

# WEICON Contact VM 20 Cyanoacrylate Adhesive

## Contact Cyanoacrylate Adhesives



### Cyanoacrylate adhesive for metals | low viscosity | very fast curing

WEICON Contact VM 20 is suited for all types of metal bonds, especially for the bonding of precisely fitted parts in serial production. Contact VM 20 can be used in the metalworking industry, in machine construction, in housing and apparatus engineering and in many other applications.

#### Technische Daten

Base		methy
Texture		colourless, clear substance
Gap bridging up to max.		0,1 mm
Initial adhesion on aluminium		50 -70 sec.
Initial adhesion on NBR rubber		10 -60 sec.
Initial adhesion on rigid PVC		30 -120 sec.
Final strength (100 % strength)		24 h
Steel sandblasted	DIN EN 1465	25 N/mm <sup>2</sup>
Aluminium sandblasted	DIN EN 1465	19 N/mm <sup>2</sup>
Rigid PVC	DIN EN 1465	12 N/mm <sup>2</sup>
ABS	DIN EN 1465	11 N/mm <sup>2</sup>
NBR	DIN EN 1465	> 8 N/mm <sup>2</sup>
Temperature resistance		-50 °C to briefly +80 °C Up to +100°C / softening temp. +150°C
ISSA Code		75.530.15
IMPA Code		812967

### Surface pre-treatment

For a flawless adhesive bond, surfaces must be clean and dry (clean and degrease with WEICON Surface Cleaner). Smooth surfaces should be roughened mechanically. To improve the adhesion of plastics difficult to bond (e.g. PE, PP, POM, PTFE), thermoplastic elastomers (TPE) and silicones, WEICON CA-Primer can be applied to the bonding surface.

### Processing

- Apply WEICON Contact Cyanoacrylate Adhesive to just one of the bonding surfaces.

- The layer thickness when applying the adhesive should be between min. 0.05 and max. 0.2 mm (depending on the type), as otherwise complete curing cannot be guaranteed.

- For large-surface bondings, WEICON Contact Cyanoacrylate Adhesives should be applied in dots in order to prevent inner tensions.

- WEICON Contact Cyanoacrylate Adhesives are very economical. One drop covers approx. 3 to 5 cm<sup>2</sup> bonding surface.

- The components should be bonded at a relative air humidity level between 40% and 80%. Below 40 %, the curing process is slowed down significantly or even prevented altogether. At an air humidity level above 80 % or with strongly basic substrates (e.g. glasses), the risk of shock-curing occurs. In these cases, certain materials show a drop in strength by 10 % to 15 % due to tensions in the adhesive layer.

- Alkaline surfaces (pH value >7) accelerate the curing process, acidic surfaces (pH value <7) slow down the curing process and can prevent polymerisation altogether in extreme cases.

### Storage

WEICON Contact Cyanoacrylate Adhesives have a shelf life of at least 9 months, when stored in unopened condition at room temperature (+18 °C to +25 °C) in a dry and dark space. Temperatures of approx. +5 °C will increase the shelf life to 12 months.

### Safety and health

When using WEICON products, the physical, safety-related, toxicological and ecological data and regulations in our safety data sheets ([www.weicon.com](http://www.weicon.com)) must be observed.

### Accessories

12955170 Dosing Tip, 1 PCE  
12955175 Dosing Tip, 1 PCE

#### Note

The specifications and recommendations given in this technical data sheet must not be seen as guaranteed product characteristics. They are based on our laboratory tests and on practical experience. Since individual application conditions are beyond our knowledge, control and responsibility, this information is provided without any obligation. We do guarantee the continuously high quality of our products. However, own adequate laboratory and practical tests to find out if the product in question meets the requested properties are recommended. A claim cannot be derived from them. The user bears the only responsibility for non-appropriate or other than specified applications.

# WEICON Contact VM 20 Cyanoacrylate Adhesive

## 1-Component Adhesives and Sealants Contact Cyanoacrylate Adhesives

### Available sizes:

12300030	WEICON Contact VM 20 Cyanoacrylate Adhesive, 30 g
12300060	WEICON Contact VM 20 Cyanoacrylate Adhesive, 60 g
12300500	WEICON Contact VM 20 Cyanoacrylate Adhesive, 0,5 kg

### Conversion table

$(^{\circ}\text{C} \times 1,8) + 32 = ^{\circ}\text{F}$	$\text{Nm} \times 8,851 = \text{lb}\cdot\text{in}$
$\text{mm}/25,4 = \text{inch}$	$\text{Nm} \times 0,738 = \text{lb}\cdot\text{ft}$
$\mu\text{m}/25,4 = \text{mil}$	$\text{Nm} \times 141,62 = \text{oz}\cdot\text{in}$
$\text{N} \times 0,225 = \text{lb}$	$\text{mPa}\cdot\text{s} = \text{cP}$
$\text{N}/\text{mm}^2 \times 145 = \text{psi}$	$\text{N}/\text{cm} \times 0,571 = \text{lb}/\text{in}$
$\text{MPa} \times 145 = \text{psi}$	$\text{kV}/\text{mm} \times 25,4 = \text{V}/\text{mil}$

To the product detail page:



#### Note

The specifications and recommendations given in this technical data sheet must not be seen as guaranteed product characteristics. They are based on our laboratory tests and on practical experience. Since individual application conditions are beyond our knowledge, control and responsibility, this information is provided without any obligation. We do guarantee the continuously high quality of our products. However, own adequate laboratory and practical tests to find out if the product in question meets the requested properties are recommended. A claim cannot be derived from them. The user bears the only responsibility for non-appropriate or other than specified applications.

WEICON Middle East L.L.C. United Arab Emirates phone +971 4 880 25 05 info@weicon.ae

WEICON Czech Republic s.r.o. Czech Republic phone +42 (0) 417 533 013 info@weicon.cz

WEICON GmbH & Co. KG (Headquarters) Germany phone +49 (0) 251 9322 0 info@weicon.de

WEICON Romania SRL Romania phone +40 (0) 3 65 730 763 office@weicon.com

WEICON South East Asia Pte Ltd Singapore Phone (+65) 6710 7671 info@weicon.com.sg

WEICON Inc. Canada phone +1 877 620 8889 info@weicon.ca

WEICON Ibérica S.L. Spain phone +34 (0) 914 7997 34 info@weicon.es

WEICON Italia S.r.L. Italy phone +39 (0) 010 2924 871 info@weicon.it

WEICON SA (Pty) Ltd South Africa phone +27 (0) 21 709 0088 info@weicon.co.za

WEICON Kimya Sanayi Tic. Ltd. Şti. Turkey phone +90 (0) 212 465 33 65 info@weicon.com.tr