

## Technical Datasheet

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# Contact VA 8312 Cyanoacrylate Adhesive



### 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.

### Technical Data

Ester type	Ethyl
Texture	colourless, clear liquid
Viscosity at +20°C (+68°F) according to Brookfield	20 -40 mPa·s
Max. Gap Bridging	0,1 mm
Initial strength on aluminium	30 -60 sec.
Initial strength on NBR-Rubber	2 -10 sec.
Initial strength on hard PVC	5 -30 sec.
Final strength approx. after	24 h
Shear strength according to DIN EN 1465 at:	
Steel sand blasted	20 N/mm <sup>2</sup>
Sand-blasted Aluminium	14 N/mm <sup>2</sup>
Rigid PVC	13 N/mm <sup>2</sup>
ABS	12 N/mm <sup>2</sup>
PC	13 N/mm <sup>2</sup>
NBR	> 8 N/mm <sup>2</sup>
Temperature resistance	-50 to +80 briefly to +100 / squatting temp. +150 °C
ISSA-Code	75.629.04/05/06/17
IMPA-Code	815241/42/43/44

### 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) must be observed.

### Available sizes:

1220012      Contact VA 8312 Cyanoacrylate Adhesive 12 g



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12200020	Contact VA 8312 Cyanoacrylate Adhesive 20 g
12200030	Contact VA 8312 Cyanoacrylate Adhesive 30 g
12200060	Contact VA 8312 Cyanoacrylate Adhesive 60 g
12200500	Contact VA 8312 Cyanoacrylate Adhesive 500 g

### Accessories:

12955170	Dosing Tips,
12955175	Dosing Tips,

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[www.tashev-galving.com](http://www.tashev-galving.com)