

Contact Cyanoacrylate Adhesives

Contact-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
Minimum shelf life at room temperature	9 mon.
Minimum shelf life from +2 °C to +7 °C	12 Mon.

Processing

Viscosity	20 - 40 mPa·s
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Curing

Initial adhesion in seconds (shear strength: 0,5 MPa)	
on aluminium sandblasted	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	20 N/mm ²
Aluminium sandblasted	14 N/mm ²
NBR	> 8 N/mm ²

Thermal parameters

Temperature resistance	-50°C to +80°C, briefly up to +100°C/ Squatting temperature +150°C
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Approvals / Guidelines

MIL-Spec	complies with	MIL-A-46050C
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Instructions for use

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.

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.

Application

- 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 cm² 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

Store WEICON Contact Cyanoacrylate adhesives unopened at room temperature in a dry place, avoiding direct sunlight. Storage in a refrigerated environment (+2 °C bis +7 °C) increases the shelf life.

Scope of delivery

Adhesive (20g) | CA Filler (30g)

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.

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Contact-Filler Set

Contact Cyanoacrylate Adhesives

Accessories

10068262 Dosing Tip, 1 PCE
10068261 Dosing Tip, 1 PCE

Available sizes

10063102 Contact-Filler Set, 1 Set, transparent
10063110 Contact-Filler Set, 1 Set, black

Conversion table

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$	$\text{Nm} \times 8.851 = \text{lb}\cdot\text{in}$
$\text{mm}/25.4 = \text{inch}$	$\text{Nm} \times 0.738 = \text{lb}\cdot\text{ft}$
$\mu\text{m}/25.4 = \text{mil}$	$\text{Nm} \times 141.62 = \text{oz}\cdot\text{in}$
$\text{N} \times 0.225 = \text{lb}$	$\text{mPa}\cdot\text{s} = \text{cP}$
$\text{N}/\text{mm}^2 \times 145 = \text{psi}$	$\text{N}/\text{cm} \times 0.571 = \text{lb}/\text{in}$
$\text{MPa} \times 145 = \text{psi}$	$\text{kV}/\text{mm} \times 25.4 = \text{V}/\text{mil}$

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