

Technical Data Sheet

Preliminary

LOXEAL INSTANT ADHESIVE 48

Description

Loxéal INSTANT 48 is a gel, fluid ethyl cyanoacrylate adhesive, suitable for bonding of rubber, plastics, woods and ceramics. Designed to be easily dispensed by dosing systems. Its delayed fixture time allows parts repositioning; it provides temperature resistance up to +120°C.

Physical properties

Composition :	modified ethyl cyanoacrylate
Colour :	transparent
Viscosity (+25°C - Pa s) :	2.000 - 2.500 thixo
Specific weight (g/ml) :	1,05
Max. gap to fill :	0,5 mm
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.

<u>Substrate</u>	<u>Fixture Time (seconds)</u>
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Plastics

* Phenolic Resin:	< 30
* Steel:	< 30
* Neoprene/NBR :	< 30

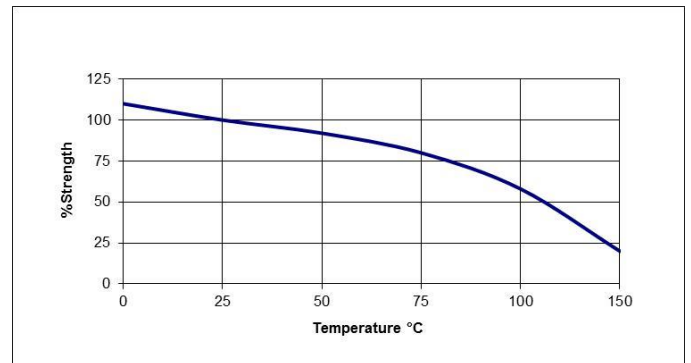
In case of too long setting time, we recommend to use Loxéal Activator 9. In case of usage with PE, PP, Silicone rubbers or PTFE Loxéal Primer 7 is always recommended.

Properties of cured material (typical)

Shear strength ISO 4587 (N/mm ²) :	13 - 18
Coefficient of thermal expansion :	90 x 10 ⁻⁶ mm/mm/°C
Dielectric strength ASTM D 149 (kV/mm) :	25
Coefficient of thermal conductivity:	0,1 W/(m.K)

Environmental resistance

The graph below shows the mechanical strength of the product (%) vs. temperature. Specimen steel - ISO 4587



Directions for use

Clean and degrease parts to bond with Loxéal Cleaner 10. Excess of product either cured or not can be removed with Loxéal CA Remover.

Storage

We recommend to store product in a cool and dry place at temperature non exceeding +20°C. For better and enhanced shelf life, keep product in a refrigerator at +2°C/+7°C. To avoid contaminations do not refill containers with used product. For more information on applications, storage and handling contact Loxéal Technical Service

Safety and handling

Consult the 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.

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