



TECHNICAL INFORMATION

BEST-CA 221

BEST-CA 221 is a one-component, solvent free cyanoacrylate adhesive based on ethyl-cyanoacrylate.

BEST-CA 212 is the standard product for bonding of plastics, e.g. polyamide, PVC, PMMA and various elastomers, e.g. rubber, EPDM and Viton amongst each other and with metals and wood.

BEST-CA 221 is very fast cure. After full cure the adhesive is high strength and temperature resistant.

BEST-CA 221 is ready-to-use and can be applied from the original container.

BEST-CA 221 is applied spot-wise or bead like. Assemble parts by using short, firm pressure. Curing process starts within seconds. On most materials fixture time is reached within 5 to 10 seconds. 85 % of final cure is reached after 30 minutes, 100% after 20 hours. The rate of cure depends on the ambient relative humidity. A relative humidity of 40 to 60% will lead to best results. Lower values may delay cure.

Bonding surfaces must be dry, free of dust and grease as well as other contaminants. Sand-blasting, grinding and staining bonding surfaces will enhance adhesion on bonding surfaces.

PROPERTIES (liquid product)

Chemical type	Ethyl-cyanoacrylate
Curing system	Humidity
Appearance	Colourless to yellowish
Viscosity (Brookfield)	100 mPas
Density (DIN 51757)	1,09 x 10 ³ kg/m ³
Max. gap filling	0,05 mm
Shelf life <small>(Storage in unopened original container at 10°C up to 23°C)</small>	6 months
<u>Curing time @23°C</u>	
Fixture time	5 to 10 seconds
Functional strength	30 minutes
Final strength	20 hours



STRENGTH VALUES (cured product)

Tensile shear strength (DIN 53283) 20 N/mm²

TEMPERATURE RANGE

short-term exposure 120°C
long-term exposure 100°C

CHEMICAL AND ENVIRONMENTAL RESISTANCE

BEST-CA adhesives show good resistance to changing climatic conditions and chemical influences.

HEALTH AND SAFETY STANDARDS

Cyanoacrylate. Danger! Adheres skin and lids within seconds. Keep product out of reach of children. Vapour irritates mucous membranes. Ensure proper ventilation. For constant or long term use vapour extraction is recommended. For further information please see corresponding EG-material safety data sheets.

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.

Revision: 130527
Revision Date: 27.05.2013