

Technical Data Sheet

LOXEAL INSTANT ADHESIVE 32

Description

Very fast curing instant adhesive on basis of ethyl cyanoacrylate. Low viscosity, designed for fast bonding of EPDM, foam rubber, difficult to bond rubber, soft/plastic.

Physical properties

Composition: ethyl cyanoacrylate
Colour: clear/colourless
Viscosity (+25°C - mPa s): 5 - 10
Specific weight (g/ml): 1,10
Gap to fill: 10 - 40 microns
Flash point: see MSDS

Shelf life: 12 months in original unopened packaging

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.

Substrate	Fixture Time (seconds)
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Plastics

* PVC : 2 - 10 * Phenolic Resin : 5 - 15 * ABS : 2 - 10

Metals

* Steel: 10 - 20

* Aluminium: 2 - 10

* Zinc: 30 - 90

Various substrates

*Neoprene/NBR: < 2 * Rubber: 2 - 5 * EPDM: < 5

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.

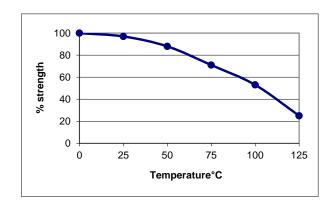
Proprieties of cured material (typical)

Tensile strength ISO 6922 (N//mm²): 12 - 25 Shear strength ISO 4587 (N//mm²): 13 - 18 Softening range: +160°C/+170°C Similar to glass Electrical resistivity DIN 53482 (Ω mm): >10¹⁵ Dielectric strength ASTM D 149 (kV/mm): 25 Dielectric constant DIN 53483 (1MHz): 5,2

Environmental resistance

The graph below shows the mechanical strength of the product (%) vs. temperature.

Specimen steel - ISO 4587



Chemical resistance

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

Substance				Resistance after 1000 h
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Motor oil	40	excellent	excellent	excellent
Alcohol	25	excellent	excellent	excellent
Gasoline	25	excellent	excellent	excellent
Relative	40	discrete	discrete	low
humidity				
90%				
Refrigerating	25	excellent	excellent	excellent
gases				

^{*} 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 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

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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