

TECHNICAL INFORMATION

BEST-CA-114/1

BEST-CA-114/1 is a one component, solvent free cyanoacrylate adhesive based on ethyl-cyanoacrylate.

BEST-CA-114/1 is recommended for bonding of plastics like Polyamid, PVC, PMMA, styrofoam and certain elastomers like rubber, EPDM, Vitons among each other and with metal and wood.

BEST-CA-114/1 is very fast curing. After full cure heat-resistant and very strong bonding properties:

BEST-CA-114/1 is supplied ready to use and best applied from the original container.

BEST-CA-114/1 is applied spot-wise or bead-like. Immediately afterwards the components should be joined by applying short and firm pressure. The polymerization process of the adhesive starts within a few seconds. Fixture time for almost all bond parts is 8 to 15 seconds. Curing after 30 minutes with 85 % and full cure after 20 hours. A relative humidity of 40 – 60% is needed for optimum curing. Below 40 % humidity the bonding reaction can be delayed. Bond surfaces should be dry, clean and free from grease and other contaminants. The adhesion of the bond surfaces can be improved by sand-blasting, grinding or staining.

PROPERTIES (liquid product)

Chemical Type	Ethyl-cyanacrylate
Curing system	air-humidity
Colour	colourless to yellow
Density (DIN EN 542)	1,09 x 10³ kg/m³
Max. gap filling property of adhesive	0,15 mm
Shelf life in unopened original (Storage temperature at 10 to 23°C)	6 months

CURING TIME @ 23°C

Fixture time	10 - 15 sec.
Functional strength	30 min.
Total curing time	20 hrs.



STRENGTH VALUES (cured product)

Tensile/shear strength Al/Al (DIN 53283)

25,2 N/mm²

Operating temperature

Permanent

Short time

up to +100°C

up to +120°C

ENVIRONMENTAL AND CHEMICAL RESISTANCE

BEST-CA show a good resistance against changing climate conditions and chemical influences.

Health and safety standards

Hazard Statements: Causes skin irritation. Causes serious eye irritation. May cause respiratory irritation. Please see EU – Safety Data Sheet for further information.

General

The data and information above correspond to the current know-how of BEST-Klebstoffe GmbH & Co.KG. Our information and data have been developed from laboratory tests and extensive practical experience. It is the user's responsibility to perform receiving inspections and to determine suitability for the user's purpose of any production methods. We disclaim all warranties expressed or implied, that any product will have specific properties for a particular purpose.

BEST-Klebstoffe GmbH & Co. KG reserves the right to change the contents of this document as necessary.

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