

# Easy-Mix RK-7200 Structural Acrylic Adhesive



## Transparent | high strength | impact-resistant | residual elasticity

WEICON Easy-Mix RK-7200 is a high-strength, solvent-free and fast-curing structural adhesive. It is based on MMA (methyl methacrylate) and has excellent adhesive strength on many materials. Due to its transparent curing, it is particularly suitable for bonding e.g. plastics and glass. WEICON Easy-Mix RK-7200 can also be used for structural bondings where a coloured adhesive would not match the components. That way, transparent plastics like acrylic glass (PMMA) and other materials can be bonded with high strength.

### Characteristics

Base	methyl methacrylate	
Texture	viscous	
Colour	transparent, colourless	
Minimum shelf life	at room temperature	3 mon.
Minimum shelf life	from +2 °C to +7 °C	6 Mon.
<b>Processing</b>		
Processing procedure	Easy-Mix	
Curing temperature	> +16 °C	
Cure temperature	+18	
Mixing ratio by weight	1:1	
Viscosity of the mixture	5.000-8.000 mPa·s	
Density of the mixture	1,2 g/cm³	
Gap bridging up to max.	2 mm	

### Curing

Pot life	at 20 °C	1-2 min.
Handling strength	(35 % strength)	8 min.
Working strength after	(50 % strength)	120 min.
Final strength	(100 % strength)	6 h

### Mechanical properties after curing

Lap shear strength material thickn. 1,5mm DIN EN 1465	
Steel 1.0338 sandblasted	18 N/mm²
Stainless steel V2A sandblasted	18 N/mm²
Aluminium sandblasted	8 N/mm²
PVC-rigid roughened	8 N/mm²
CFRP	12 N/mm²
ABS	7 N/mm²
PC (polycarbonate)	7 N/mm²
GFRP	9 N/mm²
PMMA	9 N/mm²
Polyamide 6.6	2 N/mm²

### Thermal parameters

Temperature resistance	-40°C to +120°C	
Tg after curing at room temperature (DSC)		-17,5 °C

### Electrical parameters

Dielectric strength	DIN EN 60243-1 (20°C)	13 kV/mm
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### Approvals / Guidelines

MIL-Spec	complies with	MIL-A-47284A
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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](http://www.weicon.com)) must be observed.

### Surface Pre-Treatment

For a flawless adhesive bond, surfaces must be clean and dry (e.g.

clean and degrease with Surface Cleaner). Higher strengths can be achieved by further pre-treatment of the surfaces, such as roughening by blasting or grinding. Some low-energy plastics, especially PTFE and polyolefins etc., can only be bonded after special pre-treatment of the surfaces by e.g. fluorination, low-pressure plasma, corona, flame treatment, or similar.

### Application

Easy-Mix RK-7200 can be processed straight from the double cartridge by means of the included static mixer. Dismiss the first 5 cm of the adhesive bead. The adhesive is applied to just one side. The specified pot life refers to a material batch of 10 ml at room temperature. Larger batch quantities will result in faster curing. Higher temperatures also reduce the pot life and curing time. (General rule: every increase by +10 °C above room temperature results in a decrease of the pot life and curing time by

half). Temperatures below +16 °C increase the pot life and curing time significantly. From approx. +5°C and below, no reaction takes place.

### Storage

WEICON acrylic structural adhesives should be stored in a dry place at a constant room temperature. Unopened containers

### 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.

# Easy-Mix RK-7200 Structural Acrylic Adhesive

Structural Acrylic Adhesives

can be stored at temperatures from +18 °C to +25 °C. Protect from direct sunlight. Storage in a refrigerated environment increases the shelf life.

## Scope of delivery

Adhesive | Quadro Mixing Nozzle B

## Accessories

- 10005237 Dispenser Easy-Mix D 50, 1 PCE
- 10029793 Quadro Mixing Nozzle B, 1 PCE, grey
- 10068261 Dosing Tip, 1 PCE
- 10101999 WEICON Manual Dispenser, 1 x 1:1 | 2:1

## Conversion table

(°C x 1.8) + 32 = °F	Nm x 8.851 = lb·in
mm/25.4 = inch	Nm x 0.738 = lb·ft
µm/25.4 = mil	Nm x 141.62 = oz·in
N x 0.225 = lb	mPa·s = cP
N/mm <sup>2</sup> x 145 = psi	N/cm x 0.571 = lb/in
MPa x 145 = psi	kV/mm x 25.4 = V/mil

## Available sizes

- 10034573 Easy-Mix RK-7200 Structural Acrylic Adhesive, 50 ml, transparent, colourless

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