

Technical Data Sheet

ADHESIVE 36- 10 2-COMPONENT ENGINEERING ADHESIVE IN DUAL CARTRIDGE WITH SELF-MIXING NOZZLE

Description

Multipurpose, transparent structural adhesive, 150 minutes setting time.

Recommended for structural bonding of many materials: metals, ferrite, ceramic, marble, glass, concrete, wood and some plastics (polyester, ABS, rigid PVC).

Not indicated for rubber, soft materials, polyethylene, polypropylene and Teflon. Resistant to water, gasoline and oils.

Physical properties

Related to product extruded through the mixer nozzle*

The predetermined ratio between the two components is 1:1*

Composition:	epoxy- polyamide resin
Colour :	honey amber
Viscosity of the resin (25°C –mPa.s):	14.000 - 28.000
Viscosity of the hardener (25°C –mPa.s):	10.000 – 25.000
Specific weight (g/ml):	1,10
Gap to fill:	0,1 – 2,0 mm
Shelf life :	minimum 1 year in the original packing

Curing properties

Handling cure time : 90 - 150 minutes**

Full cure time: 12 - 24 hours (1)

Shear strength: 12 - 18 N/mm²

(at 20°C on steel) ASTM D 1002

Temperature range: -40°C +80°C

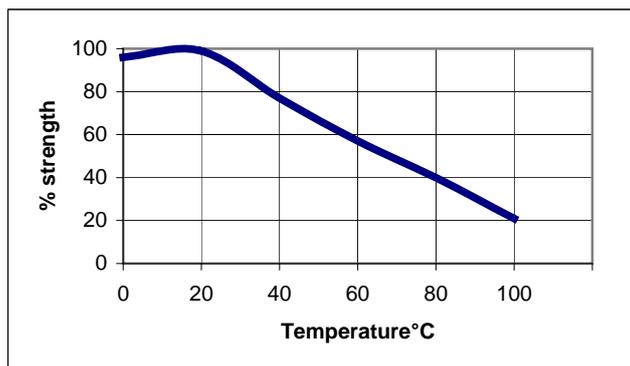
**Time detected using 2 g of Part A +Part B mix

(1)Final strength properties are reached after 6-7 days at room temperature

Environmental resistance

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

Specimen steel – ASTM 1002/DIN 53283 .



Chemical resistance

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

Substance	°C	Resistance after 100 h	Resistance after 500 h	Resistance after 1000 h
Motor oil	40	Excellent	Excellent	Excellent
Water	25	Excellent	Excellent	Excellent
Gasoline	25	Excellent	Excellent	Excellent
Cooling gas	25	Excellent	Excellent	Excellent

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

Directions for use

1. Surfaces preparation

To obtain good results we recommend to scratch the surfaces with a tool and then to degrease and clean with Loxeal Cleaner 10 or Acetone.

2. Mixing

The resin and the hardener need to be mixed before use in the ratio of weight and/or volume in compliance with technical specifications. Products are available in dual cartridges with static mixers that allow a direct and correct product application on the surfaces to bond. We recommend to not use the initial quantity of product extruded from the static mixer. Avoid excess of product blend because it may cause heating by chemical reaction.

3. Pot life

The pot life of the mixed product is belonging to the resin and the hardener. It may varie from few minutes to some hours at room temperature. High temperature reduces the pot life. We recommend to apply product at temperature not exceeding 20°C.

4. Assembly

Parts to bond shall be assembled immediately after product application and kept close until full polymerisation without putting any mechanical stress.

5. Cleaning

Excess of product can be removed with Acetone or any other solvent based cleaner compatible with the surfaces to bond. Application tools and dispensers shall be cleaned before the product is hardened. Hardened product can be only removed mechanically.

Storage

Keep product in a cool and dry room at no more than +25°C. To avoid contaminations do not refill containers with used product. For further information on applications, storage and handling contact Loxeal Technical Service

Safety and handling

Consult Material Safety Data Sheet

Note

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