

DELO-CA® 2725

Cyanoacrylate, Instant-Glue

Base

- ethyl ester
- one-part, solvent-free

Curing

- a relative humidity of 40 - 80 % is needed for optimum curing

Use

- universally usable for rubber, plastic and metal bonds
- does even level out small irregularities

Application

- supplied ready to use and best applied from the original container or with DELO dispensing units
- surfaces to be bonded should be dry, free from dust, grease and other contaminants
- due to the short handling time the joining process should be performed immediately
- DELOTHEN cleaners are recommended for cleaning
- adhesion to the joint parts can be further improved by sand-blasting, abrading or pickling
- hard-to-bond plastics can be pretreated with primer DELO-PRE 2005
- to accelerate the curing use activator DELO-QUICK 2002

Resistance

- With DELO-CA adhesives preferable elastomers (e. g. synthetic rubber) or as bondable known plastics are bonded. DELO-CA shows a good resistance against cyclic climatic conditions and chemical influences. Extremely quick curing reaction may lead to tension superimposition concerning bonding structural materials (e. g. metal). This, however, possibly influences continuous stability of the bonding

Technical data

colour	colourless
max. gap filling property of adhesive [mm]	0.05
density [g/cm ³] at room temperature (approx. 23 °C)	1.1
viscosity [mPas] at 23 °C, brookfield sp/rpm 3/10	280
curing time until firmness to touch [s] tensile/shear strength 1 - 2 MPa	10 - 15
curing time until final strength [h] at room temperature (approx. 23 °C), 50 % relative humidity of air	20

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tensile/shear strength Al/Al [MPa] DIN EN 1465 join part thickness: 1.6 mm after 72 h at room temperature (approx. 23 °C)	14
tensile/shear strength PC/PC [MPa] DIN EN 1465 join part thickness: 4 mm after 72 h at room temperature (approx. 23 °C)	6
flash point [°C] DIN 53213	> 85
recommended long-time temperature range of use [°C]	-40 to +100
short-time temperature of use [°C]	+120
specific volume resistance [Ω cm] VDE 0303, part 3	5.31xE14
dielectric constant VDE 0303, part 4	5.2
storage life at room temperature (approx. 23 °C) in unopened original container	6 months

Recommendations

General

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

It is the user's responsibility to test the suitability of the product for the intended purpose 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 behaviour of the product compared to its behaviour under laboratory conditions. All data provided are typical average values or uniquely determined parameters measured under laboratory conditions.

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Instruction for use

The instruction for use is available under following address: www.DELO.de. If requested we will also be pleased to send it to you.

Industrial health and safety standards

see material safety data sheet

Specification

see quality assurance certificate