

Cyanoacrylate adhesives

DELO[®]-CA



**Instructions for use &
General information
on the product group**

Application areas

DELO[®]-CA products are 1-component adhesives based on cyanoacrylic acid esters curing through contact with air humidity.

DELO[®]-CA is preferably used for bonding plastics and elastomers (e. g. rubber) as well as for fast fixing of metals.

Preparation of the components to be bonded

The contact surfaces must be free of oil, grease and other contaminations in order to achieve optimal bond strength. We provide our cleaners DELOTHEN. You can draw more detailed information from the technical information "DELOTHEN Cleaners".

After cleaning, adhesion to the component can be further improved by means of surface pretreatment. You can draw additional details from the written information on surface pretreatment.

The suitability and strength of the adhesive are to be verified on original components under application-specific conditions.

Processing

The products are supplied ready for use. Depending on the type of delivery, they can be processed manually directly from the container or by means of DELO[®] dispensing units DELOMAT[®]. In the majority of cases, the adhesive is applied to only one component. After applying the adhesive, the joining process and possibly fixing must proceed speedily as the products start to cure already through the humidity present in the ambient air or condensed humidity on the component surfaces.

Curing

DELO[®]-CA adhesives cure under the influence of humidity. The condensation available on the component surface is normally sufficient.

Curing conditions are ideal at a relative humidity of 40 – 70 %. If the relative humidity is lower, e. g. in winter in heated rooms, curing may be delayed or, in extreme cases, even be prevented.

For bonding plastics which are difficult to bond, that is to say nonpolar types, the primer DELO[®]-PRE 2005 is specifically recommended for CAs. Apply the primer and, after complete evaporation, the adhesive.

If the normally very fast curing is delayed or disrupted by factors such as e. g. an oversized bonding gap, a porous surface or an open bond, the use of DELO[®]-QUICK 2002 is specifically recommended for CAs.

Apply this activator to the porous or more inactive surface; after evaporation of DELO[®]-QUICK 2002, the adhesive can be usually applied to the second component. In order to accelerate curing for open applications, the activator is sprayed directly onto the adhesive.

You can draw the detailed, product-specific information on the processing of each product from the respective technical data sheet.

Instructions and advice for occupational health and safety

see material safety data sheet

Storage

In unopened container.

Cool storage is recommendable.

Storage life: see technical data sheet

General

The data and information provided are based on tests performed under laboratory conditions. Reliable information about the behavior of the product under practical conditions and its suitability for a specific purpose cannot be concluded from this.

It is the user's responsibility to test the suitability of the product for the intended purpose by considering all specific requirements. Type and physical and chemical properties of the materials to be processed with the product, as well as all actual influences occurring during transport, storage, processing and use, may cause deviations in the behavior of the product compared to its behavior under laboratory conditions. All data provided are typical average values or uniquely determined parameters measured under laboratory conditions.

The data and information provided are therefore no guarantee for specific product properties or the suitability of the product for a specific purpose.

If you have any further questions

Please contact us.

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