

# Contact VA 2500 HAT Cyanoacrylate Adhesive



**Cyanoacrylate Adhesive for special requirements**  
**high temperature resistant**  
**high viscosity**

WEICON Contact VA 2500 HT is highly viscous (2000-3000 mPa•s) and temperature resistant between -50°C (-58°F) and +140°C (+284°F). It hardens slowly with residual elasticity and has high peel and impact strength. Thanks to its curing with residual elasticity.

WEICON Contact VA 2500 HT is particularly suitable under changing climatic conditions. It is insensitive even under a longer influence of humidity. VA 2500 HT is suited for the bonding of the most diverse rubber materials and plastics and also for metal/plastic joints.

## Technical Data

Ester type	Ethyl
Composition	opaque
Viscosity at +20°C (+68°F) according to Brookfield	2.000 - 3.000 mPa•s
Max. Gap Bridging	0,2 mm
Initial strength on aluminium	40 -80 sec.
Initial strength on NBR-Rubber	25 -60 sec.
Initial strength on hard PVC	25 -100 sec.
Final strength approx. after	24 h
Shear strength according to DIN 53283 on	
Sand-blasted Steel	24 N/mm <sup>2</sup>
Sand-blasted Aluminium	18 N/mm <sup>2</sup>
Rigid PVC	13 N/mm <sup>2</sup>
ABS	12 N/mm <sup>2</sup>

## 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.

PC	13 N/mm <sup>2</sup>
NBR	> 8 N/mm <sup>2</sup>
Temperature resistance	-55 to +140 / squatting temp. +160 °C
ISSA-Code	75.629.10/11/18/19
IMPA-Code	81 52 49/50/51/52

## 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:

12550012	Contact VA 2500 HAT Cyanoacrylate Adhesive 12 g
12550030	Contact VA 2500 HAT Cyanoacrylate Adhesive 30 g
12550060	Contact VA 2500 HAT Cyanoacrylate Adhesive 60 g
12550500	Contact VA 2500 HAT 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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