

### **DELO-CA® 2505**

Cyanoacrylate, superglue

#### **Base**

- modified ethyl ester
- one-component, solvent-free

#### **Use**

- multi-purpose for rubber, plastic and metal bondings
- especially for rubber types such as EPDM, Viton, NBR, CR, SBR, NR
- 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
- compliant with RoHS directive 2002/95/EC

#### **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

#### **Curing**

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

#### **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]	0.03
Density [g/cm <sup>3</sup> ] at room temperature (approx. 23 °C)	1.1
Viscosity [mPas] at 23 °C, Brookfield rpm 3/100	20

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<b>Curing time until initial strength [s]</b> tensile shear strength 1 - 2 MPa at room temperature (approx. 23 °C), 50 % relative humidity	5 - 10
<b>Curing time until final strength [h]</b> at room temperature (approx. 23 °C), 50 % relative humidity	20
<b>Tensile shear strength Al/Al [MPa]</b> DIN EN 1465, sand-blasted component thickness: 1.6 mm after 72 h at room temperature (approx. 23 °C)	17
<b>Tensile shear strength PC/PC [MPa]</b> DIN EN 1465 component thickness: 4 mm after 72 h at room temperature (approx. 23 °C)	7
<b>Specific volume resistance [<math>\Omega\text{cm}</math>]</b> VDE 0303, part 30	>1xE13
<b>Dielectric strength [kV/mm]</b> DIN EN 60243, part 1	11
<b>Dielectric constant</b> VDE 0303, part 4	5.2
<b>Storage life</b> at room temperature (max. 25 °C) in unopened original container	6 months
<b>Performance under temperature influence</b> 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)	65
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](http://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