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	from +2 °C to +7 °C	6 Mon.
Processing		
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

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

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. +5C and below, no reaction takes place.

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

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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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 A Size 0,5 mm, 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^2 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

To the product detail page:

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