

## Technical Datasheet

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## Contact VA 1401 Cyanoacrylate Adhesive



### Cyanoacrylate Adhesive for rubber and plastics medium viscosity fast-curing

WEICON Contact VA 1401 has medium viscosity (100-150 mPa•s) and hardens quickly. It shows good results on fabric, paper, cardboard, cartons, foam rubber and large-pored elastomers. VA 1401 is a universal type for the bonding of metals, plastics and rubber, both to themselves and among each other.

### Technical Data

Ester type	Ethyl
Texture	colourless, clear liquid
Viscosity at +20°C (+68°F) according to Brookfield	100 -150 mPa•s
Max. Gap Bridging	0,15 mm
Initial strength on aluminium	2 -10 sec.
Initial strength on NBR-Rubber	<5 sec.
Initial strength on hard PVC	2 -10 sec.
Final strength approx. after	24 h
Shear strength according to DIN EN 1465 at:	
Steel sand blasted	22 N/mm <sup>2</sup>
Sand-blasted Aluminium	16 N/mm <sup>2</sup>
Rigid PVC	14 N/mm <sup>2</sup>
ABS	13 N/mm <sup>2</sup>
PC	13 N/mm <sup>2</sup>
NBR	> 8 N/mm <sup>2</sup>
Temperature resistance	-50 to +120 briefly to +150 / squatting temp. +170 °C
ISSA-Code	75.629.12/13/14/16
IMPA-Code	815245/46/47/48

### Surface pre-treatment

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.

### 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 cm<sup>2</sup> 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 smaller 7) will speed up the cure whereas acidic-reacting surfaces will retard and, under extreme conditions, completely inhibit the polymerization.

### Storage

WEICON Contact Cyanoacrylate Adhesives can be stored in the unopened original container for at least 9 months at room temperature (+ 18°C to + 25°C). Keep away from moisture and direct sunlight. At temperatures of about + 5°C, the shelf life can be extended up to 12 months.

### Safety and health

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

### Available sizes:

12054012	Contact VA 1401 Cyanoacrylate Adhesive 12 g
12054020	Contact VA 1401 Cyanoacrylate Adhesive 20 g