

DELO

Instructions for Use & General Information on the Product Group

DELO®-CA

Cyanoacrylates



Application areas

DELO®-CA are one-component adhesives on the basis of cyanoacrylic acid esters. They cure by contact with air humidity.

DELO®-CA adhesives are preferably used for bonding plastics and elastomers (such as 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 DELOTHEN cleaners. You can find more details in the “DELOTHEN Cleaners” technical information.

After cleaning, adhesion to the component can be further improved by surface pretreatment, which is described in the section “Curing”. You can find further information in the written information on surface pretreatment.

Before bonding, the components must be conditioned to room climate (temperature and air humidity).

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 scope of delivery, they can be processed manually directly from the container or by means of DELO® dispensing units (e.g. pinch valve).

The adhesive is applied to only one component to be bonded. After adhesive application, the components are to be joined and possibly fixed speedily as curing of the adhesives is already triggered by the humidity available in the ambient air or condensing on the bonding surfaces.

Opened containers with DELO®-CA must be used up within 4 weeks. It must be ensured that the adhesive stock remains closed so that no humidity can enter the containers.

Dispensing valves and product-guiding parts should be thoroughly cleaned before adhesive use. Residues of other products must be removed without leaving any residue. It is recommended that all product-guiding parts are made of non-polar plastics. As it is normally not or only hardly possible to clean product-guiding parts after using adhesives on the basis of cyanoacrylic acid esters, it is recommended to dispose of them after use. You can find more details in our technical information on equipment cleaners.

Curing

DELO-CA adhesives cure at room temperature under the influence of air humidity. Normally, the humidity on the component surfaces is sufficient.

Ideal curing conditions are a relative humidity of 40 % to 80 % at approx. +73.4 °F (+23 °C). If the relative humidity is lower, for example in winter in heated rooms, curing may be delayed or, in extreme cases, even be prevented.

For bonding plastics difficult to bond, that is to say non-polar types, the DELO®-PRE 2005 primer can improve adhesion and is specifically recommended for DELO®-CA adhesives. Apply the primer and, after complete evaporation, the adhesive.

If the normally very fast curing is delayed or disrupted by factors such as an oversized bonding gap, a porous surface or an open joint, the use of DELO®-QUICK 2002 is possible.

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

You can find the detailed, product-specific information on the processing of each product in the specific Technical Data Sheet.

Instructions and advice for occupational health and safety

See Material Safety Data Sheet

Storage

In unopened original container

Cool storage is recommendable.

Storage life: see Technical Data Sheet

CONTACT

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