

Contact GEL



Cyanoacrylate Adhesive for special requirements pasty (highly thixotropic) very slow-curing = position correction

Contact GEL is pasty (highly thixotropic 60000 - 90000 mPa•s) and curing hardens very slowly. By using WEICON Activator Spray, the cure time can be reduced.

WEICON Contact GEL is suited for porous surfaces and higher tolerance gaps and can be used on vertical surfaces. Positioning is also possible after the parts have been joined.

WEICON Contact Gel is suited for the bonding of the most diverse products. 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.

Technical Data

Ester type	Ethyl
Composition	colourless, clear liquid
Viscosity at +20°C (+68°F) according to Brookfield	60.000 - 90.000 mPa•s
Max. Gap Bridging	0,2 mm
Initial strength on aluminium	90 -120 sec.
Initial strength on NBR-Rubber	20 -30 sec.
Initial strength on hard PVC	40 -80 sec.
Final strength approx. after	24 h
Shear strength according to DIN 53283 on	
Sand-blasted Steel	21 N/mm ²
Sand-blasted Aluminium	15 N/mm ²
Rigid PVC	13 N/mm ²

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.

ABS	12 N/mm ²
PC	12 N/mm ²
NBR	> 8 N/mm ²
Temperature resistance	-50 to +80 /squatting temp. +150 °C
ISSA-Code	75.629.07
IMPA-Code	81 52 61

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 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 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.

WEICON GmbH & Co. KG
(Headquarters)
Germany
phone +49 (0) 251 9322 0
info@weicon.de

WEICON Middle East L.L.C.
United Arab Emirates
phone +971 4 880 25 05
info@weicon.ae

WEICON Inc.
Canada
phone +1 877 620 8889
info@weicon.ca
www.weicon.ca

WEICON Kimya Sanayi Tic. Ltd. Şti.
Turkey
phone +90 (0) 212 465 33 65
info@weicon.com.tr
www.weicon.com.tr

WEICON Romania SRL
Romania
phone +40 (0) 3 65 730 763
office@weicon.com

WEICON SA (Pty) Ltd
South Africa
phone +27 (0) 21 709 0088
info@weicon.co.za

WEICON South East Asia Pte Ltd
Singapore
phone (+65) 6710 7671
info@weicon.com.sg

WEICON Czech Republic s.r.o.
Czech Republic
phone +42 (0) 417 533 013
info@weiconcz.cz

WEICON Ibérica S.L.
Spain
phone +34 (0) 914 7997 34
info@weicon.es

Technical Datasheet

Create Date: 16.11.2017 - Seite 2/2

Available sizes:

12500120 Contact GEL 20 g
12500130 Contact GEL 30 g

Accessories:

11202400 Sealant and Adhesive Remover, 400 ml
11207400 Surface Cleaner, 400 ml
11850200 Hand Protective Foam, 200 ml
12450010 CA-Primer for Polyolefines, 10 ml
12500150 CA-Activator Spray, 150 ml
12505150 CA-Activator Spray AC, 150 ml

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.

WEICON GmbH & Co. KG
(Headquarters)
Germany
phone +49 (0) 251 9322 0
info@weicon.de

WEICON Middle East L.L.C.
United Arab Emirates
phone +971 4 880 25 05
info@weicon.ae

WEICON Inc.
Canada
phone +1 877 620 8889
info@weicon.ca
www.weicon.ca

WEICON Kimya Sanayi Tic. Ltd. Şti.
Turkey
phone +90 (0) 212 465 33 65
info@weicon.com.tr
www.weicon.com.tr

WEICON Romania SRL
Romania
phone +40 (0) 3 65 730 763
office@weicon.com

WEICON SA (Pty) Ltd
South Africa
phone +27 (0) 21 709 0088
info@weicon.co.za

WEICON South East Asia Pte Ltd
Singapore
phone (+65) 6710 7671
info@weicon.com.sg

WEICON Czech Republic s.r.o.
Czech Republic
phone +42 (0) 417 533 013
info@weiconcz.cz

WEICON Ibérica S.L.
Spain
phone +34 (0) 914 7997 34
info@weicon.es