

Technical Data Sheet

LOXEAL UV 30-11HH

Description

Loxeal UV 3011HH is a high viscosity adhesive that cures rapidly when exposed to a visible or ultraviolet irradiation of proper intensity. The product is designed to bond PC, ABS, and flexible and rigid PVC and does not rise stress cracking. It form a plastic film very tough and flexible.

Physical properties

Composition :	Urethane acrylate
Colour :	transparent / slightly opaque
Viscosity (+25°C - mPa s) :	8.000 - 10.000
Specific weight (g/ml) :	1,1
Flash point :	> +90°C
Refractive index @ +25°C :	1,473
Shelf life : 12 months at +25°C in original unopened packaging	

Stress cracking

According to ASTM D3929 :

@ 7 N/mm ²	> 15 min
@ 12 N/mm ²	> 4 min

Polymerization features

To obtain the best features, clean and dry parts to bond. The polymerization depends on the UV lamp radiation, on the distance from the lamp, on the thickness of the adhesive applied, on the light permeability of the pieces to bond and on geometry of the joint.

We recommend to use UV lights able to produce UV waves between 365 nm and 420 nm at 100mW/cm².

We recommend to cool the area irradiated with UV lamp while using thermoplastic materials.

Curing time

Substrate	time in seconds
• PVC/PVC rigid	ab. 6
• PVC/PVC flexible	ab. 5
• PC/PC	ab. 45
• PC/ABS	ab. 45
• Plexiglass/Plexiglass	ab. 6
• Glass/Glass	ab. 7

Properties of the polymerized adhesive

Shear strength ISO 4587 (N/mm²) :

PC/PC	> 9 N/mm ² (breaking piece)
PVC/PVC rigid	> 5 N/mm ² (breaking piece)
PVC/PVC flexible	> 2,5 N/mm ² (breaking piece)
PC/ABS	> 7 N/mm ² (breaking piece)
Tensile strength (DIN 53504) :	> 15 N/mm ²
Elongation at break : (DIN 53504) :	80 - 150 %
Hardness (Shore D) :	60 - 70

Sterilization effects :

Loxeal 30-11HH shows excellent feed back after standard sterilization processes under E.T.O. and Gamma Radiations.

Storage

We recommend to store product in a cool and dry place at temperature non exceeding +25°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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