

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.

<u>Substrate</u>	<u>Fixture</u> <u>Time</u> (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

Substance

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

Resistance

after 500 h

Resistance

after 1000 h

Resistance

after 100 h

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

<sup>\*</sup> 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<sup>2</sup>): 12 - 25

Shear strength ISO 4587 (N//mm<sup>2</sup>):

Steel 15 - 25
ABS >6
Refraction index n <sup>20</sup>D: similar to glass

Refraction index n  $^{20}$ D : similar to glass Electrical resistivity ASTM D 257 ( $\Omega$  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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