



## TECHNICAL INFORMATION

### BEST-CA 432

**BEST-CA 432** is a one-component, solvent free cyanoacrylate adhesive based on alkoxy-ethyl-cyanoacrylate.

**BEST-CA 432** 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 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 432** is very fast cure. After full cure the adhesive is high strength and temperature resistant.

**BEST-CA 432** is ready-to-use and can be applied from the original container.

**BEST-CA 432** 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)

Chemical type	Alkoxy-ethyl-cyanoacrylate
Curing system	Humidity
Appearance	Colourless to yellowish
Viscosity (Brookfield)	1500 mPas
Density (DIN 51757)	1,09 x 10 <sup>3</sup> kg/m <sup>3</sup>
Max. gap filling	0,15 mm
Shelf life (Storage in unopened original container at 10°C up to 23°C)	6 months
<u>Curing time @23°C</u>	
Fixture time	15 to 35 seconds
Functional strength	30 minutes
Final strength	20 hours



**STRENGTH VALUES (cured product)**

Tensile shear strength (DIN 53283) 12 N/mm<sup>2</sup>

**TEMPERATURE RANGE** -50°C – +80°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