

Contact VA 8312

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Cyanoacrylate Adhesive for rubber and plastics
ISEGA-certified
very fast-curing, low viscosity

WEICON Contact VA 8312 has low viscosity (20-40 mPa·s) and hardens very quickly. VA 8312 is suited 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.

ISSA: 75.629.04/05/06/17
IMPA: 81 52 41/42/43/44

Technical data

Ester type	Ethyl
Condition / nature	colourless, clear liquid
Viscosity at +20 °C Brookfield	30 mPa·s
Max. gap covering	0,1 mm
Specific gravity at +20 °C	1,05 g/cm ³
Initial adhesion on Aluminium	30-60 sec.
Initial adhesion on Nora test rubber	2-10 sec.
Initial adhesion on Rigid PVC	5-30 sec.
Final strength after	24 h
Temperature resistance	-50 bis +80 (kurzz. bis +100) Erweichungstemp. +150 °C

Pretreatment of the surface

- To ensure a perfect bonding, the surfaces to be joined must be clean and dry (to clean and degrease use WEICON Surface Cleaner).
- Smooth surfaces should be mechanically roughened.

Processing

- Apply WEICON Contact Cyanoacrylate Adhesive only on one of the surfaces to be bonded.
- The bond line should be between 0.05 mm and max. 0.2 mm (acc. to type) in thickness. Otherwise complete hardening cannot be guaranteed.
- For bonding large surfaces WEICON Contact Cyanoacrylate Adhesive should be applied drop by drop to avoid inner tensions.

- WEICON Contact Cyanoacrylate Adhesives are very economical. One drop is sufficient to cover approx. 3 - 5 cm² of bonded surface.
- The parts to be joined should be bonded in an atmosphere of 40 - 80 % relative humidity. In conditions of below 40%, the cure will be considerably slowed or even inhibited. With a relative air humidity of more than 80% or with basic substrates (e.g. glass), shock-curing can occur. In such cases, some materials show a drop in bond strength of 10 - 15 %, due to inner tensions in the bond line.
- Basic-reacting surfaces (pH-value >7) will speed up the cure whereas acidic-reacting surfaces will retard and, under extreme conditions, completely inhibit the polymerization.

Storage

To ensure a perfect bonding, the surfaces to be joined must be clean and dry (to clean and degrease use WEICON Surface Cleaner). Smooth surfaces should be mechanically roughened. To improve the adhesion on difficult to bond plastics (e.g. PE, PP, POM, PTFE), thermoplastic elastomers (TPE) and Silicone, WEICON CA-Primer can be applied on the surface.

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.

Health and Safety

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

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