Plastic-Bond



Excellent adhesion to plastics | high strength | impact-resistant | permanently elastic

WEICON Plastic-Bond is a solvent-free structural adhesive with very good adhesion to plastics, aluminum, steel and many other materials. The adhesive is suitable for static as well as dynamic loads, has high impact and peel strength and a maximum gap-filling capacity of 5 mm.

Plastic-Bond is especially suitable for structural bonding applications where high-strength bonds are required. The adhesive is highly viscous and is therefore suitable for processing on vertical surfaces.

The structural adhesive is universally applicable and can be used, for example, in plastics technology, in metal construction, in car body and vehicle construction, in mechanical engineering, in electrical engineering, in wood processing, or in trade show and exhibition construction.

Charakteristik

Base		Methyl methacrylate
Texture		viscous
Colour		off-white, milky
Minimum shelf life	at room temperature	12 mon.

Verarbeitung

Processing temperature		+10°C to +40°C
Cure temperature		+18 °C
Mixing ratio by weight		1:1
Viscosity of the mixture		40.000-60.000 mPa·s
Density of the mixture		0,98-1,02 g/cm³
Gap bridging up to max.		5 mm

Aushärtung

Pot life	at 20 °C	15 min.
Handling strength	(35 % strength)	40 min.
Working strength after	(50 % strength)	60 min.
Final strength	(100 % strength)	12 h

Mechanische Eigenschaften

Zugscherfestigkeit bei Materialdicke 1,5 mm DIN EN 1465	
Steel 1.0338 sandblasted	23.0 N/mm²
Stainless steel V2A sandblasted	22.0 N/mm²
Aluminium sandblasted	20 N/mm²
PVC-rigid roughened	12.0 N/mm²
CFRP	22.0 N/mm²
ABS	7 N/mm²
PC (polycarbonate)	11 N/mm²
GFRP	21.0 N/mm²
PMMA	9 N/mm²
Polyamide 6.6	1 N/mm²

Thermische Kennwerte

Temperature resistance	-55°C to +125°C

Elektrische Kennwerte

Dielectric strength	DIN EN 60243-1 (20°C)	21 kV/mm

Zulassungen / Richtlinien

IMPA Code	812993

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 pretreatment

Clean and dry bonding surfaces are essential for flawless adhesive bonding (e.g. cleaning and degreasing with WEICON Surface Cleaner). Best results are achieved when the adhesive surfaces are mechanically roughened. The adhesive is applied to just one side.

Application

Plastic-Bond can be processed directly from double cartridges using the static mixer. Discard the first 5 cm of the dispensed bead. The adhesive is applied on one side. The specified pot life refers to a material batch of 10 ml at room temperature. Larger batch quantities result in faster curing. Higher temperatures also reduce the pot life and curing time. Rule of thumb: for every 10 °C (50 °F) increase above room temperature, pot life and curing time are reduced by half. Temperatures below +16 °C (61 °F) significantly increase pot life and curing time. At approx. +5 °C (41 °F) and below, almost no reaction occurs.

Storage

WEICON structural acrylic adhesives should be stored in a dry place at a constant room temperature. Unopened containers can be stored at temperatures from +18 °C to +25 °C. Protect from direct sunlight. Storage in a refrigerated environment increases the shelf life.

Note
The specifications and recommendations given in this technical data sheet must not be seen as guaranteed product characteristics. They are based on our laboratory tests and on practical experience. Since individual application conditions are beyond our knowledge, control and responsibility, this information is provided without any obligation. We do guarantee the continuously high quality of our products. However, own adequate laboratory and practical tests to find out if the product in question meets the requested properties are recommended. A claim cannot be derived from them. The user bears the only responsibility for non-appropriate or other than specified applications.

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Plastic-Bond

Accessories

10029793 Quadro Mixing Nozzle B, 1 PCE, grey
10068261 Dosing Tip A Size 0,5 mm, 1 PCE

Conversion table

(°C x 1.8) + 32 = °F
mm/25.4 = inch
µm/25.4 = mil
N x 0.225 = lb
N/mm^2 x 145 = psi
MPa x 145 = psi

Nm x 8.851 = lb·in
Nm x 0.738 = lb·ft
Nm x 141.62 = oz·in
mPa·s = cP
N/cm x 0.571 = lb/in
kV/mm x 25.4 = V/mil

Available sizes

10018558 Plastic-Bond, 24 ml, off-white, milky
10058780 Plastic-Bond, 24 ml (Set), off-white, milky

To the product detail page:

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