LOXEAL ENGINEERING ADHESIVES

UNI EN ISO 9001 - UNI EN ISO 14001

Registered Quality and Environment Management System Company

Technical Data Sheet

LOXEAL INSTANT ADHESIVE 75

Description

General purpose high viscosity Ethil-Cyanoacrylate adhesive with superior peel and impact resistance. Suitable for bonding rubbers, metals and plastics.

Physical properties

Composition :	ethyl cyanoacrylate modified
Colour :	clear/colourless
Viscosity (+25°C - mPa s) :	4.000 - 5.000
Specific weight (g/ml) :	1,10
Gap to fill :	up to 0,25 mm
Flash point :	see MSDS
Shelf life :	12 months in original unopened packaging
Temperature range :	-50°C/+100°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 :	15 - 70
* Phenolic Resin :	10 - 30
* ABS :	10 - 30
Metals	
* Steel :	15 - 45
* Aluminium :	10 - 60
* Zinc :	10 - 60
Various substrates	
* Neoprene/NBR :	10 - 30
* EPDM :	30 - 70

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.

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

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

Proprieties of cured material (typical)

(24 hours curing at +25°C)

Tensile strength ISO 6922 (N//mm^2) :	12 - 25
Shear strength ISO 4587 (N//mm^2) :	
Steel	15 - 25
ABS	>6
Refraction index n $^{20}_{D}$:	similar to glass
Electrical resistivity ASTM D 257 (Ω mm) :	$>10^{15}$
Dielectric strength ASTM D 149 (Kv/mm) :	25

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.

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 Loxeal Technical Service

Safety and handling

Consult the Safety Data Sheet before use.

Note

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