

Contact Cyanoacrylate Adhesives

Contact GEL



Cyanoacrylate adhesive for special requirements | thixotropic (pasty) | very slow curing = position correction

WEICON Contact GEL is pasty (highly thixotropic 60000 - 90000 mPa•s) and cures very slowly. By using WEICON Activator Spray, the cure time can be reduced. The adhesive is suited for porous surfaces and higher tolerance gaps and can be used on vertical surfaces. Repositioning is also possible after the parts have been joined. It is suited for the bonding of various materials. WEICON Contact Gel can be used both in the hobby sector and in model building. It can also be used in many different industrial applications.

Technische Daten

Base		ethyl
Texture		colourless, clear gel
Gap bridging up to max.		0,2 mm
Initial adhesion on aluminium		90 - 120 sec.
Initial adhesion on NBR rubber		20 - 30 sec.
Initial adhesion on rigid PVC		40 - 80 sec.
Final strength (100 % strength)		24 h
Steel sandblasted	DIN EN 1465	21 N/mm ²
Aluminium sandblasted	DIN EN 1465	15 N/mm ²
Rigid PVC	DIN EN 1465	13 N/mm ²
ABS	DIN EN 1465	12 N/mm ²
NBR	DIN EN 1465	> 8 N/mm ²
Temperature resistance		-50°C to +80°C /softening temp. +150°C
ISSA Code		75.629.07
IMPA Code		815251

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.

Processing

- 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 cm² 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.

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.

Safety and health

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

Accessories

- 12955170 Dosing Tip, 1 PCE
- 12955175 Dosing Tip, 1 PCE

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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Available sizes:

12500120 Contact GEL, 20 g
12500130 Contact GEL, 30 g

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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