

# Contact VA 8406 Cyanoacrylate Adhesive



**Cyanoacrylate Adhesive for rubber and plastics**  
**low viscosity**  
**very fast-curing**

WEICON Contact VA 8406 has low viscosity (20-50 mPa•s) and hardens very quickly. It is suited for the fast fixing and bonding of various rubber materials such as solid rubber or cellular rubber, plastics and EPDM elastomers.

In combination with WEICON CA-Primer, VA 8406 can also be used for polyolefines (PE-polyethylene, PP-polypropylene) and for PTFE and silicones.



## Technical Data

Ester type	Ethyl
Composition	colourless, clear liquid
Viscosity at +20°C (+68°F) according to Brookfield	20 -50 mPa•s
Max. Gap Bridging	0,1 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 53283 on	
Sand-blasted Steel	22 N/mm <sup>2</sup>
Sand-blasted Aluminium	16 N/mm <sup>2</sup>

### Note

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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 +80 briefly to +100 / squatting temp. +150 °C

### 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.

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## Technical Datasheet

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### Available sizes:

12204012	Contact VA 8406 Cyanoacrylate Adhesive 12 g
12204030	Contact VA 8406 Cyanoacrylate Adhesive 30 g
12204060	Contact VA 8406 Cyanoacrylate Adhesive 60 g
12204500	Contact VA 8406 Cyanoacrylate Adhesive 500 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
12955170	Dosing Tips, Size 0
12955175	Dosing Tips, Typ A Size 0,5

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