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Cyanoacrylate Adhesives





About AG

Founded in 1965 and 100% Australian owned, Associated Gaskets has a long standing reputation in Australian industry for providing high quality products and exemplary service. As our range of products has continued to expand over the years, our focus remains on providing the very best service possible.

Today, AG offers a truly comprehensive range of gaskets, seals, thermal and electrical insulation, adhesives and sealants, technical sprays, liquids and industrial tapes. We couple this enormous range with extensive fabrication facilities and large stock holdings spread amongst our 6 locations; Brisbane, Melbourne, Perth, Wollongong, Newcastle and our Sydney (head office).

If you would like any more information on any of the glues listed in this guide, or any other product in AG's versatile range, please don't hesitate to contact your local AG branch.

Industries Served

- Agricultural
- Automotive
- Chemical & Petro-Chemical
- Construction
- Defence & Aerospace
- Electric Motor Rewinders & OEMs
- Electronics
- Engineering
- Food & Beverage
- Manufacturing
- Marine & Shipbuilding
- Metallurgical
- Mining
- Oil & Gas
- Paper, Pulp & Board
- Pharmaceutical
- Power Generation & Transmission
- Renewable Energy
- Switchboard Manufacture & Repair
- Tradespeople
- Transformer Manufacture & Repair
- Transport

 Water & Waste & Many, Many More...



Services Offered

- 3D Modelling & Drawing
- Die Cutting
- Extrusions
- Individualised Documentation
- Inventory Management
- Kiss Cutting
- Kits & Custom Packaging
- Laser Cutting
- Machining
- Moulding
- Product Coding & Traceability
- Rapid-Prototyping
- Sample Reproduction
- Sewing
- Shut Down Services
- Slitting
- Thicknessing
- Water Cutting & Many More...

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AG issociated Gaskets



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

Within seconds, they will bond almost all kinds of materials, including:

- Metals
- Plastics
- Glass
- Ceramics
- Wood
- Leather
- Natural and Synthetic Rubber



When using Weicon Contact Adhesives, unlike welding or soldering, surfaces remain unaltered. No material stress occurs. As a result, simpler and faster assembly is often possible and the need for auxiliary fixing devices is eliminated.

Advantages of using Weicon Contact Adhesives include:

- Enormous time and, therefore, cost savings
- Immediate on-processing of fixed parts possible
- High bond strength up to material fracture
- Clean and optically appealing bonds



Weicon Contact Cyanoacrylate Adhesives are high strength, have good temperature resistance (-50°C to 150°C) and excellent resistant to a variety of chemicals. In many instances, the cured bond proves to be harder than the material of the bonded parts (material fracture).

AG's range of Weicon Contact Adhesives includes a variety of grades for different applications. These grades typically differ chemically and by their viscosity.

Ethyl Ester based types

Achieve a high bond elasticity as a result of their molecule size and the fact that the anchoring points are positioned far from each other. These types are typically used for bonding plastics or rubber.

Alkoxy Ethyl based types

Like the ethyl ester based types, this type of adhesive creates bonds with some residual flexibility. Alkoxy ethyl based adhesives differ in that they are characterised by low odour curing, which makes them especially user-friendly in assembly line environments.

When cured, this type of adhesive is less sensitive to humidity and should be applied in situations where white "blooming" of the bond cannot be tolerated.

Methyl Ester based types

As a result of their small molecule structure and closely positioned anchor points, this type of adhesive is less flexible after curing. As a result, they represent a particularly good option for bonding metals.





Bonding of Plastics with Weicon Cyanoacrylate Adhesives

Thermoplastics (e.g. polystyrene, polycarbonate, styrene butadiene, styrene acryl nitrile, polymethylmethacrylate, polyvinylchloride and polyamide) can be bonded well with the right Weicon Cyanoacrylate Adhesive.

Plastics like polyethylene, polypropylene, polyacetal, polytetrafluoroethylene (PTFE) and other fluorite hydrocarbons have a naturally adhesive aversive surface. This causes insufficient wetting to take place meaning that the adhesive cannot anchor itself to the surface structure. As a result, these materials must be pre-treated with Weicon Contact Primer so that their surfaces are activated and therefore able to be bonded.



Duroplastics like melamine formaldehyde resin, urea formaldehyde resin, epoxy and polyester resins can be bonded well with our Contact Adhesives. Phenol formaldehyde resins however can only be bonded under certain conditions.

Since there are literally thousands of different types of plastic, each with their own specific strength results, it is also suggested that a bonding test be carried out ahead of use.

Contact Primer for Polyolefines

Without pre-treatment, many plastics can't be bonded or can only be adhered under specific conditions. When these plastics are pre-treated with Weicon Contact Primer, their surface structure changes. As a result, the bonding of plastics such as polyethylene (PE) and polypropylene (PP) becomes possible.

Even modern thermoplastic elastomers (TPE), PTFE and other notoriously difficult to glue plastics (as well as silicones) can be bonded when pre-treated with Weicon Contact Primer.

Contact Primer is available in 10ml and 100ml bottles.

Contact Activator

Weicon Contact Activator speeds up the curing process of Weicon Cyanoacrylate Adhesives.



When applied to absorbing surfaces (such as wood, foam) or chemically treated surfaces (e.g. zinc galvanised metals) the activators effectiveness lasts for approximately 1 minute. When used with non-absorbing surfaces the activators effectiveness lasts up to 12 hours (approx.).

Use of Weicon Contact Activator is suggested with:

- Highly viscous Weicon Contact Adhesives types
- Thick adhesive layers
- Absorbing or highly porous materials
- Passive materials (e.g. alkaline surfaces, zinc coated metal parts)
- Low temperatures
- Low air humidity (<30%)

Contact Activator is available in 150ml cans.





Cyanoacrylate Adhesive for Rubber & Plastics - Low Viscosity - Very Fast Cure Time - Ethyl Ester Based Weicon Contact Adhesive VA 20 has a low viscosity (<20 mPa) and hardens very quickly.

VA 20 is excellent for bonding of rubber and plastics as well as precision fitted metal/plastic joints.

	/10	Technical Data		
Available		Ester Type	Ethyl	
Sizes		Condition / Nature	Colourless, Clear Liquid	
12gm		Viscosity at 20°C Brookfield	< 20 mPa	
	Contact	Maximum Gap Covering	0.1mm	
30gm	VA 20	Initial Adhesion on Aluminium	30-60 sec.	
	window book	Initial Adhesion on Nora Test Rubber	2-15 sec.	
60gm	Onmany Mandatan Opinany Satura Antonin Gina Nyawacan Jaka Antonina da de casauntin Milli and an mana do thi	Initial Adhesion on Rigid PVC	5-60 sec.	
[00 gm	Main. 12000200 30 50	Final Strength After	24h	
SUUGIII	1	Temperature Resistance	-50°C to +80°C (approx.) Short-term to 100°C Squatting Temp.: +150°C	

VA 8312

Cyanoacrylate Adhesive for Rubber & Plastics - Low Viscosity -Very Fast Cure Time - ISEGA Certified - Ethyl Ester Based



Weicon Contact Adhesive VA 8312 has low viscosity and hardens very quickly. VA 8312 is excellent in bonding various rubber materials (such as solid rubber, sponge rubber, EPDM) as well as plastics.

VA 8312 is also used in conjunction with Weicon CA-Primer to bond polyolefines (e.g. PE, PP) or in combination with Weicon Contact Filler for the filling or cracks, clefts, holes and instant bonding on uneven surfaces.

		Technical Data		
Available		Ester Type	Ethyl	
Sizes		Condition / Nature	Colourless, Clear Liquid	
1.2 gm		Viscosity at 20°C Brookfield	20-40 mPa	
128111	Contact	Maximum Gap Covering	0.1mm	
30gm	WA 8312	Initial Adhesion on Aluminium	30-60 sec.	
	erendra sobre Minacidad baja E. Kultz	Initial Adhesion on Nora Test Rubber	2-10 sec.	
60gm	1 Strategy Goldbard 1 Strategy Landson 1 Str	Initial Adhesion on Rigid PVC	5-30 sec.	
500	41 4a 11550000 30 9 ⁴	Final Strength After	24h	
500gm		Temperature Resistance	-50°C to +80°C (approx.) Short-term to 100°C Squatting Temp.: +150°C	



Cyanoacrylate Adhesive for Rubber & Plastics - Low Viscosity - Very Fast Cure Time - Ethyl Ester Based

Weicon Contact Adhesive VA 8406 has a low viscosity and a very fast cure time. This grade is suitable for the fast fixing and bonding of various forms of rubber (e.g. solid rubber, sponge rubber, EPDM) and plastics.

When used in combination with Weicon CA-Primer, VA 8406 can also be used for bonding polyolefines (e.g. PE, PP), PTFE and silicones.

		Technical Data		
Available		Ester Type	Ethyl	
Sizes		Condition / Nature	Colourless, Clear Liquid	
1.) am		Viscosity at 20°C Brookfield	20-50 mPa	
LZgIII	Contact Per-System	Maximum Gap Covering	0.1mm	
30gm	Bidgiyasos Biv visosity	Initial Adhesion on Aluminium	2-10 sec.	
-	机相定 Provide Dates	Initial Adhesion on Nora Test Rubber	< 5 sec.	
60gm	Simmerytatikieten Ginnaerytato Antenin Killen eynaenschrift Aftentivo die elanoscrifti	Initial Adhesion on Rigid PVC	2-10 sec.	
500	6 ,66,95,66,86,95,85,97,77	Final Strength After	24h	
500gm	14 4h 1220450 60 P	Temperature Resistance	-50°C to +80°C (approx.) Short-term to 100°C Squatting Temp.: +150°C	

VA 100

Cyanoacrylate Adhesive for Rubber, Metals, Glass, Ceramic, Leather & Plastics - Medium Viscosity - Slightly Longer Cure Time - Ethyl Ester Based

Weicon Contact Adhesive VA 100 is a universal type of super glue used for bonding metals, plastics, cloths, glass, ceramic and rubbers.

Because of its versatility, VA 100 is ideal for use in the DIY arena as well as a wide variety of industries.

Available Sizes	
3gm	100000
12gm	WA 100
30gm	Acuté Acquire Acutéd maria 173 Acro Componytatisében Componytatisében
60gm	 Galle systematory/and Adhestive die classifiel RUS (21 die doyme in 1 die die systematory die doyme in 1 die
500gm	- 46 (200033 34
	1

Technical Data			
Ester Type	Ethyl		
Condition / Nature	Colourless, Clear Liquid		
Viscosity at 20°C Brookfield	60 - 120 mPa		
Maximum Gap Covering	0.15mm		
Initial Adhesion on Aluminium	30-60 sec.		
Initial Adhesion on Nora Test Rubber	3-20 sec.		
Initial Adhesion on Rigid PVC	10-60 sec.		
Final Strength After	24h		
Temperature Resistance	-50°C to +80°C (approx.) Short-term to 100°C Squatting Temp.: +150°C		





Cyanoacrylate Adhesive for Rubber & Plastics - Medium Viscosity - Fast Curing -Ethyl Ester Based - NSF Approved

Weicon Contact Adhesive VA 110 is a specialised grade designed for sensitive applications. This type is certified in accordance with NSF/ANSI Standard 61 for use in drinking water systems.

VA 110 is primarily used for bonding rubber and plastics but also adheres well to wood, metal, glass, leather and more.

		Technical Data		
Available		Ester Type	Ethyl	
Sizes		Condition / Nature	Colourless, Clear Liquid	
12gm		Viscosity at 20°C Brookfield	70-110 mPa	
128111		Maximum Gap Covering	0.15mm	
30gm		Initial Adhesion on Aluminium	20-50 sec.	
		Initial Adhesion on Nora Test Rubber	3-15 sec.	
60gm		Initial Adhesion on Rigid PVC	10-50 sec.	
F 0 0	18	Final Strength After	24h	
SUUgm		Temperature Resistance	-30°C to +80°C (approx.) Short-term to 100°C Squatting Temp.: +160°C	

VA 1401

Cyanoacrylate Adhesive for Rubber & Plastics - Medium Viscosity - Fast Cure Time - Ethyl Ester Based

Weicon Contact Adhesive VA 1401 is a medium viscosity glue with a fast cure time. This grade exhibits good adhesion on fabric, paper, cardboard, cartons, foam rubber and large-pored elastomers.

VA 1401 is a universal type of industrial adhesive which can also be used for bonding metals, plastics and rubbers both to themselves and amongst each other.

		Technical I	Data
Available		Ester Type	Ethyl
Sizes		Condition / Nature	Colourless, Clear Liquid
10		Viscosity at 20°C Brookfield	100 - 150 mPa
12gm	Contact ^{The Splane}	Maximum Gap Covering	0.15mm
30gm	VA 1401	Initial Adhesion on Aluminium	2-10 sec.
50511	Manadad masha Pristang Mananyta Kalawar	Initial Adhesion on Nora Test Rubber	< 5 sec.
60gm	Sonory years A carevon Caller generatory of the Administration date sciences of the Administration date sciences of the B. B. P. 1. Ministration on J. Prov.	Initial Adhesion on Rigid PVC	2-10 sec.
	Association and go	Final Strength After	24h
500gm		Temperature Resistance	-50°C to +120°C (approx.) Short-term to 150°C Squatting Temp.: +170°C



Cyanoacrylate Adhesive for Rubber & Plastics - Higher Viscosity - Longer Cure Time - Ethyl Ester Based

Weicon Contact Adhesive VA 300 has a higher viscosity and an extended cure time. This grade is well suited for bonding porous and highly absorbent materials such as wood, cork, leather and ceramics.

VA 300 is also used for bonding metals, rubber and various types of plastics both to themselves and among each other.

		Technical Data		
Available		Ester Type	Ethyl	
Sizes		Condition / Nature	Colourless, Clear Liquid	
1.2 gm		Viscosity at 20°C Brookfield	200-300 mPa	
12811	Contact	Maximum Gap Covering	0.15mm	
30gm	VA 300 Minimutan	Initial Adhesion on Aluminium	60-90 sec.	
-	Windy Group Winds also distance	Initial Adhesion on Nora Test Rubber	2-10 sec.	
60gm	 Premiery visit Administrative Remain admininterve Remain administrative Remain admi	Initial Adhesion on Rigid PVC	10-60 sec.	
500	M Me hanced 30 g0	Final Strength After	24h	
500gm		Temperature Resistance	-50°C to +80°C (approx.) Short-term to 100°C Squatting Temp.: +150°C	

VA 1500

Cyanoacrylate Adhesive for Rubber & Plastics - High Viscosity - Slow Curing - Ethyl Ester Based

Weicon Contact Adhesive VA 1500 is a highly viscous industrial grade of super glue which has an extended cure time. This grade offers excellent workability and is well suited for bonding rubber and plastics.

VA 1500 can also be used to bond absorbent or porous materials such as wood, leather, cork and ceramics.



Contact Mediaters VA 1500	
Annual States	
Omenceylatikaden Omenceylatik Action Gale sysneaarylatin Athonika die classificial W.K.170 Kolecture (C.M.	
let ale, 12150030 30 9 ⁰	

Technical Data			
Ester Type	Ethyl		
Condition / Nature	Colourless, Clear Liquid		
Viscosity at 20°C Brookfield	1,000—1,500 mPa		
Maximum Gap Covering	0.2mm		
Initial Adhesion on Aluminium	90-120 sec.		
Initial Adhesion on Nora Test Rubber	5-30 sec.		
Initial Adhesion on Rigid PVC	10-120 sec.		
Final Strength After	24h		
Temperature Resistance	-50°C to +80°C (approx.) Short-term to 100°C Squatting Temp.: +150°C		



Contact Gel Cyanoacrylate Adhesive for Special Applications - Pasty (highly thixotropic) - Very Slow Curing -Allows Positional Correct ions After Application - Ethyl Ester Based

Contact Gel Adhesive has a paste-like consistency and hardens slowly (though cure time can be accelerated if Weicon Activator Spray is used). This adhesive is particularly suited for bonding porous surfaces and larger gaps. It can be used on vertical surfaces and allows for some repositioning of the parts immediately after application of the adhesive.

Δ		Technical I	Data
		Ester Type	Ethyl
-	-	Condition / Nature	Colourless, Clear Liquid
	Contact	Viscosity at 25°C Brookfield	60,000-90,000 mPa
Contractor con Discretatory suite Relations (c) Contractory Institutions (c) Contractory Institutions (c) Contractory	Contact Gel	Maximum Gap Covering	0.2mm
chroniem, Policitetti consul antrogen, Eric Borner, Tio Hanner, Eric Borner, Tio Hanner, Balance Borner, en Baner, Balance Britz, chi Tugan Baner,	Mana Mana Mana Mana Mana	Initial Adhesion on Aluminium	90-120 sec.
en A garante en Tala con entre en A garante de conservente del a sector y mon el la sec entre de conservente de la sector de l	Companying this bear Companying and a second Other synapses youth Although dis classical off	Initial Adhesion on Nora Test Rubber	20-30 sec.
	45 Ma 1 2 2007 30 9 ²	Initial Adhesion on Rigid PVC	40-80 sec.
		Final Strength After	24h
		Temperature Resistance	-50°C to +80°C (approx.) Squatting Temp.: +150°C
20gm Tube	30gm Pen		

VA 5000 THIX

Cyanoacrylate Adhesive for Rubber & Plastics - High Viscosity (thixotrop) - Extended Cure Time - Ethyl Ester Based

Weicon Contact Adhesive VA 5000 THIX has been specially designed for porous and absorbing materials. It is also used when large tolerances and gaps exist between the two bonding surfaces.

VA 5000 THIX is used for bonding metals, plastics and rubber and can even be used on vertical surfaces.

		Technical I	Data		
Available		Ester Type	Ethyl		
Sizes		Condition / Nature	Colourless, Clear Liquid		
1.2 gm		Viscosity at 20°C Brookfield	25,000 mPa (approx.)		
		Maximum Gap Covering	0.2mm		
30gm	tt D0 THIX D0 THIX Manual Manual Constants Constants	Initial Adhesion on Aluminium	30-70 sec.		
		Initial Adhesion on Nora Test Rubber	5-10 sec.		
60gm	Pere	Initial Adhesion on Rigid PVC	25-50 sec.		
500		Final Strength After	24h		
500gm		Temperature Resistance	-50°C to +90°C (approx.)		



VA 2500 HT

Cyanoacrylate Adhesive for Special Applications - High Temperature Resistant - High Viscosity -Slow Cure Time - Residual Elasticity after Curing - High Peel and Impact Resistance - Ethyl Ester Based

Weicon Contact Adhesive VA 2500 HT is highly viscous and resistant to temperatures up to 140°C. This grade hardens slowly with good residual elasticity and high peel and impact strength post curing.

VA 2500 HT is particularly well suited for bonding in changing climatic conditions. It exhibits low sensitivity to prolonged humidity exposure and bonds a diverse range of rubber, plastics and plastic/metal joints.

		Technical I	Data			
Available		Ester Type	Ethyl			
Sizes		Condition / Nature	Opaque			
12gm		Viscosity at 20°C Brookfield	2,000-3,000 mPa			
L Z SIII		Maximum Gap Covering	0.2mm			
30gm		Initial Adhesion on Aluminium	40-80 sec.			
With the state of	Initial Adhesion on Nora Test Rubber	25-60 sec.				
60gm	Consistency being Automation Solite operational regime in American de constraints from Martin and martin and and and	Initial Adhesion on Rigid PVC	25-100 sec.			
500.000	M W. 12200230 30 9	Final Strength After	24h			
500gm		Temperature Resistance	-50°C to +140°C (approx.) Squatting Temp.: +160°C			

VA 30 Black

Cyanoacrylate Adhesive for Special Applications - Rubber Filled - High Temperature Resistant - Ethyl Ester -Medium Viscosity - Slow Cure Time - Residual Elasticity after Curing - High Peel and Impact Resistance

Weicon VA 30 Black is resistant to temperatures up to 140°C. This grade has an extended cure time, is black in colour and rubber-filled. It cures with good residual elasticity and has high impact strength and peel resistance.

Like VA 2500 HT, VA 30 exhibits good resistance to changing climatic conditions. It is typically used for bonding a diverse range of rubber materials (e.g. solid or sponge rubber) , plastics, metals and metal/plastic joints.



Technical Data					
Ester Type	Ethyl				
Condition / Nature	Black				
Viscosity at 20°C Brookfield	300 mPa				
Maximum Gap Covering	0.2mm				
Initial Adhesion on Aluminium	40-50 sec.				
Initial Adhesion on Nora Test Rubber	5-10 sec.				
Initial Adhesion on Rigid PVC	5-10 sec.				
Final Strength After	24h				
Temperature Resistance	-55°C to +140°C (approx.) Squatting Temp.: +160°C				



VA 250 Black

Cyanoacrylate Adhesive for Special Applications - Rubber Filled - High Temperature Resistant - Ethyl Ester -High Viscosity - Slow Cure Time - Residual Elasticity after Curing - High Peel and Impact Resistance

Weicon Contact Adhesive VA 250 Black is highly viscous and withstands temperatures up to 140°C. This high quality, rubber-filled glue cures slowly with residual elasticity and has high peel and impact strength. As a result, parts bonded with VA 250 Black maintain their strong adhesion in demanding environments.

VA 250 Black is particularly suited for bonding in changing climatic conditions. It exhibits low sensitivity to prolonged humidity exposure and bonds a diverse range of rubber, plastics and plastic/metal joints.

		Technical D)ata			
Available		Ester Type	Ethyl			
51265		Condition / Nature	Black			
12gm		Viscosity at 20°C Brookfield	2,000-3,000 mPa			
30gm		Maximum Gap Covering	0.2mm			
	Initial Adhesion on Aluminium	90-120 sec.				
60gm	60gm	Initial Adhesion on Nora Test Rubber	20-40 sec.			
Bernard Be		Initial Adhesion on Rigid PVC	40-80 sec.			
500gm	An an spaceass 30 9	Final Strength After	24h			
		Temperature Resistance	-50°C to +140°C (approx.) Squatting Temp.: +160°C			

VA 1408

Cyanoacrylate Adhesive for Special Applications - Low Viscosity - Fast Cure Time - Low Odour -Reduced Blooming - Alcoxy Ethyl Based

Weicon Contact Adhesive VA 1408 has a low viscosity and a very fast cure time. This type exhibits less "blooming " during cure and is less susceptible to moisture after curing.

VA 1408 is designed for the clean and visually attractive bonding of a wide range of materials and substrates.

		Technical Data						
		Ester Type	Alkoxy					
Available Sizes		Condition / Nature	Colourless, Clear Liquid					
51265		Viscosity at 20°C Brookfield	20-40 mPa					
30gm	Maximum Gap Covering	0.1mm						
	Initial Adhesion on Aluminium	30-60 sec.						
60gm	Withold Reads Bandwidt Reije Raifty	Initial Adhesion on Nora Test Rubber	3-20 sec.					
	Initial Adhesion on Rigid PVC	10-30 sec.						
F O O am	4+40 1223 3355 (30 P ⁰	Final Strength After	24h					
Suugm		Temperature Resistance	-50°C to +80°C (approx.) Squatting Temp.: +150°C					



Cyanoacrylate Adhesive for Special Applications - Medium Viscosity - Extended Cure Time - Low Odour - Reduced Blooming - Alcoxy Ethyl Based

Weicon Contact Adhesive VA 1460 is a medium viscosity adhesive with a reduced "blooming" effect. Compared to VA 1408, this grade cures slower and whilst still being low odour and less impacted by moisture.

Like VA 1408, VA 1460 is typically used when a clean and optically attractive bond is required. It exhibits good adhesion to a variety of materials.

		Technical Data						
		Ester Type	Alkoxy					
Available Sizes		Condition / Nature	Colourless, Clear Liquid					
SILES	-	Viscosity at 20°C Brookfield	120 - 200 mPa					
30gm	Contact Two Spetres	Maximum Gap Covering	0.15mm					
	Initial Adhesion on Aluminium	30-60 sec.						
60gm	Provide Structure	Initial Adhesion on Nora Test Rubber	10-60 sec.					
	Initial Adhesion on Rigid PVC	20-150 sec.						
E O O am	4min.12250008 30 (F	Final Strength After	24h					
		Temperature Resistance	-50°C to +80°C (approx.) Squatting Temp.: +150°C					

VA 1403

Cyanoacrylate Adhesive for Special Applications - High Viscosity - Slow Cure Time - Low Odour - Reduced Blooming - Alcoxy Ethyl Based

Weicon Contact Adhesive VA 1403 is highly viscous, low odour and has a minimal "blooming" effect during cure. This grade hardens slowly and, like VA 1408 & VA 1460, is not overly impacted by humidity post cure.

VA 1403 is used for creating clear bonds between a large selection of different material types.



Technical Data					
Ester Type	Alkoxy				
Condition / Nature	Colourless, Clear Liquid				
Viscosity at 20°C Brookfield	1,100-1,800 mPa				
Maximum Gap Covering	0.2mm				
Initial Adhesion on Aluminium	90-120 sec.				
Initial Adhesion on Nora Test Rubber	5-30 sec.				
Initial Adhesion on Rigid PVC	10-120 sec.				
Final Strength After	24h				
Temperature Resistance	-50°C to +80°C (approx.) Squatting Temp.: +150°C				



VM 20 Cyanoacrylate Adhesive for Metals - Low Viscosity - Very Fast Cure Time - Methyl Ester Based

Weicon Contact Adhesive VM 20 has a low viscosity and a very fast cure time. This grade is used for a variety of metal bonding tasks; especially the adhering of precision fitted parts in serial production environments.

Because of this high bond strength and accelerated cure, VM 20 is widely use in the metal working industry, in machine construction, engineering and a variety of other applications.

		Technical D	ata		
A		Ester Type	Methyl		
Available Sizes		Condition / Nature	Colourless, Clear Liquid		
		Viscosity at 20°C Brookfield	20-40 mPa		
30gm		Maximum Gap Covering	0.1mm		
W 20 marganete	Initial Adhesion on Aluminium	50-70 sec.			
60gm	Housedad Sega Biology Organizations	Initial Adhesion on Nora Test Rubber	10-60 sec.		
1 (Sereaucystan Sandard) 10 ferensourcestan 14 Adaption to accument 14 Adaption to accument 14 Adaption to accument	Initial Adhesion on Rigid PVC	30-120 sec.			
500gm	41-41 1200010 30 V ⁶	Final Strength After	24h		
		Temperature Resistance	-50°C to +80°C (approx.) Short-term to 100°C Squatting Temp.: +150°C		

VM 120

Cyanoacrylate Adhesive for Metals - Medium Viscosity - Extended Cure Time, Short-Term Realignment of Parts is Possible - Methyl Ester Based

Weicon Contact Adhesive VM 120 is a medium viscosity grade of industrial glue with an extended cure time that allow for short-term position corrections of the parts being bonded.

This versatile grade is used for all kinds of metal bonding work and has wide application in the metalworking, engineering, machine construction and maintenance industries.

		Technical Data						
		Ester Type	Methyl					
Available Sizes		Condition / Nature	Colourless, Clear Liquid					
SIZES	-	Viscosity at 20°C Brookfield	100 - 130 mPa					
30gm	Maximum Gap Covering	0.15mm						
	Initial Adhesion on Aluminium	50-70 sec.						
60gm	financias reads 中中Acm Distance playablem	Initial Adhesion on Nora Test Rubber	10-60 sec.					
	Initial Adhesion on Rigid PVC	30-120 sec.						
500am	4140, 1200000 30 H ²	Final Strength After	24h					
		Temperature Resistance	-50°C to +80°C (approx.) Short-term to 100°C Squatting Temp.: +150°C					



VM 2000

Cyanoacrylate Adhesive for Metals - Higher Viscosity - Longer Cure Time, Allows Realignment of the Parts - Methyl Ester Based

Weicon Contact Adhesive VM 2000 is a highly viscous grade that hardens slowly. This allows the user to reposition the parts being bonded after initial application of the adhesive which results in a high precision bond.

VM 2000 is used for all kinds of metal bonds and can also be used on a variety of absorbent and porous materials.



Technical Data					
Ester Type	Methyl				
Condition / Nature	Colourless, Clear Liquid				
Viscosity at 20°C Brookfield	1,700-2,000 mPa				
Maximum Gap Covering	0.2mm				
Initial Adhesion on Aluminium	70-90 sec.				
Initial Adhesion on Nora Test Rubber	10-90 sec.				
Initial Adhesion on Rigid PVC	30-150 sec.				
Final Strength After	24h				
Temperature Resistance	-50°C to +80°C (approx.) Short-term to 100°C Squatting Temp.: +150°C				





Humid Climate Resistance







Type Selection Table

	VA 20	VA 8312	014 8406	VA 100	VA 110	VA 1401	VA 300	VA 1500	Gel	VA 5000 THIX	VA 2500 HT	VA 30 Black	VA 250 Black	VA 1408	VA 1460	VA 1403	VM 20	VM 120	VM 2000
Metal	+	+	+	++	+	++	+	+	+	+	+	+	+	+	+	+	++	++	++
Plastic*	++	+	++	++	++	++	++	++	+	++	++	++	++	++	++	++	+	+	+
Rubber	++	+	++	++	++	++	+	++	+	++	++	++	++	++	++	+	+	+	+
EPDM	+	+	++	+	+	++	+	+		+	+	+	+	+	+	+			
Wood	+			+	+	+	++	+	+	+	+	+	+	+		++			
Balsa-Wood		+	+	+	+	+	+	+	++	+	+	+	+	+		++			
Glass / Ceramic	+		+	++	+	++	++	+	++	+	+	+	+	++	+	+			
Leather		+		++	+	++	++	++	++	+	+	+	+	+	+	++			

+ Suitable ++ Highly Suitable

In line with the information in the table above, the bonding of two different materials (e.g. for metal/rubber or metal/plastic) is also possible.

*Refer to Combined Tension and Shear Resistance DIN 52283 Table Below for Type Information.



Combined Tension and Shear Resistance

Test Specimen (as per DIN 53281)	100mm / 25mm x 1.5mm thick
Adhesive:	Weicon Contact VA 8406
Overlapping:	12mm
Pre-Treatment:	Cleaned with Weicon Surface Cleaner and Roughening of Surface
Bonding	Normal Climate (DIN 50014), +23°C @ 50% Relative Humidity
Test Speed:	10mm / minute



General Processing Information

Use Instructions

- To ensure a perfect bond, the surfaces being joined must be clean and dry (Weicon Surface Cleaner is perfect for cleaning & degreasing).
- Smooth surfaces should be mechanically roughened.
- Apply Weicon Cyanoacrylate Adhesive to one (only) of the surfaces being bonded.
- The bond line should be between 0.05mm and 0.2mm (max.) in thickness. Otherwise complete curing may not occur.
- For bonding large surfaces Weicon Contact Adhesive should be applied drop by drop to avoid inner tensions.
- Weicon Contact Adhesive are very economical. One drop is sufficient to cover about 3-5cm² of bonding surface.
- The parts to be joined should be bonded in an atmosphere of 40-80% relative humidity. In conditions below 40% the cure will be slowed considerably or even inhibited.

With a relative humidity of greater that 80% (or with basic substrates such as glass) shock-curing can occur. In such cases some adhesive show a drop in bond strength.

 Basic reacting surfaces (pH value >7) will speed up the cure while acidic reacting surfaces will retard and, under extreme conditions, completely inhibit the polymerisation.

Health and Safety

Physiologically, Weicon Cyanoacrylate Adhesives may be considered as essentially harmless. However, please ensure sufficient ventilation of the workplace to cope with the adhesive's typical vapours.

Vapours of Weicon Contact Adhesives may cause irritation of the mucous membranes and the eyes. Avoid contact with skin and eyes (gloves and protective goggles are recommended). The use of Weicon Hand Protective Foam prevents skin irritation and hand cleaning problems.

More information on each grade is available on the relevant Safety Data Sheet (SDS).

Storage

Weicon Cyanoacrylate Adhesives should always be stored in a cool, dark and dry place. The shelf life is at least 9 months if stored in temperatures between $18^{\circ}C \& 25^{\circ}C$. If stored at $+5^{\circ}C$ the shelf life can be extended to a minimum of 12 months.

Weicon Pen System

The proprietary Weicon Pen-System (design patent # 001 59884) allows Weicon Cyanoacrylate Contact Adhesives to be easily, accurately, and economically dispensed.

This specially designed container can be held just like a regular pen which greatly improves accuracy during dosing. In addition, the sloped tips allow for cutting at just the right size while the sturdy base ensures that the adhesive container is easily placed on a workbench so that the potential for spillage is minimised. This base is also removable for greater usability of the pen whenever required.

All of the 12gm, 30gm and 60gm Contact Adhesives featured in this brochure are supplied in this unique bottle as standard. The 500ml options are supplied in bottles as a result of the extra volume.







Technical Data Weicon Cyanoacrylate Adhesives in Liquid State

		VA 20	VA 8312	VA 8406	VA 100	VA 1401	VA 300	VA 1500	Gel	VA 5000 THIX	VA 2500 HT	VA 30 Black	VA 250 Black	VA 1408	VA 1460	VA 1403	VM 20	VM 120	VM 2000
Ester Type			Ethyl Alkoxy Methyl																
Condition / Nature		Colourless, Clear Liquid. VA 2500 HT is Opaque. VA 30 & VA 250 are Black																	
Properties		Particularly suitable for rubber and plastic bonding								sty	Particularly suitable for rubber and plastic bonding			Low odour, low blooming			Particularly suited to bonding metals		
Viscosity at 20°C (m∙Pas) Brookfield		<20	20-40	20-50	60-120	100- 150	200- 300	1000- 1500	60000- 90000	20000- 30000	2000- 3000	250- 300	2000- 3000	20-40	120- 200	1100- 1800	20-40	100- 130	1700- 1200
Max. Gap Coverage (mm) **		0.1	0.1	0.1	0.15	0.15	0.15	0.2	0.2	0.2	0.2	0.2	0.2	0.1	0.15	0.2	0.1	0.15	0.2
Specific Gravity at 20°C (g/cm³)		1.04	1.05	1.05	1.06	1.06	1.07	1.08	1.08	1.05	1.06	1.06	1.06	1.06	1.02	1.1	1.1	1.1	1.12
Flash Point acc. In Abel- Pensky DIN 55213 in °C		87°C																	
Initial Adhesion* in Seconds	Aluminium¹	30-60	30-60	2-10	30-60	2-10	60-90	90-120	90-120	30-70	40-80	40-50	90-120	30-60	30-60	90-120	50-70	50-70	70-90
	Nora Test Rubber²	2-15	2-10	<5	3-20	<5	2-10	5-30	20-30	5-10	25-60	5-10	20-40	3-20	10-60	5-30	10-60	10-60	10-90
	Rigid PVC ³	5-60	5-30	2-10	10-60	2-10	10-60	10-120	40-80	25-50	25-100	5-10	40-80	10-30	20-150	10-120	30-120	30-120	30-150
Final Strength in Hours			24																

*Achieved in normal climatic conditions as per DIN 50014 (23°C, 50% relative air humidity). Within the given time period, handling strength can be achieved.

**These details are dependent on the type of material to be bonded and its properties

¹Aluminium, Type Al Cu Mg 2pl, not pre-treated ²NBR Rubber, smoothed ³Rigid PVC Trovidur® EN, not pre-treated





Technical Data Weicon Cyanoacrylate Adhesives in Cured State

		VA 20	VA 8312	VA 8406	VA 100	VA 110	VA 1401	VA 300	VA 1500	Gel	VA 5000 THIX	VA 2500 HT	VA 30 Black	VA 250 Black	VA 1408	VA 1460	VA 1403	VM 20	VM 120	VM 2000
Shear Strength in N/mm² acc. to DIN 53283 (ASTM D 1002 psi)	Sand Blasted Steel	19 (2.750)	20 (2.900)	22 (3.200)	20 (2.900)	20 (2.900)	22 (3.200)	21 (3.050)		22 (3.200)	24 (3.450)	22 (3.200)	24 (3.450)	18 (2.600)			25 (3.600)			
	Sand Blasted Aluminium	14 (2.050)	14 (2.050)	16 (2.300)	15 (2.175)	15 (2.175)	16 (2.300)		15 (2.175)		18 (2.600)	18 (2.600)	18 (2.600)	18 (2.600)	12 (1.750)				19 (2.750)	
	Rigid PVC	12 (1.750)	13 (1.900)	14 (2.050)	13 (1.900)	13 (1.900)	14 (2.050)	13 (1.900)			12 (1.750)	13 (1.900)	14 (2.050)	13 (1.900)	7 (1.000)			12 (1.750)		
	ABS	11 (1.600)	12 (1.750)	13 (1.900)	12 (1.750)	12 (1.750)	13 (1.900)	12 (1.750)		10 (1.450)	12 (1.750)	11 (1.600)	12 (1.750)		10 11 (1.450) (1.600			11 (1.600)		
	РС	12 (1.750)	13 (1.900)	13 (1.900)	13 (1.900)	13 (1.900)	13 (1.900)		12 (1.750)		12 (1.750)	13 (1.900)	13 (1.900)	13 (1.900)	8 (1.150)			12 (1.750)		
	NBR	>8 (1.150) - Bonding Strength Exceeds The Strength Of The Substrate																		
Temperature Resistance			-50 Short-)°C to +8 term to +	0°C -100°C		See Page 7	-50°C to +80°C Short-term to +100°C			See Page 9	-55°C to +140°C			-50°C to +80°C Short-term to +100°C					
Squatting Temperature				+150°C			+170°C		+150°C - +160°C +150°C											
Refractive Index n ^{D20}			1.49 (similar to glass) / for types VA 2500 HT, VA 30 Black and VA 250 Black not applicable																	
Linear Thermal Expansion			80 x 10 ⁻⁶																	
Specific Forward Resistance DIN			>10 ¹⁵																	
Dielectric Strength, DIN 53481 /			25																	
Thermal Conductivity ISO 8894-2 /											0.1									
Solubility		Dimeth	imethyl formamide, dimethyl sulfoxide, acetonitrile, alkali. Swelling is possible after long-term storage in ethyl acetate, acetone and methylene chloride.																	









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