

TECHNICAL INFORMATION

BEST-CA 224

BEST-CA 224 is a one-component, solvent free cyanoacrylate adhesive based on ethyl-cyanoacrylate.

BEST-CA 224 is the standard product for bonding of plastics, e.g. polyamide, PVC, PMMA and various elastomeres, e.g. rubber, EPDM and viton amongst each other and with metals and ceramics.

BEST-CA 224 is very fast cure. After full cure the adhesive is high strength and temperature resistant.

BEST-CA 224 is ready-to-use and can be applied from the original container.

BEST-CA 224 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 10 to 15 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)	400 mPas
Density (DIN EN 542)	1,09 x 10 ³ kg/m ³
Max. gap filling	0,07 mm
Shelf life in unopened original (Storage temperature at 10°C to 23°C)	6 months



CURING TIME @ 23°C

Fixture time	10 to 15 seconds
Functional strength	30 minutes
Final strength	20 hours

STRENGTH VALUES (cured product)

Tensile shear strength (DIN 53283)	17 N/mm ²
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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

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 were 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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