

## O-Ring Bonding Set and Accessories for CA

# CA-Activator Spray



Nonfood Compounds  
Program Listed P1  
Registration 155051

### Heptane-based curing accelerator for WEICON Contact Cyanoacrylate Adhesives

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%).

#### Characteristics

Silicone-free	yes
Minimum shelf life	at room temperature 12 mon.

#### Processing

Processing temperature	+10 °C to +30 °C
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#### Approvals / Guidelines

MIL-Spec	complies with MIL-T-83523
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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](http://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 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.

### Scope of delivery

Activator | Spray can

### Available sizes

10000282 CA-Activator Spray, 150 ml

### Conversion table

(°C x 1.8) + 32 = °F	Nm x 8.851 = lb·in
mm/25.4 = inch	Nm x 0.738 = lb·ft
µm/25.4 = mil	Nm x 141.62 = oz·in
N x 0.225 = lb	mPa·s = cP
N/mm <sup>2</sup> x 145 = psi	N/cm x 0.571 = lb/in
MPa x 145 = psi	kV/mm x 25.4 = V/mil

#### 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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