

LOXEAL®

ENGINEERING ADHESIVES



11/2022

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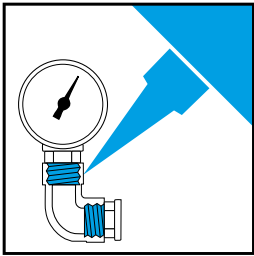
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THREAD SEALING

Guarantee hydraulic tightness of the threaded connections.

BENEFITS:

- Replace hemp and PTFE tapes.
- Range of products with different curing time.
- Lubricate for easier assembly.
- Available in 3 grades of locking strength: **low (easy to dismantle), medium (possible to dismantle), high (permanent locking).**
- Maintain the initial applied torque.
- Seal to the burst pressure and to thermal expansion rates.
- Seal and lock threaded connections against pressure of gas, air, water, oils, hydrocarbons and many chemicals.
- Certified according to various international standards, such as: DVGW, NSF, WRAS, BAM, GLOBAL MARK.

SUBSTRATES:

- Metal

	PRODUCT	MAX DIAMETER OF THREAD MAX GAP FILLING		*** VISCOSITY 25°C mPa s (LT-MT-HT)	COLOUR	CURING TIME		*** LOCKING TORQUE N m (ISO 10964)		SHEAR STRENGTH (ISO 10123) N/mm ²	TEMPERATURE RANGE °C	DESCRIPTION	
						HANDLING (minutes)	FUNCTIONAL (hours)	BREAKAWAY	PREVAILING				
LOW STRENGTH	15-36	2"	0.30 mm	3000-6000	LT	BLUE/F*	15 - 30	1 - 3	8 - 14	4 - 8	4 - 6	-55 / +180	Fluid, high temperature
	18-10	2"	0.30 mm	17000-70000	HT	WHITE	20 - 40	1 - 3	6 - 11	2 - 5	4 - 6	-55 / +150	PTFE paste, high viscosity, slow, elastic film
	23-18	3/4"	0.15 mm	600-800	LT	BLUE/F*	15 - 30	1 - 3	5 - 8	2 - 5	3 - 5	-55 / +150	Fluid, for small threads
MEDIUM STRENGTH	53-14	3/4"	0.15 mm	430-630	LT	BROWN/F*	10 - 20	1 - 3	12 - 18	10 - 20	8 - 12	-55 / +150	Fluid, general purpose
	55-14	2"	0.30 mm	2500-12000	MT	RED/F*	10 - 20	1 - 3	12 - 18	20 - 30	8 - 12	-55 / +150	Medium viscosity, general purpose
	55-37	1-1/2"	0.25 mm	2500-4500	LT	RED/F*	15 - 30	1 - 3	15 - 32	25 - 45	10 - 14	-55 / +150	Flexible, high performances
	56-03	2"	0.30 mm	5000-30000	MT	BLUE	15 - 30	1 - 3	10 - 16	12 - 20	8 - 12	-55 / +150	Fill large gaps
	58-10	2"	0.30 mm	25000-90000	HT	WHITE/F*	5 - 10	0,5 - 1	18 - 25	10 - 20	6 - 13	-55 / +150	High viscosity, fast
	58-11	2"	0.30 mm	20000-80000	HT	YELLOW/F*	15 - 30	1 - 2	18 - 24	7 - 14	6 - 13	-55 / +150	High viscosity, no risk phrases, blank MSDS
	58-12	2"	0.30 mm	20000-80000	HT	YELLOW	15 - 45	6 - 12	18 - 24	7 - 14	4 - 10	-55 / +150	High viscosity, Green, no risk phrases, blank MSDS
HIGH STRENGTH	82-01	3/4"	0.15 mm	220-300	LT	GREEN	2 - 5	1 - 3	20 - 35	50 - 70	20 - 30	-55 / +175	Sealant/retainer, fluid, fast
	83-05	3/4"	0.20 mm	500-1000	LT	GREEN	2 - 5	1 - 3	25 - 35	50 - 70	25 - 35	-55 / +200	Fluid, for stainless steel and passivated metals
	83-50	3/4"	0.20 mm	400-1000	LT	GREEN/F*	2 - 5	1 - 3	25 - 35	40 - 50	25 - 35	-55 / +200	Fluid, high temperature, for stainless steel
	84-90	1-1/2"	0.20 mm	1000-1500	LT	GREEN	15 - 30	3 - 6	20 - 30	30 - 40	10 - 20	-55 / +250	High temperature, up to + 250 °C
	85-21	1-1/2"	0.20 mm	2600-3400	LT	GREEN/F*	2 - 5	1 - 3	30 - 40	55 - 70	25 - 35	-55 / +150	Sealant/retainer, fast, allow working tolerances
	85-86	2"	0.30 mm	2200-4000	LT	GREEN/F*	10 - 40	6 - 12	25 - 35	40 - 55	15 - 25	-55 / +200	High temperature up to + 200°C
	86-55	2"	0.30 mm	5000-8000	LT	RED/F*	60 - 90	12 - 24	15 - 35	15 - 45	10 - 20	-55 / +150	Delayed curing
	86-58	2"	0.30 mm	5000-7000	LT	RED/F*	30 - 60	6 - 12	35 - 40	40 - 50	15 - 25	-55 / +150	High resistance, for brass
	86-53	2"	0.30 mm	5000-7000	HT	RED	5 - 30	3 - 6	30 - 40	45 - 55	15 - 25	-55 / +150	High viscosity and thixotropic, high resistant to (heat, corrosion, vibration, water, gases, oils, hydrocarbons and many chemicals)

LEGEND

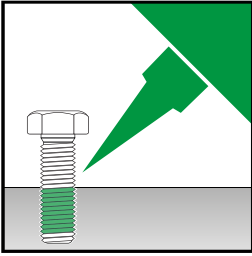
VISCOSITY BROOKFIELD:

HT- High thixotropy
 MT- Medium thixotropy
 LT- Low thixotropy

COLOR:

F* = Fluorescent under blue light





THREAD LOCKING

Loxal anaerobic thread locking adhesives enable you to lock bolts, studs, nuts and screws and to avoid loosening caused by stress and vibration.

BENEFITS:

- Replace mechanical washers and fasteners.
- Prevent loosening caused by vibration, mechanical and thermal shock.
- Lubricate for easier assembly.
- Maintain the initial applied torque.
- Available in 3 grades of locking strength: **low (easy to dismantle)**, **medium (possible to dismantle)**, **high (permanent locking)**.
- Certified according to various international standards, such as: DVGW, Gas de France, WRAS.

SUBSTRATES:

- Metal

	PRODUCT	MAX DIAMETER OF THREAD MAX GAP FILLING		*** VISCOSITY 25°C mPa s (LT-MT-HT)	COLOUR	CURING TIME		*** LOCKING TORQUE N m (ISO 10964)		SHEAR STRENGTH (ISO 10123) N/mm²	TEMPERATURE RANGE °C	DESCRIPTION	
						HANDLING (minutes)	FUNCTIONAL (hours)	BREAKAWAY	PREVAILING				
LOW STRENGTH	24-18	M24	0.20 mm	800-1400	MT	PURPLE/F*	15 - 30	1 - 3	5 - 8	2 - 5	3 - 5	-55 / +150	Anti-vibration, general purpose
	54-03	M24	0.20 mm	900-1500	MT	LIGHT BLUE/F*	10 - 20	1 - 3	14 - 20	4 - 9	8 - 12	-55 / +150	Fluid, general purpose
MEDIUM STRENGTH	55-02	M36	0.25 mm	2500-12000	MT	BLUE	20 - 40	6 - 12	18 - 25	9 - 16	9 - 13	-55 / +150	Green, no risk phrases, blank MSDS
	55-03	M36	0.25 mm	1700-9000	MT	BLUE/F*	10 - 20	1 - 3	18 - 23	9 - 16	9 - 13	-55 / +200	High temperature, oil tolerant
	55-04	M36	0.25 mm	1500-8600	MT	RED/F*	10 - 15	1 - 3	20 - 25	40 - 50	10 - 15	-55 / +150	Fill large gaps, for large diameter studs
HIGH STRENGTH	70-10	M5	0.07 mm	10-20	LT	GREEN	40 - 80	3 - 6	5 - 10	5 - 15	2 - 10	-55 / +150	Capillary penetration on pre-assembled parts, for brass & copper
	70-14	M5	0.07 mm	10-20	LT	GREEN	10 - 20	1 - 3	10 - 25	25 - 40	8 - 12	-55 / +150	Capillary penetration on pre-assembled parts, fast
	83-31	M20	0.15 mm	580-780		GREEN	60 - 120	12 - 24	12 - 25	25 - 40		-55 / +175	For cylindrical components
	83-52	M20	0.15 mm	450-650	LT	GREEN	20 - 40	6 - 12	25 - 35	50 - 65	10 - 20	-55 / +150	Green, no risk phrases, blank MSDS
	83-54	M20	0.15 mm	450-650	LT	GREEN	10 - 20	1 - 3	25 - 35	50 - 65	15 - 20	-55 / +200	General purpose, high temperature
	83-55	M20	0.15 mm	450-600	LT	RED/F*	10 - 20	1 - 3	25 - 35	50 - 65	15 - 20	-55 / +150	Sealant/retainer, oil tolerant
	85-56	M56 2"	0.30 mm	2500-4500	LT	BLUE/F*	15 - 30	3 - 6	30 - 40	40 - 50	15 - 25	-55 / +150	General purpose, medium viscosity
	86-54	M56 2"	0.30 mm	8000-24000	MT	GREEN/F*	15 - 30	3 - 6	40 - 50	45 - 55	15 - 25	-55 / +150	High viscosity, fast curing, fill large gaps
86-72	M56 2"	0.30 mm	5000-28000	MT	RED	20 - 40	3 - 6	25 - 35	40 - 70	10 - 20	-55 / +230	High temperature up to + 230 °C	

LEGEND

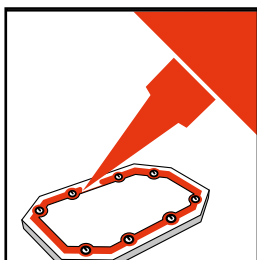
VISCOSITY BROOKFIELD:

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COLOR:

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GASKETING

Seal flat mating surfaces and join flanges on pumps, gearboxes and differential housings of any shape and dimension in an easy and effective way directly from the tube or the cartridge both vertically and horizontally.

BENEFITS:

- Prevent leakage on aging (vs performed paper, cork, or plastic gaskets).
- One adhesive replaces many pre-cut gasket shapes.
- Guarantee the parts sealing and enhance hydraulic tightness.
- Do not generate any thickness.
- Highly resistant against temperature, pressure, oils and chemicals.
- Prevent oxidation and fretting corrosion.
- Possible to dismantle with standard tools.
- Rapid cure speeds at low pressure and resistance to high temperature, up to +250 °C.

SUBSTRATES:

- Metal, plastic, glass, ceramic, enamel, wood

Liquid gasketing

PRODUCT	CLASS OF LOCKING	MAX GAP FILLING	***		COLOUR	CURING TIME		ADHESIVE STRENGTH			TEMPERATURE RANGE °C	DESCRIPTION
			VISCOSITY +25°C Pa s (LT-MT-HT)	HT		HANDLING (minutes)	FUNCTIONAL (hours)	SHEAR (ISO 4587) N/mm ²	TENSILE (ISO 6922) N/mm ²	IMPACT (ASTM D 950) KJ/m ²		
28-10	Low strength	0.30 mm	17-60	HT	GREEN/F*	20 - 40	3 - 6	4 - 6	2 - 4	2 - 4	-55 / +150	Easy to dismantle, elastic film
58-14	Medium strength	0.50 mm	28-100	HT	ORANGE	15 - 30	3 - 6	5 - 10	5 - 8	3 - 5	-55 / +150	General purpose
58-31	Medium strength	0.50 mm	70-600	HT	RED/F*	10 - 20	1 - 3	8 - 13	7 - 10	4 - 7	-55 / +180	Elastic film, high performances
59-10	Medium strength	0.50 mm	50-300	HT	RED/ORANGE	15 - 30	3 - 6	5 - 10	6 - 8	3 - 5	-55 / +200	High temperature, fill large gaps

Elastomeric & plastic Gasket

PRODUCT	APPEARANCE	COLOUR	CURING TIME		ELONGATION AT BREAK %	TENSILE STRENGTH (ISO 10123) N/mm ²	HARDNESS SHORE A	TEMPERATURE RANGE °C	DESCRIPTION
			INITIAL STRENGTH (minutes)	BEAD Ø 2 mm					
59-20	Paste	Transparent Grey/black	15 - 30	24 h	400 - 600	0.8 - 2	20 - 30	-55 / +180	Odourless neutral silicone, high oil resistance Odourless neutral silicone, high oil resistance
			15 - 30	24 h	400 - 600	0.6 - 1.5	20 - 30	-55 / +180	
59-30	Paste	Red/black	10 - 20	24 h	300 - 600	1.5 - 2.5	25 - 35	-60 / +250	High temperature silicone
59-40	Paste	Transparent Grey	10 - 20	24 h	80 - 150	1 - 2	40 - 50	-40 / +90	MS polymer, odourless, paintable, UV rays resistant MS polymer, odourless, paintable, UV rays resistant
			10 - 15	24 h	150 - 350	1.2 - 1.8	40 - 60	-40 / +90	

LEGEND

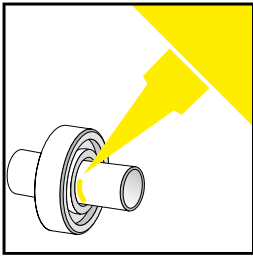
VISCOSITY BROOKFIELD:

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COLOR:

F* = Fluorescent under blue light





RETAINING

Retaining anaerobic Loxal adhesives lock and fit cylindrical assemblies and increase the load carrying capacity.

BENEFITS:

- Allow high strength cylindrical assemblies like: bearings, pulleys, pivots, bushes.
- Replace welding and mechanical retainers.
- Allow larger machining tolerances, reducing manufacturing cost.
- Lubricate for easier assembly.
- Seal the joint preventing fretting corrosion.
- Can seal together different materials.
- Ensure high transmission strength.
- High temperature resistance.

SUBSTRATES:

- Metal

	PRODUCT	MAX DIAMETER OF THREAD MAX GAP FILLING		*** VISCOSITY 25°C mPa s (LT-MT-HT)	COLOUR	CURING TIME		*** LOCKING TORQUE (ISO 10964) N m		SHEAR STRENGTH (ISO 10123) N/mm ²	TEMPERATURE RANGE °C	DESCRIPTION		
						HANDLING (minutes)	FUNCTIONAL (hours)	BREAKAWAY	PREVAILING					
MEDIUM STRENGTH	53-11	M20	0.12 mm	400-650	LT	YELLOW/F*	10 - 20	1 - 3	11 - 20	15 - 25	8 - 12	-55 / +150	General purpose	
	82-13	M12	0.10 mm	120-180	LT	GREEN/F*	30 - 60	12 - 24	15 - 25	35 - 45	15 - 30	-55 / +150	Fluid, for precise joints, slow curing	
HIGH STRENGTH	82-21	M12	0.10 mm	120-180	LT	GREEN	5 - 10	1 - 3	24 - 35	50 - 60	17 - 22	-55 / +150	Fluid, for precise joints, fast curing	
	82-33	M12	0.10 mm	120-180	LT	GREEN	5 - 10	1 - 3	20 - 30	45 - 55	17 - 22	-55 / +150	Oil tolerant	
	83-03	M20 3/4"	0.20 mm	800-1200	LT	GREEN/F*	2 - 5	1 - 3	25 - 35	50 - 70	25 - 35	-55 / +200	Fluid, very fast curing, high temperature	
	83-21	M20 3/4"	0.15 mm	400-600	LT	GREEN	2 - 5	1 - 3	25 - 35	50 - 70	25 - 35	-55 / +175	General purpose, fast curing, high temperature	
	85-02	M36 1-1/2"	0.20 mm	3000-4000	MT	GREEN/F*	1 - 4	1 - 3	30 - 40	55 - 70	25 - 35	-55 / +175	Very fast curing, high temperature	
	85-21	M36 1-1/2"	0.20 mm	2600-3400	LT	GREEN/F*	2 - 5	1 - 3	30 - 40	55 - 70	25 - 35	-55 / +150	Sealant/retainer Fast, allow working tolerances	
	85-23	M36 1-1/2"	0.20 mm	2500-4500		Transparent	Brass: < 2 Chromed: 10 - 20 Steel: 5 - 10 Aluminium: 6 - 18	2 - 4	30 - 40	40 - 50	25 - 35	-55 / +150	Fast curing, high strength, allows larger machining tolerances	
	85-61 UV	M36 1-1/2"	0.20 mm	3000-4000	LT	BLUE/F*	5 - 10	1 - 3	30 - 40	50 - 60	20 - 25	-55 / +150	Double curing: anaerobic & UV	
	86-21		2"	0.30 mm	7000-30000 THIXO		GREEN/F*	1 - 4	1 - 3	30 - 40	50 - 70	25 - 30	-55 / +150	High viscosity, fill large gaps, fast curing
	86-86	M56 2"	0.30 mm	5000-35000	MT	GREEN/F*	20 - 40	3 - 6	25 - 35	40 - 70	10 - 20	-55 / +230	High temperature	
89-51		2"	0.30 mm	60000-720000	HT	SILVER	15 - 30	3 - 6	40 - 45	15 - 20	25 - 30	-55 / +150	Repair damaged shafts	

LEGEND

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COLOR:

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UV CURING ADHESIVES

Loxéal UV curing adhesives cure in a short time in presence of a UV light source, if at least one of the substrates is transparent. They create a very tough plastic film.

BENEFITS:

- Usually colorless, they are designed to bond clean, transparent and not yellowing junctions.
- They're suitable for coating, potting and sealing.
- They are extremely reactive, they start curing as the sun UV light activates the photo initiators.
- Different kind of UV lamps are available for industrial use, such as mercury vapor lamps and led lamps.
- Some of Loxéal UV curing adhesives can be used for medical devices application.

SUBSTRATES:

- Glass/glass, glass/metal, transparent plastic (PC, ABS, PMMA)

	PRODUCT	VISCOSITY +25°C mPa s	GAP FILLING mm	SPEED ON CURE	UV CURE (nm)	HARDENESS (Shore D)	ELONGATION AT BREAK (%) DIN 53504	TENSILE STRENGTH (ASTM D 2095-69) N/mm ²	DESCRIPTION
PLASTIC	30-11	200 - 300	0.03 - 0.20	+	365 - 400	50 - 65	100 - 150	-	Fluid for medical plastic, approved for medicals ISO 10993
	30-12	200 - 400	0.03 - 0.20	++	365 - 400	50 - 65	120 - 200	-	Specific for thermoplastic
	30-12 GEL	GEL	0.03 - 2	++	365 - 400	70 - 80	120 - 200	-	Gel, specific for thermoplastic
	UV3013	1500 - 2000	0.03 - 1.5	++	365 - 400	40 - 50	200 - 250	-	Specific for PMMA and transparent plastic
	30-27	90 - 150	0.03 - 0.20	++	365 - 400	70 - 80	10 - 50	-	Specific for medical needles, approved for medicals ISO 10993
GLASS	30-20	2200 - 2900	0.03 - 1.5	+	365 - 400	50 - 65	80 - 100	10 - 14	Transparent, fast curing, general purpose, for decorative objects
	30-21	600 - 1300	0.03 - 1.5	+	365 - 400	50 - 70	90 - 150	10 - 14	Tough, bonding on edges
	30-22	5500 - 7500	0.03 - 2	++	365 - 400	50 - 65	80 - 100	8 - 12	Transparent, high viscosity, general purpose
	30-23	50 - 100	0.03 - 1.5	+	365 - 400	60 - 75	60 - 100	10 - 14	Very fluid, for plain surfaces
	30-24	2200 - 2900	0.03 - 2	++	365 - 400	50 - 70	60 - 100	12 - 16	Rigid film, high resistance, for decorative objects
	30-30	500 - 800	0.03 - 1.5	++	400	50 - 60	60 - 120	8 - 14	Clarity overtime, adhesive excess easy to clean
	30-33	1000 - 2000	0.03 - 1.5	++	365 - 400	65 - 75	80 - 150	6 - 10	Clarity overtime, tough
	30-34	2500 - 3500	0.03 - 1.5	++	365 - 400	60 - 70	80 - 120	8 - 14	Clarity overtime, for decorative objects
	30-35	5000 - 8000	0.03 - 1.5	++	365 - 400	40 - 50	150 - 200	8 - 12	Clarity overtime, resistant to humidity
	30-36	5000 - 8000	0.03 - 2	++	365 - 400	60 - 70	100 - 150	8 - 12	Clarity overtime, tough, fill large gaps
	30-37	2200 - 2900	0.03 - 1.5	++	365 - 400	50 - 60	90 - 150	6 - 10	Flexible, for bonding glass with metallic plastics
	30-38	20000 - 30000	0.03 - 2	++	365 - 400	50 - 75	100 - 150	5 - 10	Clarity overtime, high viscosity, fill large gaps
	30-60	GEL	0.03 - 2.5	+	365 - 400	60 - 70	60 - 100	4 - 8	Gel, transparent, for vertical bonding
	30-83	1000 - 1600	0.03 - 1	++	365 - 400	50 - 65	50 - 100	-	For coating and doming, tack-free





CYANOACRYLATE ADHESIVES - INSTANT

The Cyanoacrylate range Loxel Instant is developed to bond quickly a huge variety of substrates. They cure by reacting to small traces of moisture on substrates surfaces.

BENEFITS:

- Curing in seconds at room temperature.
- Allow high resistance in a short time.
- Solvent free.
- Allow neat assembly without mechanical means (rivet, screws, welding).
- Easy dispensing either manually or with dosing systems.
- Three different chemical bases for specific needs: (Methyl for metals / Ethyl as universal and in special modified versions / Alcoxy, no blooming - odour free).
- Can resist to high temperature.

SUBSTRATES:

- Metal, plastic, rubber, paper, wood and cork.

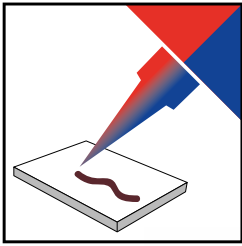
IN COMBINATION WITH PRIMER 7:

- Polyethylene, Polypropylene, EPDM, silicone rubber and PTFE.



	PRODUCT	SPECIFIC GRAVITY	VISCOSITY +25°C mPa s	GAP FILLING (microns)	SPEED OF CURE (5 fast, 1 slow)	TENSILE STRENGTH (ISO 6922) N/mm ²	SHEAR STRENGTH (ISO 4587) N/mm ²	DESCRIPTION
METHYL	IST 14	1.10	80 - 150	10 - 100	2	25 - 30	20 - 25	Fluid, high resistance, delayed curing, for metals
	IST 17	1.19	1200 - 1800	10 - 200	1	25 - 30	18 - 25	High viscosity, high resistance, delayed curing, for metals
ETHYL	IST 23	1.06	40 - 80	10 - 60	3	12 - 25	13 - 18	Fluid, general purpose
	IST 25	1.10	350 - 450	10 - 150	3	15 - 23	13 - 20	Medium viscosity, general purpose
	IST 27	1.10	1200 - 1800	10 - 200	2	18 - 25	13 - 18	High viscosity, general purpose, fill large gaps
	IST 32	1.10	5 - 10	10 - 40	5	12 - 25	13 - 18	Difficult to bond rubber and plastic, very fast curing
	IST 34	1.10	10 - 30	10 - 100	5	12 - 25	13 - 18	Difficult to bond rubber and plastic, very fast curing
	IST 41	1.10	5 - 10	10 - 40	5	18 - 25	13 - 18	Fluid, difficult to bond substrates, very fast curing
	IST 43	1.10	80 - 150	10 - 150	4	22 - 25	15 - 20	High resistance on wood, leather, fabrics, ceramics and metal
	IST 43S	1.06	80 - 150	10 - 150	5	15 - 25	15 - 20	Universal, high temperature, approved for food NSF P1
	IST 45	1.06	600 - 1200	10 - 150	4	12 - 25	12 - 20	High viscosity, difficult to bond substrates
	IST 47	1.08	GEL	10 - 300	2	18 - 25	13 - 18	Gel, high temperature, approved for food NSF P1
	IST 48	1.05	2000 - 2500 THIXO	0.5 mm	2	18 - 25	13 - 18	Fluid gel, vertical bonding, for porous surfaces

	PRODUCT	SPECIFIC GRAVITY	VISCOSITY +25°C mPa s	GAP FILLING (microns)	SPEED OF CURE (5 fast, 1 slow)	TENSILE STRENGTH (ISO 6922) N/mm ²	SHEAR STRENGTH (ISO 4587) N/mm ²	DESCRIPTION
ALCOXY	IST 60R	1.06	3 - 10	10 - 30	1	10 - 20	14 - 22	Delayed curing infiltrant for better penetration, for 3D printing
	IST 61	1.06	10 - 20	10 - 40	1	10 - 20	14 - 22	Fluid, odourless, no blooming
	IST 63	1.07	80 - 150	10 - 150	1	10 - 25	12 - 22	General purpose, odourless, no blooming
MODIFIED	IST 67	1.1	1000 - 1500	10 - 200	1	10 - 25	12 - 22	High viscosity, odourless, no blooming
	IST 29	1.06	500 - 1500	10 - 200	1	18 - 25	13 - 18	Elastomeric, black, general purpose
	IST 37	1.05	1000 - 2000	10 - 200	3	12 - 25	16 - 20	High viscosity, flexible, high impact resistant
	IST 73	1.06	100 - 200	10 - 150	2	12 - 25	15 - 25	Tough and flexible, high temperature
	IST 74	1.06	100 - 200	10 - 150	2	12 - 25	15 - 25	High temperature, black, tough and flexible
	IST 75	1.10	4000 - 5000	10 - 250	2	12 - 25	15 - 25	High viscosity, tough, high performance, general purpose
HIGH TEMPERATURE	IST 77	1.10	2000 - 4000	10 - 250	2	12 - 25	15 - 25	High viscosity, tough, black, high performance, general purpose
	IST 54	1.06	5 - 15	10 - 60	2	18 - 25	13 - 18	Fluid, resistant up to +130°
	IST 55	1.06	600 - 1000	10 - 200	2	18 - 25	18 - 25	Medium viscosity, resistant up to +130°
	IST 56	1.10	100 - 150	10 - 150	2	18 - 25	16 - 20	Fluid, resistant up to +200°



EPOXY ADHESIVES

Loxale epoxy adhesives are structural adhesives with high mechanical resistance. The 2k resins cure by mixing the two components (resin and hardener), usually at room temperature. The modified 2k epoxy resins are designed for applications that require flexible bonding and sealing. 1k epoxy resins are the highest performant adhesives as for mechanical, thermal and chemicals resistance, they cure by means of heating.



BENEFITS:

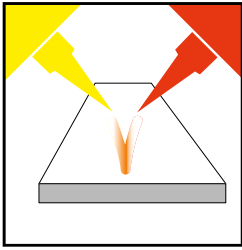
- High mechanical resistance.
- Can bond different materials.
- Different curing times available.
- Heating shorten the curing process.
- Fill large gaps.
- Highly resistant against humidity and chemicals.
- Available in a full color range: from transparent for glass and design to black for carbon fiber.

SUBSTRATES:

- Metal, composite, glass, ceramic, wood, stone, plastic.

	PRODUCT	COLOUR	VISCOSITY +25°C Pa s	HANDLING TIME (+25 °C) minutes	FUNCTIONAL CURE TIME (+25 °C)	SHEAR STRENGTH (ISO 4587) N/mm ²	PEEL STRENGTH N/25 mm	DESCRIPTION
TWO-PART Viscosity = (A) resin + (B) hardener (*) time detected on a 2 g total mass mixture A + B (**) Heat curing for 60 minutes at +80 °C	31-10	AMBER	12-18 (A) / 10-25 (B)	90 - 150 (*)	12 - 24 h	12 - 14	10 - 25	Tough, 120 minutes
	31-40	COLOURLESS	12-18 (A) / 15-30 (B)	10 - 20 (*)	30 - 40 min	10 - 12	4 - 20	Tough, transparent, 15 minutes
	31-42	COLOURLESS	12-18 (A) / 15-30 (B)	3 - 8 (*)	20 - 30 min	12 - 14	4 - 20	Tough, transparent, 5 minutes
	32-43	TRANSLUCENT	30-55 THIXO (A) / 50-80 THIXO (B)	5 - 10 (*)	10 - 20 min	10 - 14	-	General purpose, fast curing also at low temperature
	35-44	COLOURLESS	10-20 (A) / 14-24 (B)	10 - 20 (*)	40 - 60 min	5 - 9	25 - 60	General purpose, tough and flexible, high peel resistant
	36-10	AMBER	14-28 (A) / 10-25 (B)	90 - 150 (*)	12 - 24 h	12 - 18	25 - 40	Flexible and tough, 120 minutes
	3636	GREY	50-100 THIXO (A) / 100-200 THIXO (B)	50 - 80 (*)	72 - 96 h	15 - 25	60 - 80	Tough, high viscosity, slow curing
	4401	GREY	60-120 THIXO (A) / 50-100 THIXO (B)	10 - 15	24 - 36 h	20 - 30	150 - 300 (**)	Tough, high temperature
	4428	BLACK	60-150 THIXO (A) / 100-200 THIXO (B)	10	24 - 36 h	18 - 22	150 - 200	Fast curing, high temperature, for composites
	4429	BLACK	50-80 THIXO (A) / 50-80 THIXO (B)	150	24 - 36 h	18 - 22	200	High viscosity, non-sag, slow curing, high temperature, for composites
	METALOX	METAL GREY	THIXO	15	5 h			2K Fast and high strenght for metal bonding and repair
EB4451	GREY	5-15 THIXO (A) / 8-25 THIXO (B)	150	36 - 48 h	18 - 22	-	Thermally conductive, high temperature	
EPOXSTIK	AMBER	PASTE		5 - 7	15 - 25 min	4 - 6	-	Plastic putty designed for fast or emergency maintenance and repair
HYBRID TWO-PART	4807	GREY	15-25 THIXO (A) / 0.7-2 (B)	10 - 20	72 h	4 - 10	60 - 80	Maximum flexibility, for bonding together different materials
	4820	BLACK	20-50 / 0.2-0.3	25 - 50	72 h	4 - 7	-	Self-levelling, maximum flexibility, general purpose
	4821	BLACK	THIXO PASTE	10 - 15	72 h	4 - 7	60 - 80	High viscosity, maximum flexibility, general purpose
	4826	IVORY	THIXO PASTE	-	72 h	1 - 2	-	Self-extinguishing, thermally conductive, high temperature

	PRODUCT	COLOUR	VISCOSITY +25°C Pa s	HANDLING TIME AT +25 °C minutes	SHEAR STRENGTH (ISO 4587) N/mm ²	PEEL STRENGTH (ISO 4587) N/25 mm	TEMPERATURE RANGE °C	DESCRIPTION
SINGLE-PART (-) Curing time depends on the temperature	4500	GREY	800-3800 THIXO	30 min / @ +150°C	20 - 30	80 - 120	-40 / +180	Tough, high viscosity, for vertical bonding, high performances
	4580	GREY	150-250 THIXO	45 min / @ +150°C	18 - 25	80 - 120	-40 / +180	Tough, self-levelling, fluidify while curing
	4620	WHITE	15-30	30 min / @ +150°C	18 - 25	-	-40 / +180	Fluid, tough, self-levelling
	4680	IVORY	60-100	15 min / @ +150°C	20 - 25	-	-40 / +180	High impact strength, fluidify while curing for ferrites and magnets
	4690	BLACK	200-300 THIXO	45 min / @ +150°C	18 - 25	80 - 150	-40 / +180	Tough, non-sag, high performances
	4700	AMBER	8-12	90 min / @ +150°C	15 - 25	-	-40 / +180	Self-levelling, cure at low temperature
	4780	BLACK	400-600 THIXO	30 min / @ +150°C	15 - 25	-	-40 / +180	High viscosity, thermal conductive



ACRYLIC ADHESIVES

Loxéal epoxy adhesives are structural adhesives with high peel and impact strength. They assure high resistance against chemicals and good resistance against heat.

BENEFITS:

- Greatly increase in design possibilities to bond a wide variety of substrates.
- Suitable for materials with different thermal expansion coefficient.
- Shocks and vibrations resistant.
- Chemical reaction can start in different ways:
 - Mixing by static mixer
 - Bead on bead
 - At contact (with liquid activator)

SUBSTRATES:

- Metal, glass, ceramic, plastic.



	PRODUCT	VISCOSITY +25°C mPa s	POT LIFE (minutes)	HANDLING TIME (minutes)	FUNCTIONAL CURE (minutes)	SHEAR STRENGTH (ISO 4587) N/mm ²	PEEL STRENGTH (ISO 4587) N/25 mm	JOINT THICKNESS mm	DESCRIPTION
ACTIVATED	30-55 (+Att.20)	15000-30000 THIXO	-	1 - 4	30 - 60	15 - 25	85 - 100	1	High viscosity, general purpose
	3439 (+Att.20)	600-1000	-	20 - 50 seconds	10 - 20	20 - 30	85 - 100	0.2	Fluid, high temperature, high resistance
	3459 (+Att.20)	15000-25000 THIXO	-	20 - 40 seconds	10 - 20	20 - 30	85 - 100	0.2	Gel, high temperature, high resistance
BEAD ON BEAD	33-47 (A+B)	5000-12000	-	1 - 3	30 - 60	8 - 20	45 - 65	0.5	Fluid, general purpose
MIXING	3362	3000-6000 (A) / 3000-6000 (B)	4 - 7	10 - 12	90 - 180	20 - 25	-	1	Low odour, for plastic, high performances
	3452	4000-5000 (A) / 4000-5000 (B)	2 - 3	8 - 10	60 - 120	19 - 21	-	0.50	Low odour, for metal, high performances
	3460	THIXO (A) / 15000-30000 (B)	3 - 4	4 - 6	2 - 4 hours	10 - 15 (HDPE)	120	1	Fast, for polyolefins (PE, PP,...)
	3461	THIXO (A) / 15000-30000 (B)	5 - 8	10 - 12	8 - 10 hours	8 - 13 (HDPE)	120	1	Slow, for polyolefins (PE, PP,...)
	AC5465	THIXO (A) / 15000-30000 (B)	5 - 7	10 - 12	10 - 12 hours	8 - 10 (HDPE)	120	0.50	Polyolefins bonder (PE, PP,...), transparent, 0-gap
	AC5466	THIXO (A) / 10000-20000 (B)	5 - 7	13 - 16	10 - 12 hours	8 - 10 (HDPE)	120	1	Polyolefins bonder (PE, PP,...), no odor
	SUPERLOX	THIXO (A) / 15000-30000 (B)	5 - 7	10 - 12	10 - 12 hours	8 - 10 (HDPE)	120	0.50	Polyolefins bonder (PE, PP,...), transparent, 0-gap
	AC5002	1000-7000 THIXO (A) 1000-7000 (B)	2 - 3	5 - 10	20 - 25	20 - 25	250 - 300	0.50	MMA, pink&green, fluids, toughened, general purpose
	AC5004	80000-120000 THIXO (A) 8000-120000 (B)	1 - 2	5 - 10	20 - 25	18 - 20	45 - 50	3	MMA, specialty, crystal clear, toughened
	AC5007	3000-9000 (A) / 1000-2000 (B)	7 - 10	15 - 20	20 - 30	20 - 30	200 - 250	0.50	MMA, excellent performances on a wide variety of substrates

Polyurethane Adhesives

PRODUCT	VISCOSITY +25°C mPa s	POT LIFE (minutes)	FUNCTIONAL CURE (hours)	SHEAR STRENGTH (ISO 4587) N/mm ²	PEEL STRENGTH (ISO 4587) N/25 mm	JOINT THICKNESS mm	DESCRIPTION
33-26	4000-8000 THIXO (A) / 3000-6000 THIXO (B)	4 - 8	24 - 48	10 - 20	-	-	Fast curing, resistant to water, for rigid materials
33-28	4000-8000 THIXO (A) / 3000-6000 THIXO (B)	15 - 20	24 - 48	10 - 15	-	-	Slow curing, resistant to water, for rigid materials

SURFACE CONDITIONERS AND COMPLEMENTARY PRODUCTS

A good bonding starts from cleaning the parts carefully, in order to allow the adhesive to create chemical and physical conjunctions.

Loxal Cleaners degrease and clean to prepare surfaces before adhesives application. They remove also oxidation caused by air and humidity.

Loxal Removers are designed to remove cured adhesives (Cyanoacrylates and sealants).

Loxal activators allow anaerobic and cyanoacrylate adhesives to cure when environmental and operative conditions are critical.

Loxal Primers are designed to increase the surface energy, optimizing the bond strength to surfaces such as polypropylene, polyethylene, silicone and PTFE with cyanoacrylate adhesives.

SURFACE CONDITIONERS

CATEGORY	PRODUCT	DESCRIPTION
For cyanoacrilates	Primer 7	Primer for Polyolefins, speed up curing and avoid blooming effect
For sealants	Primer 79	For Polyolefins and rubbers
For cyanoacrilates	Activator 9	For difficult and porous surfaces, no-blooming
For cyanoacrilates	Remover CR1	Remover for cured adhesives
For cyanoacrilates	Remover CR2	Remover for cured adhesives, non-flammable
For silicone	Remover CR5	Remover for cured adhesives, low odor, low volatility solvent, also available in gel (CR5 gel)
For anaerobics	Activator 11	Activator, shorten curing time, fixture time about 1 minute
For anaerobics	Activator 17	Activator, for passive surfaces, solvent free, fixture time 1-2 minutes
For anaerobics	Activator 18	Activator, non-flammable, solvent free, odourless, fixture time about 1 minute
For acrylics	Activator 20	Activator, solvent free, fixture time 1-2 minutes
Cleaner	10	Non-CFC solvent based for cleaning, degreasing, fast drying

HOW TO USE:

Apply on one of the two surfaces, wait for evaporation for few seconds. The treated surface remain active but assembling must be made seconds after the application of the Anaerobic Adhesive.



COMPLEMENTARY PRODUCTS

CATEGORY	PRODUCT	APPROVALS	DESCRIPTION
Silicone grease	Grease no 4	Food NSF H1, potable water TZW	Waterproof, lubricant, PTFE based
Silicone grease	Grease no 9	Food NSF H1, potable water TZW	Waterproof, lubricant
Silicone oil	Oil 1000	Potable water WRAS	Anti-adhesive, lubricant for metal plastic and rubber
Silicone oil	Oil 12500	-	High viscosity anti-adhesive, lubricant for metal, plastic and rubber

SILICON GREASE WITH TEFLON NO 4

Combines the slip properties of silicon with the lubricating power of PTFE. Suitable for metal/plastic, metal/rubber, plastic/plastic and in some cases metal/metal combinations. It is not toxic, odorless and tasteless, allowed to use with potable water. Does not allow growth of fungus and moulds even in high humidity and temperature conditions. It is not flammable and has good electrical insulation properties.

SILICON GREASE NO 9

Provides lubricants properties for metal/plastic, metal/rubber and plastic/plastic combinations, also suitable for metal/metal not subjected to high loads. It is not toxic, odorless, tasteless, allowed to use with potable water. Does not allow growth of fungus and moulds even in high humidity conditions. It is not flammable and has good electrical insulation properties.



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ASSEMBLED ACCORDING TO YOUR NEEDS!

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ENGINEERING ADHESIVES

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