

TECHNICAL INFORMATION

BEST-CA 422

BEST-CA 422 is a one-component, solvent free cyanoacrylate adhesive based on alkoxy-ethyl-cyanoacrylate.

BEST-CA 422 is the standard product for bonding of plastics, e.g. polyamide, PVC, PMMA, and various elastomers, e.g. rubber, EPDM and Viton among each other and with metals and ceramics. The product does not bloom and does not leave a white residue even on black materials. The product is also almost odourless.

BEST-CA 422 is very fast cure. After full cure the adhesive is high strength and temperature resistant.

BEST-CA 422 is ready-to-use and can be applied from the original container.

BEST-CA 422 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

15 to 35 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)

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| Chemical type | Alkoxy-ethyl-cyanoacrylate |
| Curing system | Humidity |
| Appearance | Colourless to yellowish |
| Viscosity (Brookfield) | 200 mPas |
| Density (DIN EN 542) | 1,09 x 10 ³ kg/m ³ |
| Max. gap filling | 0,15 mm |
| Shelf life in unopened original (Storage temperature 10°C to 23°C) | 6 months |



CURING TIME @ 23°C

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|---------------------|------------------|
| Fixture time | 15 to 35 seconds |
| Functional strength | 30 minutes |
| Final strength | 20 hours |

STRENGTH VALUES (cured product)

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| Tensile shear strength (DIN 53283) | 13 N/mm ² |
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| <u>TEMPERATURE RANGE</u> | -50°C – +80°C |
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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 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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