

# Contact GEL



Cyanoacrylate Adhesive for special requirements  
 pasty (highly thixotropic)  
 very slow-curing = position correction

Contact GEL is pasty (highly thixotropic 60000 - 90000 mPa·s) and hardens very slowly. By using WEICON Activator Spray, the cure time can be reduced.

WEICON Contact GEL is suited for porous surfaces and higher tolerance gaps and can be used on vertical surfaces. Positioning is also possible after the parts have been joined.

WEICON Contact Gel is suited for the bonding of the most diverse products. WEICON Contact Gel can be used both in the hobby sector and in model building. It can also be used in many different industrial applications.

ISSA: 75.629.07  
 IMPA: 81 52 61

## Technical data

Ester type	Ethyl
Condition / nature	colourless, clear liquid
Viscosity at +20 °C Brookfield	60.000-90.000 mPa·s
Max. gap covering	0,2 mm
Specific gravity at +20 °C	1,08 g/cm <sup>3</sup>
Initial adhesion on Aluminium	90-120 sec.
Initial adhesion on Nora test rubber	20-30 sec.
Initial adhesion on Rigid PVC	40-80 sec.
Final strength after	24 h
Temperature resistance	-50 bis ca. +80 Erweichungstemp. +150 °C

## Pretreatment of the surface

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 >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.

## 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.

## Health and Safety

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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