DANLUBE A/S
"Så ved du det holder"

Tune Parkvej 5
4030 Tune
Tlf.: +45 70 25 12 80
info@danlube.dk
www.danlube.dk

Cyanoacrylate Adhesives

WEICON Cyanoacrylate Adhesives are coldcuring one-component adhesives, free of solvents. They quickly polymerise by reacting with moisture both on the surfaces to be bonded and from the air, and cure under light pressure.

They will bond within seconds almost all materials to and among each other, such as:

- Metals
- Glass
- Wood
- Natural and synthetic rubber
- Plastics
- Ceramics
- Leather

When using WEICON Cyanoacrylate Adhesives, unlike in the case of welding and soldering, surfaces remain unaltered. No material stress occurs. Thus, more simple and rapid assembly is often possible, and auxiliary fixing devices are not necessary.

The resulting advantages are numerous:

- Enormous time and, therefore, cost savings
- Immediate on-processing of fixed parts possible
- High bond strength up to material fracture
- Clean and optically appealing bondings

WEICON Cyanoacrylate Adhesives provide high structural strength, with a temperature resistance from -50°C *(-58°F)* to up to +140°C *(+284°F)* and good levels of resistance to a lot of chemicals. In many instances, the cured bond joint proves to be harder than the material of the bonded parts (material fracture).

A wide range of product types is available for a variety of applications. The types differ chemically and by their viscosity.

Ethyl ester based types

Due to the size of the molecules and the resulting anchoring points positioned far from each other, a higher elasticity of the bond joint is achieved. These types are recommended for bonding plastics and rubber.

Alkoxy ethyl based types

Also with adhesives on this basis there is flexibility concerning the curing due to the similar molecule structure. However, its particular characteristic is its low odour and, therefore, user-friendly processability especially with assembly line manufacturing.

When cured, they are less sensitive to humidity and should be applied in those instances where the white “blooming” of the bond line is not tolerated for optical reasons.

Methyl ester based types

Due to their small molecule structure and closely positioned anchoring points, these types are less flexible after curing. Therefore, they offer particularly good application possibilities for bonding metals.

Technical product information, a table showing the various different types and basic information on cyanoacrylate adhesives are available on the following pages.

Continuous development and adaptation to the latest demands based on practical experience and the environment guarantee, furthermore, constantly high quality standards.

Bonding of plastics with WEICON Cyanoacrylate Adhesives

Thermoplastics, like for example polystyrene, styrene butadiene, styrene acryl nitrile, polymethylmethacrylate, polycarbonate and polyvinylchloride as well as polyamide, which are most frequently used in industry, can be bonded well with the right WEICON Cyanacrylate Adhesive. With plastics like polyethylene, polypropylene, polyacetal, polytetrafluor ethylene and other fluorite hydrocarbons with their natural adhesive aversive surfaces, an insufficient wetting of the surface takes place, and the adhesive cannot anchor itself to the surface structure. Only if these materials are pretreated with WEICON Contact Primer, their surfaces are activated and therefore able to bond.

Duroplastics like melamine formaldehyde resin, urea formaldehyde resin, epoxy and polyester resins can be bonded well with WEICON Contact; phenal formaldehyde resins, however, can only be bonded under certain conditions. For each type of plastic a specific strength results; that is why test bonding should always be carried out.

Cyanoacrylate Adhesives

Contact Primer for Polyolefines

Without pre-treatment, many plastics are unable to bond or bond only under certain conditions. When these plastics are pre-treated with WEICON Contact Primer, their surface structure changes. Thereby the joining of plastics, like polyethylene (PE) and polypropylene (PP) belonging to the polyolefine group, which are usually difficult to bond, is made possible. Even modern thermoplastic elastomers (TPE), PTFE and related plastics as well as silicones, can be bonded when pre-treated with WEICON Contact Primer.

10 ml ✓ 12450010

100 ml ✓ 12450100

10 ml ✓ 12451010
Pump dispenser

100 ml ✓ 12451100
Pump dispenser

Contact Activator

The Activator speeds up the curing process of WEICON Cyanoacrylate Adhesives. When applied to absorbing surfaces, like for example wood or foam etc., and all chemically-treated surfaces, like for example zinc galvanized metals etc., the activator's effectiveness lasts approx. one minute.

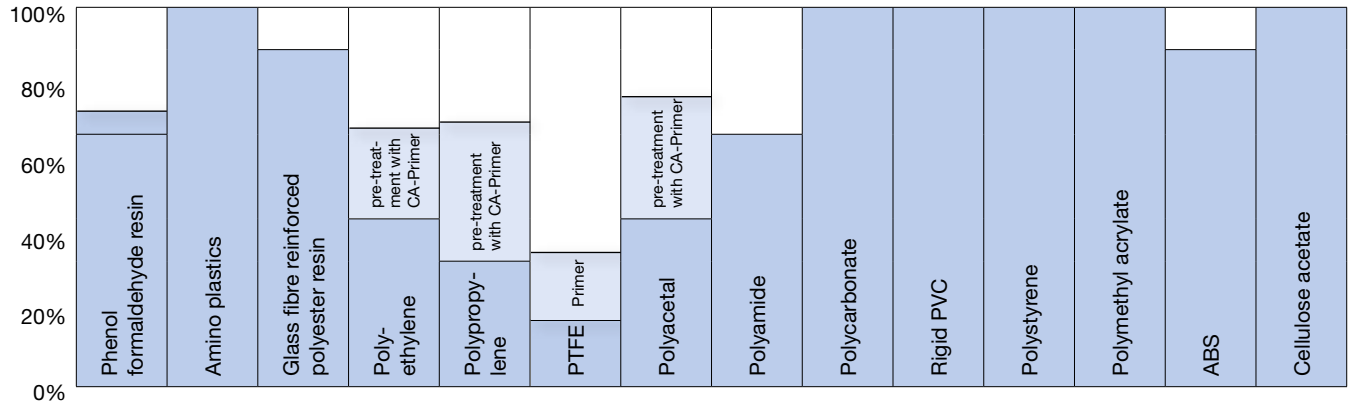
With non-absorbent surfaces the Activator's effectiveness lasts up to approx. 12 hours.

Use is recommendable with:
- Highly viscous WEICON Contact types
- Large thickness of the adhesive layer
- Absorbing and porous surfaces
- Passive materials (alkaline surfaces, like for example zinc coated metal parts).
- Disadvantageous environmental conditions (low temperatures, too low air humidity < 30%)

150 ml ✓ 12500150
CA-Activator Spray

150 ml ✓ 12505150
CA-Activator Spray AC
(based on acetone)

Combined tension and shear resistance



Test spec. DIN 53281:	100 x 25 x 1,5 mm
Adhesive:	WEICON Contact VA 8406
Overlapping:	12 mm
Pre-treatment:	cleaned with WEICON Surface Cleaner and surface made coarse
Bonding:	Normal climate DIN 50014, +23°C *(+73°F)* and 50% rel. air humidity
Test speed:	10 mm/min.

DANLUBE A/S "Så ved du det holder" • Tlf.: +45 70 25 12 80 • info@danlube.dk • www.danlube.dk

General Information

Directions for use

- To ensure a perfect bonding, the surfaces to be joined must be clean and dry (to clean and degrease use e.g. WEICON Surface Cleaner).
- Smooth surfaces should be mechanically roughened.
- Apply WEICON Contact Cyanoacrylate Adhesive only on one of the surfaces to be bonded.
- The bond line should be between 0.05 mm and max. 0.2 mm in thickness. Otherwise complete curing cannot be guaranteed.
- For bonding large surfaces WEICON Contact Cyanoacrylate Adhesive should be applied drop by drop to avoid inner tensions.
- WEICON Contact Cyanoacrylate Adhesives are very economical. One drop is sufficient to cover approx. 3 - 5 cm² of bonded surface.
- The parts to be joined should be bonded in an atmosphere of 40 - 80 % relative humidity. In conditions of below 40%, the cure will be considerably slowed or even inhibited. With a relative air humidity of more than 80% or with basic substrates (e.g. glass), shock-curing can occur. In such cases, some materials show a drop in bond strength of 10 – 15 %, due to inner tensions in the bond line.
- Basic-reacting surfaces (pH-value >7) will speed up the cure whereas acidic-reacting surfaces will retard and, under extreme conditions, completely inhibit the polymerization.

Physiological Properties

Health and safety at work

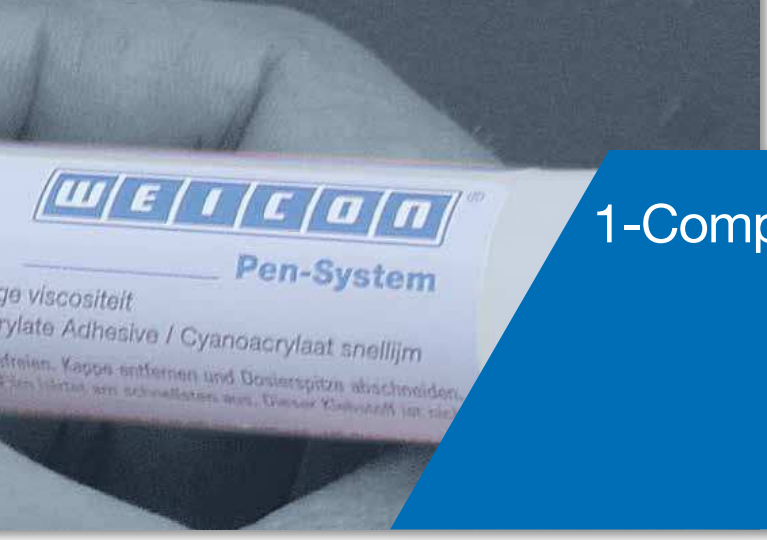
Physiologically, WEICON Cyanoacrylate Adhesives may be considered as essentially harmless. However, ensure sufficient ventilation of workplaces to cope with the adhesive's typical vapours. Vapours of WEICON Contact may cause irritation of the mucous membranes and the eyes. Avoid contact with skin and eyes (wear gloves and protective goggles). The use of WEICON Hand Protective Foam prevents skin irritation and hand cleaning problems

Storage

WEICON Cyanoacrylate Adhesives should always be stored in a cool, dry and dark place. The shelf life is at least 9 months if stored at room temperature (+18/*+64°F* to +25°C/*+77°F*). If stored at +5°C (*+41°F)* (e.g. in a refrigerator), the shelf life can be extended to 12 months.

Conversions

(°C x 1.8) +32 = °F	MPa x 145 = psi
kV/mm x 25.4 = V/mil	MPa x 0.145 = KSI
mm / 25.4 = inches	mPa·s = cP
µm / 25.4 = mil	N·m x 8.851 = lb·in
N x 0.225 = lb	N·m x 0.738 = lb·ft
N/mm x 5.71 = lb/in	N·mm x 0.142 = oz·in
N/mm x 5.71 = pli	kg x 2.2046 = lb
N/mm² x 145 = psi	



1-Component Adhesives and Sealants

Cyanoacrylate Adhesives

Type Selection Table

	VA 20	VA 8312	VA 8406	VA 100	VA 110	VA 1401	VA 300	VA 1500	GEL	VA 5000 THIX	VA 2500 HT	VA 30 Black	VA 250 Black	VA 1408	VA 1460	VA 1403	VM 20	VM 120	VM 2000
Metal	+	+	+	++	+	++	+	+	+	+	+	+	+	+	+	+	++	++	++
Plastic*	++	++	++	++	++	++	++	++	+	+	++	++	++	++	++	++	+	+	+
Rubber	++	++	++	++	++	++	+	++	+	+	++	++	++	++	++	+	+	+	+
EPDM Elastomers	+	+	++	+	+	++	+	+		+	+	+	+	+	+	+			
Wood	+			+	+	+	++	+	+	+	+	+	+	+		++			
Balsa-wood		+	+	+	+	+	+	+	++	+	+	+	+	+		++			
Glass / Ceramic	+		+	++	+	++	++	+	++	+	+	+	+	++	+	+			
Leather		+		++	+	++	++	++	++	+	+	+	+	+	+	++			

suitable (+) highly suitable (++)

VA 20

Cyanoacrylate Adhesive for rubber and plastics
low viscosity • very fast curing

ISEGA
Certificate of Conformity as an adhesive in food technology.

WEICON Contact VA 20 has low viscosity (< 20 mPa•s) and hardens very quickly.

VA 20 is suited for the bonding of rubber and plastics and also for precisely fitted metal/ plastic joints.

12 g	30 g	60 g
12000012	12000030	12000060

500 g
12000500

Technical Data

Ester type	Ethyl
Condition / nature	colourless, clear liquid
Viscosity at +20°C *(+68°F)* Brookfield	< 20 mPa·s
Max. gap covering	0,1 mm
Initial adhesion on aluminium	30 - 60 sec.
Initial adhesion on Nora test rubber	2 - 15 sec.
Initial adhesion on Rigid PVC	5 - 60 sec.
Final strength after	24 h
Temperature resistance	-50 to approx. +80°C *(-58 to approx. +176°F)* (briefly to +100°C/*+212°F*) squatting temp. +150°C *(+302°F)*

VA 100

Cyanoacrylate Adhesive for rubber and plastics
medium viscosity • slightly longer curing

WEICON Contact VA 100 is a universal type for the bonding of metals, plastic and rubber, both to and among each other.

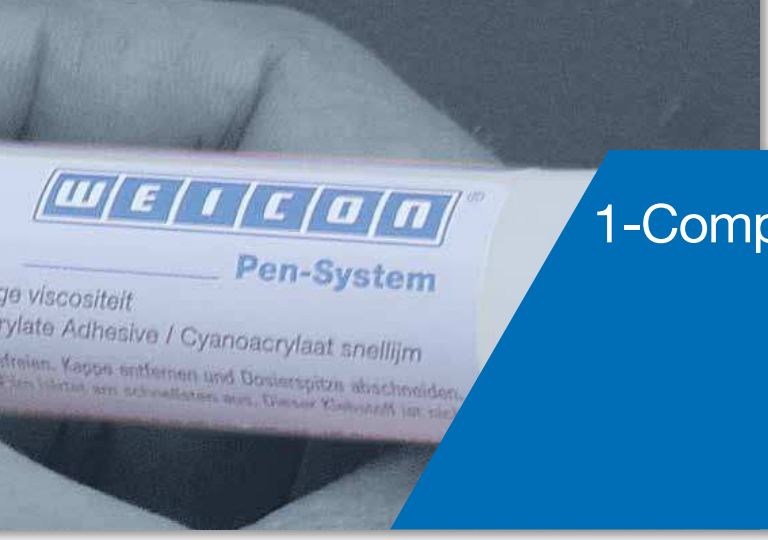
VA 100 is ideal for the „do-it-yourself“ area, but can also be used in many areas of industry.

3 g	12 g	30 g
12050001	12050012	12050030

60 g	500 g
12050060	12050500

Technical Data

Ester type	Ethyl
Condition / nature	colourless, clear liquid
Viscosity at +20°C *(+68°F)* Brookfield	60 - 120 mPa·s
Max. gap covering	0,15 mm
Initial adhesion on aluminium	30 - 60 sec.
Initial adhesion on Nora test rubber	3 - 20 sec.
Initial adhesion on Rigid PVC	10 - 60 sec.
Final strength after	24 h
Temperature resistance	-50 to approx. +80°C *(-58 to approx. +176°F)* (briefly to +100°C/*+212°F*) squatting temp. +150°C *(+302°F)*



1-Component Adhesives and Sealants

Cyanoacrylate Adhesives

ISEGA

Certificate of Conformity as an adhesive in food technology.

VA 8312

Cyanoacrylate Adhesive for rubber and plastics
low viscosity • very fast-curing • ISEGA-certified

WEICON Contact VA 8312 has low viscosity (20-40 mPa•s) and hardens very quickly. VA 8312 is suited for the bonding of various rubber materials such as solid rubber or cellular rubber, plastics and EDPM elastomers.

In combination with WEICON CA-Primer, VA 8312 can also be used for polyolefines (PE-polyethylene, PP-polypropylene). In combination with WEICON Contact Filler*, VA 8312 is suited for the instant bonding and filling of cracks, clefts, holes and uneven surfaces.

12 g	30 g	60 g	500 g
12200012	12200030	12200060	12200500

Technical Data

Ester type	Ethyl
Condition / nature	colourless, clear liquid
Viscosity at +20°C *(+68°F)* Brookfield	20 - 40 mPa·s
Max. gap covering	0,1 mm
Initial adhesion on aluminium	30 - 60 sec.
Initial adhesion on Nora test rubber	2 - 10 sec.
Initial adhesion on Rigid PVC	5 - 30 sec.
Final strength after	24 h
Temperature resistance	-50 to approx. +80°C *(-58 to approx. +176°F)* (briefly to +100°C/*+212°F*) squatting temp. +150°C *(+302°F)*

VA 5000 THIX

Cyanoacrylate Adhesive for rubber and plastics
high viscosity (thixotrop) • longer cure

For porous and absorbing materials and larger tolerances. Suitable for metals, plastics, and rubber, even on vertical surfaces.

12 g	30 g	60 g	500 g
12551012	12551030	12551060	12551500

Technical Data

Ester type	Ethyl
Condition / nature	colourless, clear liquid
Viscosity at +20°C *(+68°F)* Brookfield	approx. 25.000 mPa·s
Max. gap covering	0,2 mm
Initial adhesion on aluminium	30 - 70 sec.
Initial adhesion on Nora test rubber	5 - 10 sec.
Initial adhesion on Rigid PVC	25 - 50 sec.
Final strength after	24 h
Temperature resistance	-50 to approx. +90°C

*

WEICON Contact Filler

Fillers for instant bonding and filling-in of clefts and cracks, holes as well as unlevelled surfaces in conjunction with WEICON Contact Adhesive VA 8312.

Contact Filler should be applied in layers:

Adhesive - Filler - Adhesive

After curing is completed, the material can be sanded and overpainted.

30 g
12650030

VA 8406

Cyanoacrylate Adhesive for rubber and plastics low viscosity • very fast-curing

WEICON Contact VA 8406 has low viscosity (20-50 mPa•s) and hardens very quickly. It is suited for the fast fixing and bonding of various rubber materials such as solid rubber or cellular rubber, plastics and EPDM elastomers requiring quick fixing.

In combination with WEICON CA-Primer, VA 8406 can also be used for polyolefines (PE-polyethylene, PP-polypropylene) and for PTFE and silicones.

Technical Data

Ester type	Ethyl
Condition / nature	colourless, clear liquid
Viscosity at +20°C *(+68°F)* Brookfield	20 - 50 mPa·s
Max. gap covering	0,1 mm
Initial adhesion on aluminium	2 - 10 sec.
Initial adhesion on Nora test rubber	< 5 sec.
Initial adhesion on Rigid PVC	2 - 10 sec.
Final strength after	24 h
Temperature resistance	-50 to approx. +80°C *(-58 to approx. +176°F)* (briefly to +100°C/*+212°F*) squatting temp. +150°C *(+302°F)*

12 g	30 g	60 g	500 g
12204012	12204030	12204060	12204500

VA 1401

Cyanoacrylate Adhesive for rubber and plastics medium viscosity • fast-curing

WEICON Contact VA 1401 has medium viscosity (100-150 mPa•s) and hardens quickly. It shows good results on fabric, paper, cardboard, cartons, foam rubber and large-pored elastomers.

VA 1401 is a universal type for the bonding of metals, plastics and rubber, both to themselves and among each other.

12 g	30 g	60 g
12054012	12054030	12054060

500 g
12054500

Technical Data

Ester type	Ethyl
Condition / nature	colourless, clear liquid
Viscosity at +20°C *(+68°F)* Brookfield	100 - 150 mPa·s
Max. gap covering	0,15 mm
Initial adhesion on aluminium	2 - 10 sec.
Initial adhesion on Nora test rubber	< 5 sec.
Initial adhesion on Rigid PVC	2 - 10 sec.
Final strength after	24 h
Temperature resistance	-50 to approx. +120°C *(-58 to approx. +248°F)* (briefly to +150°C/*+302°F*) squatting temp. +170°C *(+338°F)*

1-Component Adhesives and Sealants

Cyanoacrylate Adhesives

VA 300

Cyanoacrylate Adhesive for rubber and plastics
higher viscosity • longer curing

WEICON Contact VA 300 has a higher viscosity (200-300 mPa•s) and a longer curing time. It is particularly suited for absorbent and porous products such as wood, cork, leather and ceramics.

VA 300 is also suited for the bonding of metals, plastics and rubber, both to themselves and among each other.

12 g	30 g	60 g
12100012	12100030	12100060

500 g
12100500

Technical Data

Ester type	Ethyl
Condition / nature	colourless, clear liquid
Viscosity at +20°C *(+68°F)* Brookfield	200 - 300 mPa·s
Max. gap covering	0,15 mm
Initial adhesion on aluminium	60 - 90 sec.
Initial adhesion on Nora test rubber	2 - 10 sec.
Initial adhesion on Rigid PVC	10 - 60 sec.
Final strength after	24 h
Temperature resistance	-50 to approx. +80°C *(-58 to approx. +176°F)* (briefly to +100°C/*+212°F*) squatting temp. +150°C *(+302°F)*

VA 1500

Cyanoacrylate Adhesive for rubber and plastics
high viscosity • slow-curing

WEICON Contact VA 1500 is highly viscous (1000-1500 mPa•s) and has a slower curing time. The product is suited for the bonding of rubber and plastics and can also be used on absorbent and porous materials such as wood, cork, leather and ceramics.

12 g	30 g	60 g
12150012	12150030	12150060

500 g
12150500

Technical Data

Ester type	Ethyl
Condition / nature	colourless, clear liquid
Viscosity at +20°C *(+68°F)* Brookfield	1.000 - 1.500 mPa•s
Max. gap covering	0,2 mm
Initial adhesion on aluminium	90 - 120 sec.
Initial adhesion on Nora test rubber	5 - 30 sec.
Initial adhesion on Rigid PVC	10 - 120 sec.
Final strength after	24 h
Temperature resistance	-50 to approx. +80°C *(-58 to approx. +176°F)* (briefly to +100°C/*+212°F*) squatting temp. +150°C *(+302°F)*

VM 20

Cyanoacrylate Adhesive for metals
low viscosity • very fast-curing

WEICON Contact VM 20 has a low viscosity (20-40 mPa•s) and hardens very quickly. It is suited for all types of metal bonds, especially for the bonding of precisely fitted parts in serial production.

VM 20 can be used in the metalworking industry, in machine construction, in housing and apparatus engineering and in many other applications.

30 g	60 g	500 g
12300030	12300060	12300500

Technical Data

Ester type	Methyl
Condition / nature	colourless, clear liquid
Viscosity at +20°C *(+68°F)* Brookfield	20 - 40 mPa·s
Max. gap covering	0,1 mm
Initial adhesion on aluminium	50 - 70 sec.
Initial adhesion on Nora test rubber	10 - 60 sec.
Initial adhesion on Rigid PVC	30 - 120 sec.
Final strength after	24 h
Temperature resistance	-50 to approx. +80°C *(-58 to approx. +176°F)* (briefly to +100°C/*+212°F*) squatting temp. +150°C *(+302°F)*

VM 120

Cyanoacrylate Adhesive for metals
medium viscosity • slower curing, a short-term realignment of parts is possible

WEICON Contact VM 120 has a medium viscosity (100-130 mPa•s) and a longer curing time allowing short-term position corrections of the parts to be bonded.

WEICON Contact VM 120 is suited for all types of metal bonds.

WEICON Contact VM 120 can be used in the metalworking industry, in machine construction, in housing and apparatus engineering and in many other applications.

30 g	60 g	500 g
12350030	12350060	12350500

Technical Data

Ester type	Methyl
Condition / nature	colourless, clear liquid
Viscosity at +20°C *(+68°F)* Brookfield	100 - 130 mPa·s
Max. gap covering	0,15 mm
Initial adhesion on aluminium	50 - 70 sec.
Initial adhesion on Nora test rubber	10 - 60 sec.
Initial adhesion on Rigid PVC	30 - 120 sec.
Final strength after	24 h
Temperature resistance	-50 to approx. +80°C *(-58 to approx. +176°F)* (briefly to +100°C/*+212°F*) squatting temp. +150°C *(+302°F)*

500 g bottle

1-Component Adhesives and Sealants

Cyanoacrylate Adhesives

VM 2000

Cyanoacrylate Adhesive for metals
high viscosity • slow-curing, allows realignment of parts

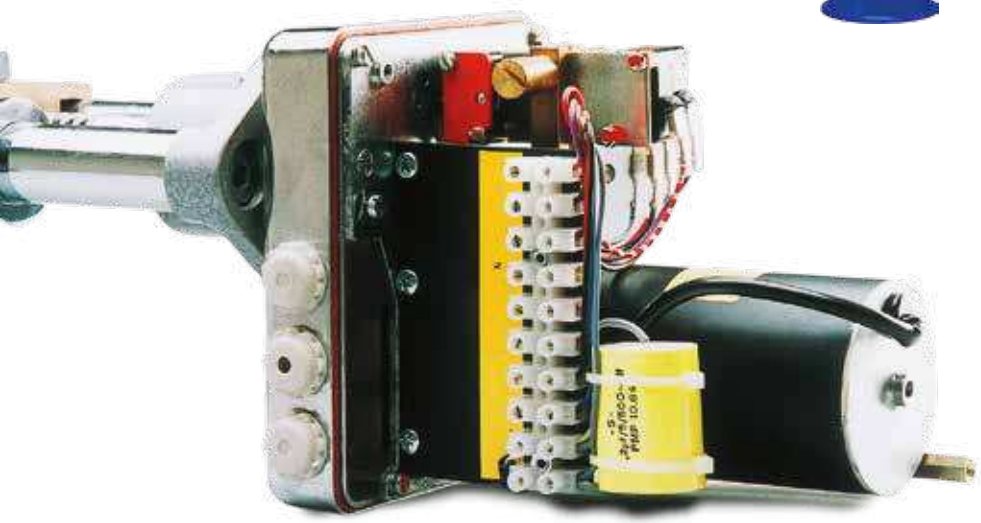
Technical Data

Ester type	Methyl
Condition / nature	colourless, clear liquid
Viscosity at +20°C *(+68°F)* Brookfield	1.700 - 2.000 mPa·s
Max. gap covering	0,2 mm
Initial adhesion on aluminium	70 - 90 sec.
Initial adhesion on Nora test rubber	10 - 90 sec.
Initial adhesion on Rigid PVC	30 - 150 sec.
Final strength after	24 h
Temperature resistance	-50 to approx. +80°C *(-58 to approx. +176°F)* (briefly to +100°C/*+212°F*) squatting temp. +150°C *(+302°F)*

WEICON Contact VM 2000 is highly viscous (1700-2000 mPa•s) and hardens slowly, which enables position correction of the parts to be bonded.

VM 2000 is suited for all types of metal bonds and can also be used on absorbent and porous products.

30 g	60 g	500 g
12400030	12400060	12400500



VA 2500 HT

Cyanoacrylate Adhesive for special requirements • high temperature resistant
high viscosity • slow-curing • residual elasticity after curing • high peel and impact resistance

WEICON Contact VA 2500 HT is highly viscous (2000-3000 mPa•s) and temperature resistant between -50°C *(-58°F)* and +140°C *(+284°F)*. It hardens slowly with residual elasticity and has high peel and impact strength. Thanks to its curing with residual elasticity, WEICON Contact VA 2500 HT is particularly suitable under changing climatic conditions. It is insensitive even under a longer influence of humidity. VA 2500 HT is suited for the bonding of the most diverse rubber materials and plastics and also for metal/plastic joints.

Technical Data

Ester type	Ethyl
Condition / nature	opaque
Viscosity at +20°C *(+68°F)* Brookfield	2.000 - 3.000 mPa·s
Max. gap covering	0,2 mm
Initial adhesion on aluminium	40 - 80 sec.
Initial adhesion on Nora test rubber	25 - 60 sec.
Initial adhesion on Rigid PVC	25 - 100 sec.
Final strength after	24 h
Temperature resistance	-55 to +140°C *(-67 to + 284°F)* squatting temp. +160°C *(+320°F)*

12 g	30 g	60 g	500 g
12550012	12550030	12550060	12550500

VA 30 Black

Cyanoacrylate Adhesive for special requirements • rubber-filled • high temperature resistant
medium viscosity • longer curing • residual elasticity after curing • high peel and impact resistance

WEICON Contact VA 30 Black has medium viscosity (300 mPa•s) and is temperature resistant between -50°C *(-58°F)* and +140°C *(+284°F)*. It has a longer curing time, is rubber-filled and black, hardens with residual elasticity and has high peel and impact strength. Thanks to its curing with residual elasticity, WEICON Contact VA 30 Black is particularly suitable under changing climatic conditions. It is insensitive even under a longer influence of humidity.

VA 30 Black is ideally suited for the bonding of diverse rubber materials such as solid rubber or cellular rubber, plastics and metal/plastic joints.

Technical Data

Ester type	Ethylester
Condition / nature	black
Viscosity at +20°C *(+68°F)* Brookfield	250 - 300 mPa·s
Max. gap covering	0,2 mm
Initial adhesion on aluminium	40 - 50 sec.
Initial adhesion on Nora test rubber	5 - 10 sec.
Initial adhesion on Rigid PVC	5 - 10 sec.
Final strength after	24 h
Temperature resistance	-55 to +140°C *(-67 to + 284°F)* squatting temp. +160°C *(+320°F)*

12 g	30 g	60 g	500 g
12603012	12603030	12603060	12603500

Cyanoacrylate Adhesives

VA 250 Black

Cyanoacrylate Adhesive for special requirements • rubber-filled • high temperature resistant high viscosity • slow-curing • residual elasticity after curing • high peel and impact resistance

Technical Data

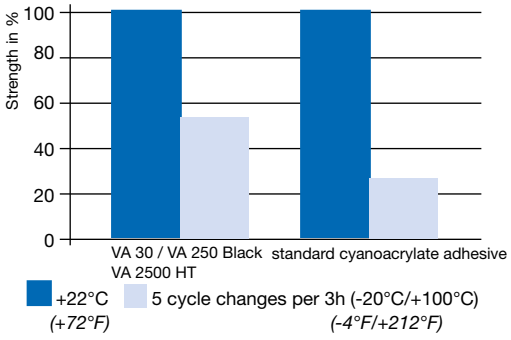
Ester type	Ethyl
Condition / nature	black
Viscosity at +20°C *(+68°F)* Brookfield	2.000 - 3.000 mPa·s
Max. gap covering	0,2 mm
Initial adhesion on aluminium	90 - 120 sec.
Initial adhesion on Nora test rubber	20 - 40 sec.
Initial adhesion on Rigid PVC	40 - 80 sec.
Final strength after	24 h
Temperature resistance	-55 to +140°C *(-67 to + 284°F)* squatting temp. +160°C *(+320°F)*

12 g	30 g	60 g	500 g
12600012	12600030	12600060	12600500

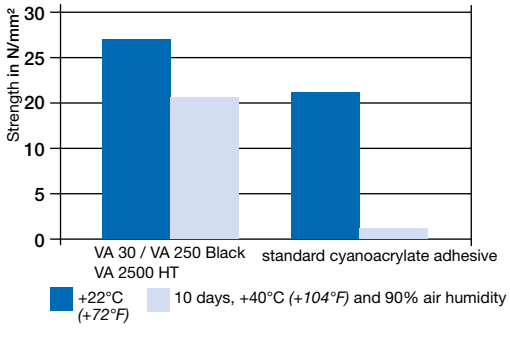
VA 250 Black is highly viscous (2000-3000 mPa•s) and temperature resistant between -50°C *(-58°F)* and +140°C *(+284°F)*. It hardens slowly and with residual elasticity, is rubber-filled and black, and has high peel and impact strength.

Thanks to its curing with residual elasticity, WEICON Contact VA 250 Black is particularly suitable under changing climatic conditions. It is insensitive even under a longer influence of humidity. It is best suited for the bonding of diverse rubber materials such as solid rubber or cellular rubber, plastics and metal/ plastic joints.

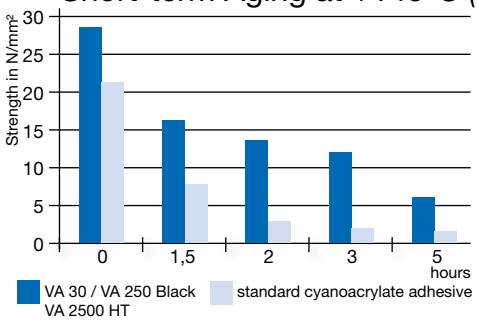
Temperature Change Load



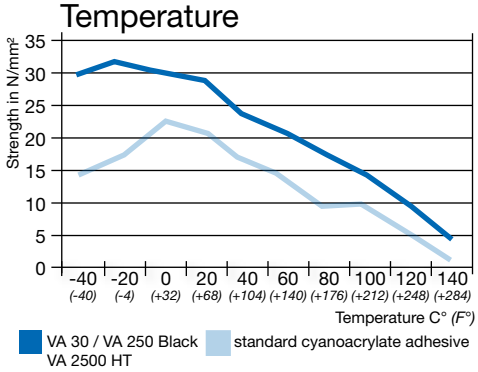
Humid Climate Resistance



Short-term Aging at +140°C *(+284°F)*



Strength Dependent on Temperature



VA 1408

Cyanoacrylate Adhesive for special requirements
low viscosity • very fast-curing • low odour and "blooming"

WEICON Contact VA 1408 has a low viscosity (20-40 mPa•s) and a reduced "blooming" effect. It hardens quickly, is low in odour when processing and less susceptible to moisture effects after curing. The product is suited for the clean and visually attractive bonding of the most diverse products.

Technical Data

Ester type	Alkoxy
Condition / nature	colourless, clear liquid
Viscosity at +20°C *(+68°F)* Brookfield	20 - 40 mPa·s
Max. gap covering	0,1 mm
Initial adhesion on aluminium	30 - 60 sec.
Initial adhesion on Nora test rubber	3 - 20 sec.
Initial adhesion on Rigid PVC	10 - 30 sec.
Final strength after	24 h
Temperature resistance	-50 to +80°C *(-58 to + 176°F)* squatting temp. +150°C *(+302°F)*

30 g ✓	60 g ✓	500 g ✓
12253030	12253060	12253500

VA 1460

Cyanoacrylate Adhesive for special requirements
medium viscosity • longer curing • low odour and "blooming"

VA 1460 has a medium viscosity (120-200 mPa•s) and a reduced "blooming" effect. It hardens less quickly, is low in odour when processing and less susceptible to moisture effects after curing.

WEICON Contact VA 1460 is suited for the bonding of the most diverse products. The product can be used in numerous industrial applications.

30 g ✓	60 g ✓	500 g ✓
12250030	12250060	12250500

Technical Data

Ester type	Alkoxy
Condition / nature	colourless, clear liquid
Viscosity at +20°C *(+68°F)* Brookfield	120 - 200 mPa·s
Max. gap covering	0,15 mm
Initial adhesion on aluminium	30 - 60 sec.
Initial adhesion on Nora test rubber	10 - 60 sec.
Initial adhesion on Rigid PVC	20 - 150 sec.
Final strength after	24 h
Temperature resistance	-50 to +80°C *(-58 to + 176°F)* squatting temp. +150°C *(+302°F)*

Cyanoacrylate Adhesives

VA 1403

Cyanoacrylate Adhesive for special requirements
high viscosity • slow-curing • low odour and “blooming”

Technical Data

Ester type	Alkoxy
Condition / nature	colourless, clear liquid
Viscosity at +20°C *(+68°F)* Brookfield	1.100 - 1.800 mPa·s
Max. gap covering	0,2 mm
Initial adhesion on aluminium	90 - 120 sec.
Initial adhesion on Nora test rubber	5 - 30 sec.
Initial adhesion on Rigid PVC	10 - 120 sec.
Final strength after	24 h
Temperature resistance	-50 to +80°C *(-58 to + 176°F)* squatting temp. +150°C *(+302°F)*

WEICON Contact VA 1403 is highly viscous (1100-1800 mPa•s), low in odour when processing and has a reduced “blooming” effect. It hardens slowly and is less susceptible to moisture effects after curing.

VA 1403 is suited for the clean and visually attractive bonding of the most diverse products.

30 g	60 g	500 g
12252030	12252060	12252500


Pen-System
WEICON®
Design Pat. 00159884

1-Component Adhesives and Sealants

Cyanoacrylate Adhesives

NSF Certified to NSF/ANSI 61 — Clearance certificate for the direct use in the food industry, according to the NSF/ANSI (Standard 61)

VA 110

Cyanoacrylate Adhesive for rubber and plastics
medium viscosity • slightly longer cure

Technical Data

Ester type	Ethyl
Condition / nature	colourless, clear liquid
Viscosity at +20°C *(+68°F)* Brookfield	70 - 110 mPa·s
Max. gap covering	0,15 mm
Initial adhesion on aluminium	20 - 50 sec.
Initial adhesion on Nora test rubber	3 - 15 sec.
Initial adhesion on Rigid PVC	10 - 50 sec.
Final strength after	24 h
Temperature resistance	-30 *(-22°F)* to approx. +80°C *(+176°F)* squatting temp. +160°C *(+320°F)*

The special feature of the product is its NSF approval in accordance with ANSI Standard 61 - Drinking Water System Components. Thus, VA 110 also meets the highest standards and can be used in sensitive areas such as in the pharmaceutical industry, in the manufacturing of cosmetics, in the food industry, in the manufacturing of toys or jewelry industry.

12 g	30 g	60 g
12052012	12052030	12052060

500 g
12052500

Contact GEL

Cyanoacrylate Adhesive for special requirements
pasty (highly thixotropic) • very slow-curing = position correction

Technical Data

Ester type	Ethyl
Condition / nature	colourless, clear liquid
Viscosity bei +25 °C *(+77°F)* in Brookfield	60.000 - 90.000 mPa·s
Max. gap covering	0,2 mm
Initial adhesion on aluminium	90 - 120 sec.
Initial adhesion on Nora test rubber	20 - 30 sec.
Initial adhesion on Rigid PVC	40 - 80 sec.
Final strength after	24 h
Temperature resistance	-50 to +80°C *(-58 to + 176°F)* squatting temp. +150°C *(+302°F)*

20 g tube

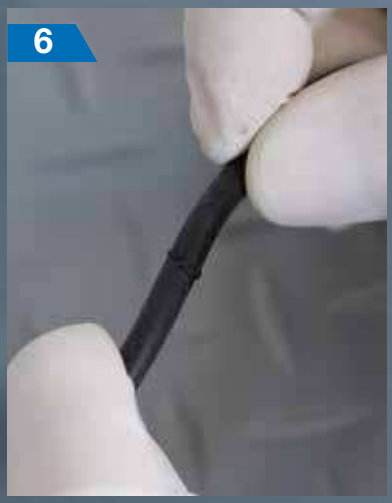
Contact Gel is pasty (highly thixotropic; 60000-90000 mPa•s) and hardens very slowly. By using WEICON Activator Spray, the cure time can be reduced.

WEICON Contact Gel is suited for porous surfaces and higher tolerance gaps and can be used on vertical surfaces. Positioning is also possible after the parts have been joined.

WEICON Contact Gel is suited for the bonding of the most diverse products.

WEICON Contact Gel can be used both in the hobby sector and in model building. It can also be used in many different industrial applications.

20 g	30 g
12500120	12500130



1. Cut sealing material to size with the WEICON Safety Knife.

2. Prior to adhesion of the sealing materials clean with WEICON Surface Cleaner and leave to dry.
Surface Cleaner evaporates completely without residue.

3. Pre-treat round cord made of silicone prior to adhesion with WEICON Contact Primer. To do this, brush a thin layer onto the surfaces to be bonded and leave to dry for 2 minutes.

4. Cut off the dosing tip with the WEICON Safety Knife.

5. Apply adhesive to one side.

6. Join the two ends of the sealing materials to fit and affix under slight pressure.

New

For special requirements

O-Ring Bonding Set

WEICON O-Ring Bonding Set

Using the WEICON O-Ring Bonding Set, sealing rings out of all common materials can be produced in no time.

Set ✓
12508030

WEICON O-Ring Bonding Set consists of:

12603012 **Contact VA 30 Black** 12 g
11207150 **Surface Cleaner** 150 ml
12450010 **Contact Primer** 10 ml
13250000 **WEICON Safety Knife**

Technical Data

WEICON Contact in liquid form

		VA 20	VA 8312	VA 8406	VA 100	VA 110	VA 1401	VA 300	VA 1500	GEL	VA 5000 THIX	VA 2500 HT	VA 30 Black	VA 250 Black	VA 1408	VA 1460	VA 1403	VM 20	VM 120	VM 2000
Ester type		Ethyl													Alkoxy			Methyl		
Condition / nature		colourless, clear liquid, VA 2500 HT opaque, VA 30 Black and VA 250 Black																		
Properties		particularly suitable for rubber and plastic bonding								pasty		particularly suitable for rubber and plastic bonding			low odour, low blooming			particularly suitable for bonding metals		
Viscosity at +20°C *(+68°F)* (m.Pas.) Brookfield		< 20	20-40	20-50	60-120	70-110	100-150	200-300	1000-1500	60000-90000	20000-30000	2000-3000	250-300	2000-3000	20-40	120-200	1100-1800	20-40	100-130	1700-2000
Max. gap covering in mm **		0,10	0,10	0,10	0,15	0,15	0,15	0,15	0,20	0,20	0,20	0,20	0,20	0,20	0,10	0,15	0,20	0,10	0,15	0,20
Specific gravity at +20°C *(+68°F)* (g/cm³)		1,04	1,05	1,05	1,06	1,06	1,06	1,07	1,08	1,08	1,05	1,06	1,06	1,06	1,06	1,02	1,10	1,10	1,10	1,12
Flash point acc. to Abel-Pensky DIN 55213 in °C		87°C *(+189°F)*																		
Initial adhesion* in seconds	Aluminium [1]	30-60	30-60	2-10	30-60	20-50	2-10	60-90	90-120	90-120	30-70	40-80	40-50	90-120	30-60	30-60	90-120	50-70	50-70	70-90
	Nora Test rubber [2]	2-15	2-10	< 5	3-20	3-15	< 5	2-10	5-30	20-30	5-10	25-60	5-10	20-40	3-20	10-60	5-30	10-60	10-60	10-90
	Rigid PVC [3]	5-60	5-30	2-10	10-60	10-50	2-10	10-60	10-120	40-80	25-50	25-100	5-10	40-80	10-30	20-150	10-120	30-120	30-120	30-150
Final strength in hours		24																		

1-Component Adhesives and Sealants

Cyanoacrylate Adhesives

Technical Data

WEICON Contact in cured state

		VA 20	VA 8312	VA 8406	VA 100	VA 110	VA 1401	VA 300	VA 1500	GEL	VA 5000 THIX	VA 2500 HT	VA 30 Black	VA 250 Black	VA 1408	VA 1460	VA 1403	VM 20	VM 120	VM 2000
Shear strength in N/mm² according to DIN 53283 (ASTM D 1002 psi)	Sand-blasted Steel	19 *(2.750)*	20 *(2.900)*	22 *(3.200)*	20 *(2.900)*	20 *(2.900)*	22 *(3.200)*	21 *(3.050)*			22 *(3.200)*	24 *(3.450)*	22 *(3.200)*	24 *(3.450)*	18 *(2.600)*			25 *(3.600)*		
	Sand-blasted Aluminium	14 *(2.050)*	14 *(2.050)*	16 *(2.300)*	15 *(2.175)*	15 *(2.175)*	16 *(2.300)*	15 *(2.175)*			18 *(2.600)*	18 *(2.600)*	18 *(2.600)*	18 *(2.600)*	12 *(1.750)*			19 *(2.750)*		
	Rigid PVC	12 *(1.750)*	13 *(1.900)*	14 *(2.050)*	13 *(1.900)*	13 *(1.900)*	14 *(2.050)*	13 *(1.900)*			12 *(1.750)*	13 *(1.900)*	14 *(2.050)*	13 *(1.900)*	7 *(1.000)*			12 *(1.750)*		
	ABS	11 *(1.600)*	12 *(1.750)*	13 *(1.900)*	12 *(1.750)*	12 *(1.750)*	13 *(1.900)*	12 *(1.750)*			10 *(1.450)*	12 *(1.750)*	11 *(1.600)*	12 *(1.750)*	10 *(1.450)*			11 *(1.600)*		
	PC	12 *(1.750)*	13 *(1.900)*	13 *(1.900)*	13 *(1.900)*	13 *(1.900)*	13 *(1.900)*	12 *(1.750)*			12 *(1.750)*	13 *(1.900)*	13 *(1.900)*	13 *(1.900)*	8 *(1.150)*			12 *(1.750)*		
	NBR	> 8 *(1.150)* (bonding exceeds strength of substrate)																		
Temperature resistance		-50 to +80°C *(-58 to +176°F)* (briefly to +100°C/*+212°F*)					-50 to +120°C *(-58 to +302°F)* (briefly to +150°C/*302°F*)	-50 to +80°C *(-58 to +176°F)* (briefly to +100°C/*+212°F*)			-50 to +90°C *(-58 to +194°F)*	-55 to +140°C *(-67 to +284°F)*			-50 to +80°C *(-58 to +176°F)* (briefly to +100°C/*+212°F*)					
Squatting temperature		+150°C *(302°F)*					+170°C *(338°F)*	+150°C *(302°F)*			-	+160°C *(320°F)*			+150°C *(302°F)*					
Refractive index n^{D20}		1.49 (similar to glass) / for types VA 2500 HT, VA 30 Black and VA 250 Black not applicable																		
Linear thermal expansion coefficient ISO 11359 / ASTM D 696 (K^{-1})		80×10^{-6}																		
Specific forward resistance DIN 53482* / ASTM D 257 (Ω mm)		$> 10^{15}$																		
Dielectric strength, DIN 53481* / ASTM D 149 (KV/mm)		25																		
Thermal conductivity ISO 8894-2 / ASTM C 177 (W/m•K)		0,1																		
Solubility		Dimethyl formamide, dimethyl sulfoxide, acetonitrile, alkali. Swelling is possible after long-time storage in ethyl acetate, acetone and methylene chloride.																		

*Achieved in normal climate DIN 50014 +23°C *(+73°F)* and 50% relative air humidity.
Within the given time period, handling strength can be reached.
** These details are dependent on the type of material to be bonded and its properties
*** Following the DIN-norm measured on bonding joints.

1) Aluminium. Type Al Cu Mg 2pl., not pre-treated
2) NBR-rubber, smoothed
3) Rigid PVC Trovidur® EN, not pre-treated