

# Contact Cyanoacrylate Adhesives

## WEICON VA 2407



### universal use | high adhesive strength | fast-curing

WEICON VA 2407 is a colourless and crystal clear curing two-component cyanoacrylate adhesive for bonding a wide variety of materials. It adheres very well to many plastics (e.g. polycarbonate), steel, stainless steel, aluminium, ceramics, glass, and rubber.

The newly developed adhesive combines the advantages of instant adhesives with the process reliability of 2-component adhesives.

The high-strength and fast-curing structural adhesive can be sanded and painted after approx. 25 minutes. It is resistant to weathering, many aggressive chemicals, impact stress, and vibration. It is temperature-resistant from -20 °C to +120 °C (-4° to +248°F). Depending on the geometry of the bond, gaps of up to 5 mm can be bridged with VA 2407.

Due to its fast and impact-resistant curing, it is particularly suitable for bonding e.g. plastic and rubber. It can also be used for structural bonding where a coloured adhesive joint would disturb the overall visual impression of the component. With VA 2407, transparent plastics, such as Plexiglas and other materials, can be bonded cleanly and in a visually appealing, high-strength manner.

The adhesive is suitable for a wide variety of applications in plastics technology, mechanical engineering, model and mould making, metal construction, ship and boat building, bodywork and vehicle construction, trade fair and exhibition construction and many other areas of industry.

### Characteristics

Specific properties	2C Cyanoacrylate
Base	Ethyl acrylate
Texture	pasty
Colour	transparent

### Processing

Mixing ratio by weight	10:1
Viscosity	25 °C Cone / Plate 1.000 mPa·s
Gap bridging up to max.	5 mm

### Curing

Initial adhesion in sec. at 23°C and 50% relative humidity	
on aluminium	20 - 30 sec.
on ABS untreated	4 - 4,5 min.
on rigid PVC	2,5 - 3 min.
Final strength	at room temperature 24 h
Pot life	at 20 °C, 10 g batch 5 min.

### Mechanical properties after curing

Shear strength according to DIN EN 1465		
Steel sandblasted	DIN EN 1465	16 - 21 N/mm <sup>2</sup>
Aluminium sandblasted	DIN EN 1465	10 - 15 N/mm <sup>2</sup>
Rigid PVC	DIN EN 1465	10 - 14 N/mm <sup>2</sup>
ABS	DIN EN 1465	13 - 15 N/mm <sup>2</sup>
NBR	DIN EN 1465	> 8 N/mm <sup>2</sup>
PC (polycarbonate)		12 - 17 N/mm <sup>2</sup>

### Thermal parameters

Temperature resistance	-20 °C to +120 °C
Softening temperature	+150 °C
Flashpoint	+87 °C (+189 °F)
Thermal expansion coefficient	80 x 10 <sup>-6</sup> m/(m·K)
Thermal conductivity	DIN EN ISO 22007-4 0,1 W/m·K

### Electrical parameters

Resistance	DIN IEC93	> 10 <sup>15</sup> Ω·cm
Dielectric strength		25 kV/mm

### Instructions for use

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.

### Surface pre-treatment

Clean and dry bonding surfaces are essential for flawless adhesive bonding (e.g. cleaning and degreasing with WEICON Surface Cleaner).

### Shelf life

When stored in unopened condition in a dry place at constant room temperature (+18°C bis +25°C), WEICON VA 2407 has a shelf life of at least 9 months. At temperatures around +5°C the shelf life is extended to 12 months.

### Available sizes

1280010	WEICON VA 2407, 10 g, transparent
1280050	WEICON VA 2407, 50 g, transparent

#### 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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### Conversion table

$(^{\circ}\text{C} \times 1,8) + 32 = ^{\circ}\text{F}$   
 $\text{mm}/25,4 = \text{inch}$   
 $\mu\text{m}/25,4 = \text{mil}$   
 $\text{N} \times 0,225 = \text{lb}$   
 $\text{N}/\text{mm}^2 \times 145 = \text{psi}$   
 $\text{MPa} \times 145 = \text{psi}$

$\text{Nm} \times 8,851 = \text{lb}\cdot\text{in}$   
 $\text{Nm} \times 0,738 = \text{lb}\cdot\text{ft}$   
 $\text{Nm} \times 141,62 = \text{oz}\cdot\text{in}$   
 $\text{mPa}\cdot\text{s} = \text{cP}$   
 $\text{N}/\text{cm} \times 0,571 = \text{lb}/\text{in}$   
 $\text{kV}/\text{mm} \times 25,4 = \text{V}/\text{mil}$

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