

LOXEAL INSTANT ADHESIVE 63

Description

Instant adhesive on basis of alcoxy-ethyl cyanoacrylate. Low odour not irritating, non blooming effect for appearance sensitive assemblies. Especially suitable to be used in non ventilated or closed areas. Delayed setting time allows adjustment of parts during assembly.

Physical properties

Composition: alcoxy- ethyl cianoacrylate
Colour : clear
Viscosity (25°C –mPa.s): 80-150
Specific weight (g/ml): 1,07
Gap to fill: 10 – 150 microns
Flash point (ISO 2592): 87°C
Shelf life : 6 months at 20 °C
Temperature range -50°C + 80°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>Fixturing Time</u> (seconds)
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Plastics

* PVC: 20- 50
* Phenolic Resin: 10- 40
* ABS: 15- 40

Metals

* Steel: 20 - 50
* Aluminium: 10- 30
* Zinc: 40 - 100

Various substrates

*Neoprene/NBR : 5 - 10

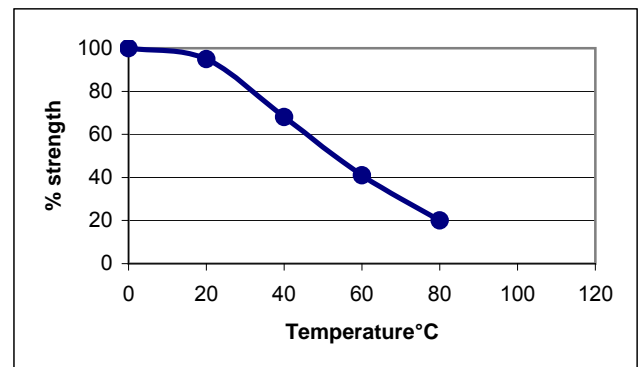
In case setting time is unacceptably long, we recommend the use of Loxeal Activator 9. IN case of usage with PE ,PP, Silicone rubbers or PTFE Loxeal Primer 7 is always recommended.

Proprieties of cured material

Tensile strength ASTM D 2095 (N/mm²): 10 - 25
Shear strength ISO 4587 (N/mm²): 14 - 22
Impact strength ASTM D 950 (N.mm/ mm²): 15 - 20
Softening range: 150°C
Refraction index n²⁰_D: similar to glass
Electrical resistivity DIN 53482 (Ω.mm): >10¹⁵
Dielectric strength ASTM D149 (kV/mm): 25
Dielectric constant DIN 53483 (1MHz): 3

Environmental resistance

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



Chemical resistance

After 24 hours of polymerisation at indicated temperature.

Substance	°C	Resistance after 100 h	Resistance after 500 h	Resistance after 1000 h
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Motor oil	40	Discrete	Discrete	Low
Alcohol	25	Good	Good	Good
Gasoline	25	Excellent	good	Discrete
Relative humidity 90%	40	Low	Null	Null
Refrigerating gases	25	Excellent	Excellent	Excellent

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

Directions for use

Clean and degrease parts to bond with Loxeal Cleaner 10. Excess of product 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 +3 /+8°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.

Note

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