

# Contact VM 20

## Introduction

WEICON Contact Cyanoacrylate Adhesives are cold curing one-component adhesives, free of solvents. They quickly polymerise by reacting with moisture both on the surfaces to be bonded and from the air, and cure under light pressure.



- low viscosity, 20-40 mPa·s
- very fast-curing
- for metal-metal combinations, particularly in assembly line manufacture for the bonding of close fitting parts

## Technical data

Ester type	Methyl
Condition / nature	colourless, clear liquid
Viscosity at +20°C Brookfield	20-40 mPa·s
Max. gap covering	0,1 mm
Initial adhesion on Aluminium	50-70 sec.
Initial adhesion on Nora test rubber	10-60 sec.
Initial adhesion on Rigid PVC	30-120 sec.
Final strength after	24 h

## Pretreatment of the surface

- To ensure a perfect bonding, the surfaces to be joined must be clean and dry (to clean and degrease use e.g. WEICON Cleaner S).
- Smooth surfaces should be mechanically roughened.

## 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 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 >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 should always be stored in a cool, dry and dark place. The shelf life is at least 9 months if stored at room temperature (18 - 25°C). If stored at +5°C (e.g. in a refrigerator), the shelf life can be extended to 12 months.

## 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, our 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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