

DELO-CA® 2219

Cyanoacrylate, superglue

Base

- ethyl ester
- one-component, solvent-free

Curing

- a relative humidity of 40 - 80 % is required for optimal curing

Use

- multi-purpose for rubber, plastic and metal bondings
- even bridges small unevennesses
- the product is normally used in a temperature range of -40 °C to +100 °C; depending on the application, other limits may be more reasonable

Processing

- supplied ready for use and can be applied well from the original container or with DELO dispensing units
- surfaces to be bonded should be dry, free of dust, grease and other contaminations
- the short processing time requires fast adhesive processing
- use DELOTHEN cleaners for cleaning
- further improvement of the bond strength by sand blasting, grinding, or etching.
- plastics difficult to bond can be pretreated with primer DELO-PRE 2005
- for acceleration of curing use activator DELO-QUICK 2002

Resistance

- Elastomers (e. g., synthetic rubber) or plastics known to be bondable are preferably bonded with DELO-CA adhesives. DELO-CA shows good resistance to changing climatic conditions and chemical influences. An extremely fast curing reaction can lead to tension superposition when bonding materials with solid structure (e. g., metal), influencing the permanent resistance of the bondings.

Technical data

Color	colorless
Max. gap filling capacity [mm]	0.04
Density [g/cm ³] at room temperature (approx. 23 °C)	1.1
Viscosity [mPas] at 23 °C, Brookfield spm 3/10	240
Curing time until firmness to touch [s] tensile shear strength 1 - 2 MPa	5 - 10

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Curing time until final strength [h] at room temperature (approx. 23 °C), 50 % relative humidity	20
Tensile shear strength Al/Al [MPa] DIN EN 1465, sand-blasted component thickness: 1.6 mm after 72 h at room temperature (approx. 23 °C)	17
Tensile shear strength PC/PC [MPa] DIN EN 1465 component thickness: 4 mm after 72 h at room temperature (approx. 23 °C)	7
Flash point [°C] DIN 53213	83
Specific volume resistance [Ωcm] VDE 0303, part 3	> 1xE13
Dielectric constant VDE 0303, part 4	5.2
Storage life at room temperature (max. 25 °C) in unopened original container	6 months

Performance under temperature influence

Tensile shear strength Al/Al based on initial value at room temperature
DIN EN 1465, sand-blasted, component thickness: 1.6 mm

Temperature influence	Tensile shear strength Al/Al [%]
after storage 100 h at 100 °C measured at room temperature (approx. 23 °C)	71
after storage 500 h at 100 °C measured at room temperature (approx. 23 °C)	35
measured at 100 °C	65

Instructions and advice

General

The data and information provided are based on tests performed under laboratory conditions. Reliable information about the behavior of the product under practical conditions and its suitability for a specific purpose cannot be concluded from this.

Many product properties are subject to temperature and may change permanently, especially at high temperatures.

It is the user's responsibility to test the suitability of the product for the intended purpose and temperature range of use by considering all specific requirements. Type and physical and chemical properties of the materials to be processed with the product, as well as all actual influences occurring during transport, storage, processing and use, may cause deviations in the behavior of the product compared to its behavior under laboratory conditions. All data provided are typical average values or uniquely determined parameters measured under laboratory conditions.

The data and information provided are, therefore, no guarantee for specific product properties or the suitability of the product for a specific purpose.

Instructions for use

The instructions for use of DELO-CA are available on: www.DELO.de. We will be pleased to send them to you on demand.

Occupational health and safety

see material safety data sheet

Specification

see quality assurance test report