remains oily on the surface (oxygen inhibition). The oily effect should disappear (seconds to days), but it can be eventually removed with Acetone.

LOXEAL Srl - Via Marconato 2 - 20811 - CESANO MADERNO (MB) - Italy - Tel +39 (0)362 5293.1 - Fax +39 (0)362 524225 - www.loxeal.com

d. Expose for about 2-4 minutes to UV light, with a power emission stronger than the one used during fixture for bonding finishing.

5. Bonding stability
When internal stresses are assumed and/or in case of irregular thickness of the adhesive film, gentle heating of the parts at a temperature of +50°C/+60°C should be considered to stabilize the bonding.

Warnings

This adhesive is not approved for usage with neither pure nor with gaseous oxygen.
The liquid product may damage paints and elastomers. If the product gets in contact, even accidentally, with some thermoplastics, stress cracking of the plastics could happen.

Storage

Keep product in a cool and dry room at +5°/+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

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