

Two-component cyanoacrylate adhesive (superglue)

Application areas	<p>Fast, highly viscous (gel-like) and gap-bridging two-component adhesive with versatile application possibilities in the entire construction, assembly and industrial sector</p> <ul style="list-style-type: none"> ▪ for bonding and mounting rubber materials of all kinds, including sponge rubber, many plastics like EPDM Ethulene-Propylene-Dien-Monomer, EPDM, NBP, CR, SBR, NR, ABS, PMMA, PS, PC and PVC-hard with each other and among themselves ▪ especially recommended for overhead work and vertical surfaces ▪ good adhesion even on common materials like glass, ceramics, metals, leather, cork, wood etc. ▪ ideal for handicraft and industry 				
Product benefits	<ul style="list-style-type: none"> ▪ universally applicable ▪ in contrast to 1-component instant adhesives, Wisacoll AC 22.2K is able to bridge gaps of up to 2 mm in width; larger gaps / layer thicknesses are possible, but require prior material and application-related testing, as the adhesive can become too hot with large layer thicknesses ▪ highly viscous ▪ non-dripping ▪ fast ▪ high-strength ▪ mechanically reworkable ▪ low shrinkage ▪ solvent-free ▪ fast polymerising adhesive layer 				
Base	modified cyanoacrylates				
Restrictions	<p>Although the bonds of cyanoacrylate adhesives are moisture resistant, constant direct exposure to water should be avoided as this will significantly reduce the strength of the bond and over time it will no longer be guaranteed. Not suitable for PE, PP, PTFE (Teflon®), bitumen and waxy substrates.</p>				
Density	<table border="0"> <tr> <td>Binder (A-component)</td> <td>ca. 1.06 g/cm³</td> </tr> <tr> <td>Hardeners (B-component)</td> <td>ca. 1.15 g/cm³</td> </tr> </table>	Binder (A-component)	ca. 1.06 g/cm ³	Hardeners (B-component)	ca. 1.15 g/cm ³
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Hardeners (B-component)	ca. 1.15 g/cm ³				
Shore hardness	ca. 35 Shore-D or ca. 90 Shore-A				
Mixing ratio	parts by volume (A:B = 4:1)				
Viscosity	<table border="0"> <tr> <td>Binder (A-component)</td> <td>ca. 200'000 mPa*s (at +23 °C)</td> </tr> <tr> <td>Hardeners (B-component)</td> <td>ca. 75 mPa*s</td> </tr> </table> <p>The viscosity during processing at 15 °C is about twice as high as at +25 °C.</p>	Binder (A-component)	ca. 200'000 mPa*s (at +23 °C)	Hardeners (B-component)	ca. 75 mPa*s
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Processing temperature	from +5 °C until +35 °C, optimal +23 °C				
Open time (unjoined)	ca. 3 - 4 min (depending on preparation quantity / layer thickness)				

Max. processing time in static mixer	max. 3 min (at +20 °C); the processing time of Wisacoll AC 22.2K is approx. halved at +30 °C and approx. doubled at +10 °C. Within this time, the adhesive MUST be completely renewed in the static mixer to ensure a perfect mixture. If the work is interrupted beyond this time, it is therefore essential that the static mixer be replaced!			
Temperature resistance	from -40 °C until +100 °C (the adhesive softens at higher temperatures)			
Electrical properties	Dielectric strenght (DIN 52481)	ca. 10 - 13 kV/mm		
	Dielectric constant ϵ at a frequency of 1 MHz (DIN 53482)	ca. 5.3		
Gap filling capacity	ca. 0 - 5 mm (optimal 0 - 2 mm)			
Flash point	+87 °C			
Tensile shear strength	Metals	N/mm²	Plastics	N/mm²
indicative values acc. to ISO 4587	steel	ca. 17	PC	ca. 11
	steel, sand blasted	ca. 19	ABS	ca. 12
	stainless steel	ca. 15	PMMA	ca. 10
	aluminium	ca. 6		
			Timbers	N/mm²
			pine wood	ca. 13
			beechwood	ca. 15
Fixing time indicative values	Metals ca. 5 - 10 s	Plastics ca. 10 - 90 s	Timbers ca. 7 - 45 s	
	Fixing time, working time, open time etc. can only be determined precisely by carrying out your own tests, as they are strongly influenced by the substrate, temperature, application quantity, application quantity and other criteria. The times given are purely indicative. We recommend allowing for appropriate safety margins.			
Final strenght	ca. 8 h at 23 °C until final strength is achieved			
Processing	The bonding surfaces must be sound, dry and free of dust and grease. Wisatyp TL 16 and Wisaclean R 101 have proved their worth in practice for the cleaning of the majority of adhesive surfaces. For PVC surfaces we recommend Wisaclean R 101. Our wide range of professional cleaners are described in detail on our website. In addition, the bonding surfaces can also be sanded immediately beforehand (metals) or cut (recommended for rubber).			
	<ul style="list-style-type: none"> ▪ Insert the supplied double plunger into the 2C cartridge ▪ Remove the sealing cap and squeeze out the cartridge until both components emerge evenly ▪ Attach the static mixer to the cartridge and dispense a small bead onto a test piece to ensure that both components are mixed correctly ▪ Apply the adhesive and join the parts immediately; after use, remove the static mixer, dispose of it and ensure that the adhesive components are not mixed at the outlet ▪ Close the cartridge ▪ Store in a cool and dry place! 			

Cleaning

Uncured Wisacoll AC 22 is cleaned with Wisaclean R 216 (fast evaporating) or Wisatyp SA solvent (slow evaporating). The cured product can normally only be removed mechanically. To wash your hands, please use water and soap.

Further information



You can find more information about this product (link to the product on our homepage, safety data sheet, certificates, special enquiries etc.) under the adjacent ISOPIN QR code.

Colours

Binder (A-component)	transparent
Hardeners (B-component)	whitish
Mixture (cured film)	milky-white until cloudy cream-coloured

Item no.

AC 22.2K - double syringes à 10 g (Side-by-Side)
No application gun required thanks to the supplied plunger.

Please always order micro static mixers separately!

Delivery form

CTN à 10 double syringes à 10 g

Shelf life

In closed original packaging, protected from direct sunlight, stored in a cool, dry place between +2 °C and +10 °C and at an optimum humidity of between 50 % and 60 %, the official shelf life is 9 months from date of production.
Over storage time, viscosity increases and reactivity decreases.

Accessories good to know...

Item no.	Brief description
SM.10	Micro static mixer for AC 22.2K Orange elements (16S), conical nozzle

Safety and disposal: Familiarise yourself with the valid Safety Data Sheets (SDS) for the products used. All applicable safety regulations and disposal instructions must be observed.

Observe: All information is based on careful examinations in the labs and our previous practical experience. They are non-committal notes. Due to the many materials that are marketed and the different processing methods, which we cannot influence, we can, of course, not assume any warranty, including under patent-law, for the result of your work. We recommend performing sufficient own tests to find out if the product meets the respective requirements. In addition, we refer to our terms and conditions of sale, delivery and payment, available at www.wisabax.ch/agb.html. © Wisabax AG - This technical data sheet replaces all older versions.

Have you noticed an unclear formulation or an error? Thank you for your feedback. In case of doubt, the German version of the technical data sheet applies.