



LOXEAL®

ENGINEERING ADHESIVES

PUT IT ON & GO TO SLEEP



MEDICAL GRADE UV CURING ADHESIVE

LOXEAL 30-27

Technical Data



Overview:

Loxeal® UV 30-27 Series is fast curing, high strength Ultra Violet curing adhesive. The product is recommended for the 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 the visual inspection.

Physical Properties

Composition:	Acrylic Base
Colour:	Clear
Viscosity (+25°C – mPas):	
UV 30-27	90 – 150
UV 30-27P	650 – 750
UV 30-27HV	1,500 – 2,500
Specific Weight (g/ml):	1.0 – 1.1
Refractive index @ +25°C	1.476
Flash Point, closed cup:	> +93°C
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 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. Curing time may vary according to adhesive gap.

Properties of Cured Adhesive

Tensile strength (DIN 53504):	15 - 20 N/mm ²
Elongation at break (DIN 53504):	10 - 50 %
Hardness shore D (ASTM D2240):	65 - 80
Pull out force (ISO 7864) typical values:	
Stainless steel needles to PP hubs	
Ø 0.25 mm	50 N
Ø 0.80 mm	135 N
Ø 1.00 mm	140 N

Effects of Sterilization

UV 30-27 adhesive shown no adverse effect to Gamma Sterilization.

Certificates

- ISO 10993 :
- L929 MEM Elution Test - Cytotoxicity
 - Haemolysis
 - Intracutaneous Injection Test
 - Kligman Maximization Test
 - Systemic Injection Test

Storage:

Store the material in a cool and dry place at temperature not 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:

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.

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