

## **Epoxy Resin Systems**

## **Plastic Metal**

## **WEICON C**



#### aluminium-filled | high temperature resistance

WEICON C is a temperature-resistant and flowable epoxy resin system especially for industrial use. The adhesive is non-corrosive, anti-magnetic and cures practically without shrinkage.

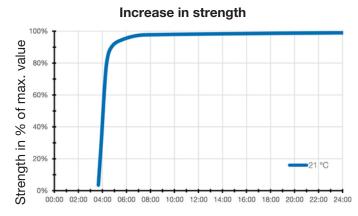
WEICON C is particularly suitable as an adhesive for largescale applications, for pouring out moulds and for the production of fixing devices and tools (e.g. injection moulds). It can be used in the tool and mould making sector as well as in many other industrial areas subjected to high thermal stress.

#### Characteristics

	Epoxy
	aluminium
	flowable
	grey
at room temperature	24 mon.
	+15°C to +40°C
	>3 °C above dew point
	< 85 %
	100:11
	100:20
at +25 °C	~35.000 mPa·s
	1,6 g/cm <sup>3</sup>
Layer thickness 1.0 mm	1,6 kg/m²
per step	10 mm
	at +25 °C Layer thickness 1.0 mm

Curing		
Pot life	at 20 °C, 500 g batch	60 min.
Additional layer after	(35 % strength)	4 h
Working strength after	(80 % strength)	6 h
Final strength	(100 % strength)	12 h
Shrinkage		0,07 %
Mechanical properties after o	uring	
- Measured after curing at		24 h RT + 14 h +120 °C
Tensile strength	DIN EN ISO 527-2	50 MPa
Elongation at break (tensile)	DIN EN ISO 527-2	0,9 %
E-modulus (tensile)	DIN EN ISO 527-2	6400-7500 MPa
Compressive strength	DIN EN ISO 604	174 MPa
E-modulus (pressure)	DIN EN ISO 604	6200-6700 MPa
Bending strength	DIN EN ISO 178	83 MPa
Hardness (Shore D)	DIN ISO 7619	89±3
Adhesive strength	DIN EN ISO 4624	25 MPa
Taber Test	DIN ISO 9352 (H18, 1 kg, 1000 rotations)	1,3 g / 0,8 cm <sup>2</sup>
Lap shear strength material thic	kn. 1,5mm DIN EN 1465	
Steel 1.0338 sandblas	ted	15 MPa
Stainless steel V2A sa	ndblasted	16 MPa
Aluminium sandblaste	d	8 MPa
Galvanized steel		6 MPa
Thermal parameters		
Temperature resistance		-80°C to +220°C
Tg after curing at room temperature	(DSC)	~ +58 °C
Tg after tempering (at 120°C)	(DSC)	+120 °C
Heat deflection resistance	DIN EN ISO 75-2 (*after tempering)	+60 °C/+108 °C
Thermal expansion coefficient	ISO 11359	40·60^-6 K^-1 1, m·k
Thermal conductivity	DIN EN ISO 22007-4	0,65 W/m·k
Heat capacity	DIN EN ISO 22007-4	0,96 J/(g·K)
Electrical parameters		
Resistance	DIN EN 62631-3-1	2,11·10^14 Ω·m
Magnetic		no
Approvals / Guidelines		
ISSA Code		75.509.07/08
IMPA Code		812903/04
MIL-Spec	complies with	MIL-A-47284A

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Time in hours

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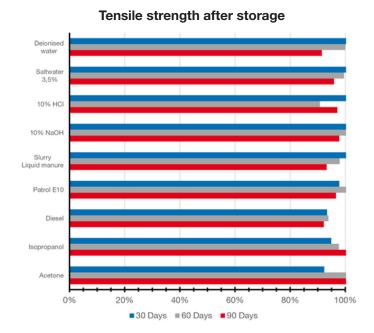
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## WEICON

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#### Instructions for use

When using WEICON products, the physical, safety-related, toxicological and ecological data and regulations in our EC safety data sheets (www.weicon.com) must be observed.

#### **Surface Pre-Treatment**

The successful application of WEICON C depends on the thorough preparation of the surfaces. This is the most important factor for overall success. Dust, dirt, oil, grease, rust and moisture or wetness have a negative impact on the adhesion. Therefore, before processing WEICON C, the following points must be observed: The areas to be bonded or repaired must be free of any oil, grease, dirt, rust, oxides, paint and other impurities or residues. For cleaning and degreasing, we recommend WEICON Cleaner Spray S.

Smooth and particularly heavily soiled surfaces should additionally be treated by mechanical surface pre-treatment, e.g. by grinding or preferably by blasting. In case of blasting, the surface should be brought to a degree of purity of SA 2 ½ - "Near White Blast Cleaning" (according to ISO 8501/1-2, NACE, SSPC, SIS). In order to achieve an optimum surface roughness of 75 - 100 µm, angular, disposable blasting media (aluminum oxide, corundum) should be used. The surface quality is negatively influenced by the use of reusable blasting media (slag, glass, quartz), but also by ice blasting. The air for blasting must be dry and oil-free. Metal parts that have come into contact with sea water or other salt solutions should first be rinsed thoroughly with demineralised water and, if possible, left to rest overnight so that all salts can be dissolved from the metal. Before each application of WEICON C, a test for soluble salts should be carried out according to the Bresle method (DIN EN ISO 8502-6).

The maximum amount of soluble salts remaining on the substrate should not exceed 40 mg/m<sup>2</sup>. Heating and repeated blasting of the surface may be necessary to remove all soluble salts and moisture.

After each mechanical pre-treatment, the surface should be cleaned again with WEICON Cleaner Spray S and protected from further contamination until the coating is applied.

Areas where no adhesion to the substrate is desired must be treated with silicone-free mould release agents. For smooth surfaces, we recommend WEICON Mould Release Agent Liquid F 1000 or, for porous surfaces, WEICON Mould Release Agent Wax P 500.

After the surface pre-treatment, WEICON C should be applied as soon as possible (within one hour) to avoid oxidation, flash rust or new contamination.

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#### **Mixing**

Before adding the hardener, the resin needs to mixed with the fillers thoroughly and without creating bubbles. Then mix the resin and hardener together thoroughly and bubblefree for at least four minutes at 20°C (68°F). The included processing spatula or a mechanical mixer, such as the Stirrer Stainless Steel, can be used for this purpose. With mechanical mixers, a low speed of max. 500 rpm should be used. The components should be stirred until a homogeneous mixture is achieved. The mixing ratio of the two components must be strictly observed, as otherwise, strongly deviating physical values will result (max. deviation +/- 2 %). Only prepare a batch as large as can be processed within the pot life of 60 minutes. The specified pot life refers to a material batch of 500 g and 20°C (68°F) material temperature. Mixing larger quantities or higher processing temperatures will result in faster curing due to the typical reaction heat of epoxy resins.





#### **Application**

For processing, we recommend an ambient temperature of 20°C (68 °F) at less than 85% relative humidity. For a thin pre-coat, work WEICON C intensively into the surface in crosswise layers using the Contour Spatula Flexy or a paint brush to achieve maximum adhesion. By means of this technique, the epoxy resin penetrates well into all cracks and roughness depths. Afterwards, further applications can be carried out straight away, until the desired layer thickness is reached. Make sure that the epoxy resin is applied evenly and without air bubbles.

#### Curing

Final hardness is reached after 12 hours at 20°C (68°F) at the latest. At lower temperatures, the curing can be accelerated by evenly applying heat up to max. 40°C (104°F). e.g. with a heating pack, hot air blower or fan heater. Higher temperatures shorten the curing time. The following rule of thumb applies: Each increase by +10°C (50°F) above room temperature (20°C/68°F) will decrease the curing time by half. Temperatures below 16°C (61°F) increase the curing time. until at approx. 5°C (41°F) and below, almost no reaction will take place at all. In order to achieve a permanently high temperature resistance, after 48 hours, tempering should be

carried out as follows: 2 h at +40°C, 2 h at +60°C, 2 h at +80°C, 2 h at +100°C, finally 14 h at +120°C.

#### Storage

WEICON Epoxy Resin Systems should be stored in a dry place at room temperature. Unopened containers can be stored at temperatures from +18 °C to +28 °C. Opened containers must be used up within 6 months.

#### Scope of delivery

Processing Spatula | Instructions for use | Gloves | Resin & Hardener

#### **Accessories**

10000147 10000347 10024313 10025288 10026647	Cleaner Spray S, 500 ml, transparent Cleaner S, 5 L, colourless, transparent Surface Cleaner, 400 ml, transparent Surface Cleaner, 5 L, transparent Mould Release Agent Liquid F 1000, 250 ml, white, milky
10026171 10053995 10000913 10010887 10022562 10016002 10039667 10045523	Mould Release Agent Wax P 500, 0,5 kg Repair Stick Multi-Purpose, 115 g, vintage white Glass Fibre Cloth Tape, 1 PCE, white Processing Spatula, 1 PCE Processing Spatula, 1 PCE Pump Dispenser WPS 1500, 1 PCE Cable Scissors No. 35, 1 PCE Processing Kit, 1 PCE

#### Recommended equipment

Angle grinder PE film 0.2 mm Blast machine Fabric tape Heat pocket Brush Hot or fan heater Foam roller Smoothing trowel, spatula Lint-free cloth

#### **Conversion table**

$(^{\circ}C \times 1.8) + 32 = ^{\circ}F$	Nm x 8.851 = lb⋅in
mm/25.4 = inch	$Nm \times 0.738 = Ib \cdot ft$
$\mu$ m/25.4 = mil	Nm x 141.62 = oz∙in
$N \times 0.225 = Ib$	mPa⋅s = cP
$N/mm^2 x 145 = psi$	$N/cm \times 0.571 = lb/in$
MPa x 145 = psi	$kV/mm \times 25.4 = V/mil$

#### Available sizes

10000032	WEICON C, 0,5 kg, grey
10000033	WEICON C, 2 kg, grey
10051209	WEICON C, 0,2 kg, grey

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# WEICON®

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	WEICON A	WEICON B	WEICON BR	WEICON C	WEICON F	WEICON F2	WEICON HB 300	WEICON HT 111	WEICON SF	WEICON ST	WEICON TI	WEICON UW	WEICON WR2	WEICON HP	WEICON Fire Safe	WEICON Anti-Static	WEICON Food Grade	WEICON Anti-Stick	WEICON Ceramic BL	WEICON GL	WEICON GL-S	WEICON Ceramic W	WEICON Ceramic HC 220	WEICON WP	WEICON WR	WEICON CBC
Repair and moulding	х	х	х	х	х	х	х	х	х	х	х	х	х													
Adhesive				х	х		х	х		х				х	х											
Wear, erosion and corrosion protection – abrasion-resistant coating																x	x	х	х	х	х	х	x	x		
Casting, relining and gap compensation – casting and injecting potting compound	х					x							x												x	x

To the product detail page:



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#### Chemical resistance after curing\* (Excerpt)

Exhaust fumes	+	Potassium carbonate	+
Acetone	0	Potassium hydroxide 0-20 % (caustic potash)	+
Ethyl ether	+	Milk of lime	+
Ethyl alcohol	0	Carbolic acid	-
Ethylbenzene	-	Creosote oil	-
Alkalis (alkaline substances)	+	Cresylic acid	-
Hydrocarbons, aliphatic (petroleum derivatives)	+	Magnesium hydroxide	+
Formic acid >10 % (methanoic acid)	-	Maleic acid (cis-ethylenedicarboxylic acid)	+
Ammonia anhydrous 25%	+	Methanol (methyl alcohol ) <85 %	-
Amyl acetate	+	Mineral oil	+
Amyl alcohol	+	Naphthalene	-
Hydrocarbons, aromatic (benzene, toluene, xylene)	+	Naphthene	-
Barium hydroxide	+	Sodium carbonate (soda)	+
Petrol (92-100 octane)	+	Sodium bicarbonate (sodium hydrogen carbonate)	+
Hydrobromic acid <10 %	+	Sodium chloride (table salt)	+
Butyl acetate	+	Sodium hydroxide >20 % (caustic soda)	0
Butyl alcohol	+	Caustic soda	+
Calcium hydroxide (slaked lime)	+	Heating oil, diesel	+
Chloroacetic acid	-	Oxalic acid <25 % (ethanedioic acid)	+
Chloroform (trichlormethane)	0	Perchloraethylene	0
Chlorosulphuric acid (wet and dry)	-	Kerosene	+
Chlorinated water (swimming pool concentration)	+	Oils, vegetable and animal	+
Hydrochloric acid	+	Phosphoric acid <5%	+
Chromium bath	+	Phthalic acid, phthalic anhydride	+
Chromic acid	+	Crude oil	+
Diesel fuels	+	Nitric acid <5%	0
Mineral oil and mineral oil products	+	Hydrochloric acid <10 %	+
Acetic acid diluted <5%	+	Sulphur dioxide (wet and dry)	+
Ethanol <85 % (ethyl alcohol)	+	Carbon disulphide	+
Greases, oils and waxes	+	Sulphuric acid <5%	0
Hydrofluoric acid diluted	0	White spirit	+
Tannic acid diluted <7%	+	Carbon tetrachloride (tetrachloromethane)	+
Glycerin (trihydroxipropane)	+	Tetralin (tetrahydronaphthalene)	0
Glycol	0	Toluene	-
Humic acid	+	Trichloraethylene	0
Impregnating oils	+	Hydrogen peroxide <30 % (hydrogen superoxide)	+
Potash	+	Xylene	-

<sup>+ =</sup> resistant 0 = for a limited time - = not resistant \*The storage of all WEICON Plastic Metal types was carried out at +20°C chemical temperature.

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