1-Component Adhesives and Sealants

Contact Cyanoacrylate Adhesives

CA-Filler Set

WEICON Contact Filler and WEICON Contact VA 8312

WEICON Contact VA 8312 is suitable 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.

Characteristics		
Base		ethyl
Texture		colourless, clear substance
Processing		
Viscosity		20 - 40 mPa·s
Curing		
Anfangshaftung in Sekunken (Scherfestigkeit: 0,5 MPa)		
on aluminium		30 - 60 sec.
on rigid PVC		5 - 30 sec.
on NBR rubber		2 - 10 sec.
Final strength	(100 % strength)	24 h
Mechanical properties after curing		
Shear strength according to DIN EN 1465		
Steel sandblasted	DIN EN 1465	20 N/mm²
Aluminium sandblasted	DIN EN 1465	14 N/mm²
NBR	DIN EN 1465	> 8 N/mm²
Thermal parameters		
Temperature resistance		-50°C to +80°C, briefly up to +100°C/Squatting temperature +150°C

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^2 bonding surface. - The components should be bonded at a relative air humdity level between 40% and 80%. Below 40%, the curing process is slowed down significantly or even prevented altogether. At an air humdity 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.

Scope of delivery

Adhesive | CA-Filler

Safety and health

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

Accessories

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

Available sizes

12890001 CA-Filler Set, 1 PCE, transparent
12891001 CA-Filler Set, 1 PCE, black

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CA-Filler Set

Conversion table

(°C x 1,8) + 32 = °F
mm/25,4 = inch
µm/25,4 = mil
N x 0,225 = lb
N/mm^2 x 145 = psi
MPa x 145 = psi

Nm x 8,851 = lb·in
Nm x 0,738 = lb·ft
Nm x 141,62 = oz·in
mPa·s = cP
N/cm x 0,571 = lb/in
kV/mm x 25,4 = V/mil

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