

WEICON VA 8406 Cyanoacrylate Adhesive



Cyanoacrylate adhesive for rubber and plastic | ISEGA-certified | low viscosity | very fast curing

WEICON Contact VA 8406 is suitable for the fast fixing and bonding of various rubber materials, such as solid rubber or cellular rubber, plastics and EPDM elastomers. In combination with WEICON CA-Primer, VA 8406 can also be used for polyolefines (PE-polyethylene, PP-polypropylene) and for PTFE and silicones.

Characteristics

| | |
|---------------------|------------|
| Base | ethyl |
| Texture | liquid |
| Colour after curing | colourless |
| Silicone-free | yes |

Processing

| | |
|-------------------------|--------------------|
| Processing temperature | +15 °C to +40 °C |
| Relative air humidity | 40% - 70% |
| Viscosity | 25 °C Cone / Plate |
| Density | (+20 °C) |
| Gap bridging up to max. | 0,1 mm |

Curing

| | |
|---|----------------------------------|
| Initial adhesion in seconds (shear strength: 0,5 MPa) | |
| - measured at | 23 °C and 50 % relative humidity |
| on aluminium sandblasted | 10-20 sec. |
| on ABS untreated | 10-15 sec. |
| on rigid PVC | 20-40 sec. |
| Final strength (100 % strength) | 24 h |

Mechanical properties after curing

| | |
|---|-----------|
| Shear strength according to DIN EN 1465 | |
| Steel sandblasted | 12-22 MPa |
| Aluminium sandblasted | 8-16 MPa |
| Rigid untreated PVC | 8-14 MPa |
| Untreated ABS | 6-13 MPa |
| PC (polycarbonate) | 6-13 MPa |

Contact Cyanoacrylate Adhesives

Thermal parameters

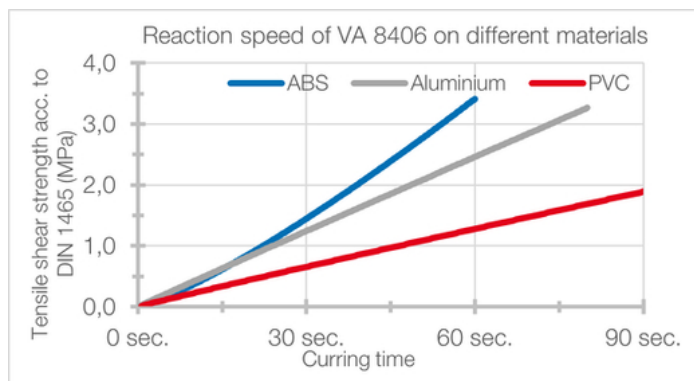
| | |
|-------------------------------|--------------------------------------|
| Temperature resistance | -50°C to +80°C, briefly up to +100°C |
| Softening temperature | +150 °C |
| Refraction index | ~ 1,49 nD20 |
| Thermal expansion coefficient | ~ 80 x 10 ⁻⁶ m/(m·K) |
| Thermal conductivity | DIN EN ISO 22007-4 |

Electrical parameters

| | |
|---------------------|------------|
| Resistance | DIN IEC93 |
| Dielectric strength | ~ 25 kV/mm |

Approvals / Guidelines

| | |
|-----------|--|
| ISEGA | EG 1935/2004LFGB §§ 30&31 |
| ISSA Code | 75.530.08 |
| MIL-Spec | comply with MIL-A-46050C Type II Class 1 |



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

The successful application of WEICON Contact Cyanoacrylate Adhesives depends on the thorough preparation of the surfaces. This is the most important factor for overall success. Dust, dirt and moisture or wetness have a negative impact on the adhesion.

Therefore, before processing WEICON Contact Cyanoacrylate Adhesives, the following points must be observed: For a flawless adhesive bond, adhesive 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 that are difficult to bond (e.g. PE, PP, POM, PTFE), thermoplastic elastomers (TPE) and silicones, WEICON CA-Primer can be applied to the bonding surface.

Contact Primer for Polyolefines

Without pre-treatment, many plastics cannot or can only be bonded under certain conditions. When these plastics are pre-treated with WEICON Contact Primer, their surface structure changes. This makes it possible to bond plastics

Note

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1-Component Adhesives and Sealants

Contact Cyanoacrylate Adhesives

that are otherwise difficult to bond, e.g. polyethylene (PE) and polypropylene (PP) from the polyolefine group. Even modern thermoplastic elastomers (TPE), PTFE and related plastics as well as silicones can be bonded, when pre-treated with WEICON Contact Primer.

Processing

The products are supplied ready for use. Depending on the form of delivery, they can be processed by hand directly from the container or with appropriate dosing equipment. 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 mm and max. 0.2 mm, 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 is sufficient for an adhesive area of 3 to 5 cm².

Curing

After applying the product, the parts to be bonded must be joined quickly and fixed if possible, since the curing of the products has already started as a result of the humidity in the ambient air or condensed on the bonding surfaces. The components should be bonded at a relative air humidity level between 40 % and 70 %. Below 40 %, the curing process is slowed down significantly or even prevented altogether. At an air humidity level above 70 % or with strongly alkaline substrates (e.g. glasses), there is a risk of shock curing. 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. If curing is delayed or disturbed by factors such as a too wide adhesive gap, porous or acidic surface, the use of WEICON Contact Activator is recommended.

WEICON Contact Activator

The activator speeds up the curing process of WEICON Contact Cyanoacrylate Adhesives. When applied to absorbing surfaces, e.g. wood or foam etc., and all chemically-treated surfaces, e.g. zinc galvanized metals etc., the activator's effectiveness lasts approx. one minute. On 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, low air humidity < 30 %).

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

Accessories

| | |
|----------|--|
| 11207150 | Surface Cleaner, 150 ml, transparent |
| 11207400 | Surface Cleaner, 400 ml, transparent |
| 12500150 | CA-Activator Spray, 150 ml |
| 12505150 | CA-Activator Spray AC, 150 ml |
| 12450010 | CA Primer for Polyolefines, 10 ml |
| 12450100 | CA Primer for Polyolefines, 100 ml |
| 12955170 | Dosing Tip, 1 PCE |
| 12955175 | Dosing Tip, 1 PCE |
| 12650030 | Contact Filler Contact Filler, 30 g, transparent 30 g, transparent |
| 12651030 | Contact Filler Contact Filler, 30 g, black 30 g, black |
| 12470012 | CA-Remover, 12 ml |
| 12470030 | CA-Remover, 30 ml |
| 10953001 | Processing Spatula, 1 PCE |

Available sizes

| | |
|----------|--|
| 12204012 | WEICON VA 8406 Cyanoacrylate Adhesive, 12 g |
| 12204030 | WEICON VA 8406 Cyanoacrylate Adhesive, 30 g |
| 12204060 | WEICON VA 8406 Cyanoacrylate Adhesive, 60 g |
| 12204500 | WEICON VA 8406 Cyanoacrylate Adhesive, 0,5 kg |

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1-Component Adhesives and Sealants

Contact Cyanoacrylate Adhesives

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:



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