



LOXEAL®

ENGINEERING ADHESIVES

PUT IT ON & GO TO SLEEP



MEDICAL GRADE UV CURING ADHESIVE

LOXEAL 30-27 Series

Technical Data



Overview:

Loxeal® UV 30-127 Series is fast curing, high strength Ultra Violet curing adhesive.

This product is recommended for assembly of medical syringe needles, also may be used for bonding some thermoplastics to glass and metal.

The product is fluorescent to the blue light for visual inspection.

Physical Properties

Adhesive Type:	Acrylic Base
Colour:	Clear
Specific Gravity ((+25°C g/ml):	1.0 – 1.1
Viscosity at +25°C	mPas
• UV 30-27	90 – 150
• UV 30-27P	650 – 750
• UV 30 – 27HV	1500 – 2500
Flash Point, Closed Cup:	> +93°C
Refractive Index @ +25°C:	1.476
Shelf Life: 12 months at 25°C in original unopened packaging	

Curing Properties

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

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

Curing time may vary according to adhesive gap.

Properties of Cured Adhesive

- Tensile Strength (DIN 53504) 15 – 20 N/mm²
- Elongation at Break (DIN 53504) 10 – 50 %
- Hardness Shore D (ASTM D2240) 65 – 80
- Pull Out Force (ISO 7864) Typical Value:
Stainless Steel Needles to PP Hubs
 - Ø 0.25 mm 50 N
 - Ø 0.80 mm 135 N
 - Ø 1.00 mm 140 N

Certificates

- ISO 10993:
- L929 MEM Elution Test – Cytotoxicity
 - Haemolysis
 - intracutaneous Injection Test
 - Kligman Maximum Test
 - Systemic Injection test

Sterilization Effects:

Loxeal 30-27 shown no adverse effect to Gamma Sterilization.

Storage:

We recommend to store this product in a cool and dry place at temperature not exceeding +25°C. To avoid contaminations, do not refill containers with used products. 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, obtain 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 the sale or use of Loxeal products. Loxeal specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits.

Everjoy Industrial Supplies Pte. Ltd.

38 Woodlands Industrial Park E1, #04-11 Singapore 757700

Tel.: +65 6748 3093 Fax: +65 6748 7202 Email: salesmgnt@everjoy.com.sg