WEICON®

1-Component Adhesives and Sealants
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

Processing

Viscosity	20 - 40 mPa·s

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/mm²
Aluminium sandblasted	14 N/mm²
NBR	> 8 N/mm²

Thermal parameters

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

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.

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 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

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 (20g) | CA Filler (30g)

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Contact-Filler Set

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

$(°C \times 1.8) + 32 = °F$

$mm/25.4 = inch$

$\mu m/25.4 = mil$

$N \times 0.225 = lb$

$N/mm^2 \times 145 = psi$

$MPa \times 145 = psi$

$Nm \times 8.851 = lb \cdot in$

$Nm \times 0.738 = lb \cdot ft$

$Nm \times 141.62 = oz \cdot in$

$mPa \cdot s = cP$

$N/cm \times 0.571 = lb/in$

$kV/mm \times 25.4 = V/mil$

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