

Fast-Metal Minute Adhesive



Highly filled | pasty | gap-filling | very short pot life | fast-curing

WEICON Fast-Metal Minute Adhesive is ideal for repairs and bondings with larger bonding gaps or bigger tolerances. Its gap-filling properties make it suitable for rough and poorly fitting surfaces as well as for filling in cracks, cavities and unlevelled surfaces. WEICON Fast-Metal Minute Adhesive can be used on numerous materials such as metal, plastic, fibre-reinforced materials, ceramics, glass, stone and wood.

Characteristics

| | | |
|--------------------|----------------------------|---------|
| Base | Epoxy resin, highly filled | |
| Texture | pasty, gap-filling | |
| Colour | grey | |
| Minimum shelf life | at room temperature | 12 mon. |

Processing

| | | |
|-------------------------|-----------------------|--|
| Processing temperature | +10°C to +30°C | |
| Cure temperature | +6 °C to +40 °C | |
| Mixing ratio by weight | 1:1 | |
| Density of the mixture | 1,8 g/cm ³ | |
| Gap bridging up to max. | 4 mm | |

Curing

| | | |
|------------------------|-----------------------|----------|
| Pot life | at 20 °C, 10 ml batch | 3-4 min. |
| Handling strength | (35 % strength) | 40 min. |
| Working strength after | (50 % strength) | 2 h |
| Final strength | (100 % strength) | 24 h |
| Shrinkage | | 0,3 % |

Mechanical properties after curing

| | | |
|--|--------------------------|----------------------|
| Tensile strength | DIN EN ISO 527-2 | 24 MPa |
| E-modulus (tensile) | DIN EN ISO 527-2 | 4.000 - 4.500 MPa |
| Compressive strength | DIN EN ISO 604 | 10 MPa |
| Bending strength | DIN EN ISO 178 | 58 MPa |
| Hardness (Shore D) | DIN ISO 7619 | 70 |
| Lap shear strength material thicken. 1,5mm DIN EN 1465 | | |
| | Steel 1.0338 sandblasted | 20 N/mm ² |
| | Aluminium sandblasted | 19 N/mm ² |
| | PVC-rigid roughened | 11 N/mm ² |

Thermal parameters

| | | |
|--------------------------|--------------------------|---------------|
| Temperature resistance | -50°C to +145°C | |
| Temperature conductivity | 0,286 mm ² /s | |
| Thermal conductivity | DIN EN ISO 22007-4 | 0,51 W/m·K |
| Heat capacity | DIN EN ISO 22007-4 | 0,904 J/(g·K) |

Electrical parameters

| | | |
|---------------------|-----------------------|---------------------------|
| Resistance | DIN EN 62631-3-1 | 4,57·10 ¹² Ω·m |
| Dielectric strength | DIN EN 60243-1 (20°C) | 17 kV/mm |

Approvals / Guidelines

| | |
|-----------|-----------|
| ISSA Code | 75.629.51 |
| IMPA Code | 812981 |

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

Clean and dry bonding surfaces are essential for flawless adhesive bonding (e.g. cleaning and degreasing with WEICON Surface Cleaner).

Processing

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.

Scope of delivery

Adhesive

Accessories

10005237 Dispenser Easy-Mix D 50, 1 PCE

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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Conversion table

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

Available sizes

- 10007785 Fast-Metal Minute Adhesive, 24 ml, grey
- 10058777 Fast-Metal Minute Adhesive, 1 Set, grey

To the product detail page:



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