

## 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 <sup>3</sup>	
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 thickn. 1,5mm DIN EN 1465

Steel 1.0338 sandblasted	20 N/mm <sup>2</sup>
Aluminium sandblasted	19 N/mm <sup>2</sup>
PVC-rigid roughened	11 N/mm <sup>2</sup>

### Thermal parameters

Temperature resistance		-50°C to +145°C
Temperature conductivity		0,286 mm²/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 <sup>12</sup> 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](http://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.

### Storage

WEICON epoxy adhesives should be stored in a dry place at room temperature. Unopened containers can be stored at temperatures from +18 °C to +25 °C. Protect from direct sunlight. Failure to observe these storage instructions will reduce the shelf life to 6 months. Epoxy resins generally tend to crystallise at temperatures below +5 °C. This effect is increased by large temperature fluctuations, e.g. during transport especially in the winter months. This has a negative impact on processing, curing and technical data, can, however, be reversed by heating the product (up to max. +50 °C, no open flame). In WEICON epoxy

#### 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.

WEICON Middle East L.L.C.  
United Arab Emirates  
phone +971 4 880 25 05  
[info@weicon.ae](mailto:info@weicon.ae)

WEICON Czech Republic s.r.o.  
Czech Republic  
phone +42 (0) 417 533 013  
[info@weicon.cz](mailto:info@weicon.cz)

WEICON GmbH & Co. KG  
(Headquarters) Germany  
phone +49 (0) 251 9322 0  
[info@weicon.de](mailto:info@weicon.de)

WEICON Romania SRL  
Romania  
phone +40 (0) 3 65 730 763  
[office@weicon.com](mailto:office@weicon.com)

WEICON South East Asia Pte Ltd  
Singapore  
Phone (+65) 6710 7671  
[info@weicon.com.sg](mailto:info@weicon.com.sg)

WEICON Inc.  
Canada  
phone +1 877 620 8889  
[info@weicon.ca](mailto:info@weicon.ca)

WEICON Ibérica S.L.  
Spain  
phone +34 (0) 914 7997 34  
[info@weicon.es](mailto:info@weicon.es)

WEICON Italia S.r.l.  
Italy  
phone +39 (0) 10 2924 871  
[info@weicon.it](mailto:info@weicon.it)

WEICON SA (Pty) Ltd  
South Africa  
phone +27 (0) 21 709 0088  
[info@weicon.co.za](mailto:info@weicon.co.za)

WEICON Kimya Sanayi Tic. Ltd. Şti.  
Türkiye  
phone +90 (0) 212 465 33 65  
[info@weicon.com.tr](mailto:info@weicon.com.tr)

# Fast-Metal Minute Adhesive

adhesives, crystallisation is reduced by the careful choice and combination of base resins (bisphenol A and F).

## Scope of delivery

Adhesive

## Accessories

10024313 Surface Cleaner, 400 ml, transparent

## 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:



### 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.

WEICON Middle East L.L.C.  
United Arab Emirates  
phone +971 4 880 25 05  
info@weicon.ae

WEICON Czech Republic s.r.o.  
Czech Republic  
phone +42 (0) 417 533 013  
info@weicon.cz

WEICON GmbH & Co. KG  
(Headquarters) Germany  
phone +49 (0) 251 9322 0  
info@weicon.de

WEICON Romania SRL  
Romania  
phone +40 (0) 3 65 730 763  
office@weicon.com

WEICON South East Asia Pte Ltd  
Singapore  
Phone (+65) 6710 7671  
info@weicon.com.sg

WEICON Inc.  
Canada  
phone +1 877 620 8889  
info@weicon.ca

WEICON Ibérica S.L.  
Spain  
phone +34 (0) 914 7997 34  
info@weicon.es

WEICON Italia S.r.L.  
Italy  
phone +39 (0) 010 2924 871  
info@weicon.it

WEICON SA (Pty) Ltd  
South Africa  
phone +27 (0) 21 709 0088  
info@weicon.co.za

WEICON Kimya Sanayi Tic. Ltd. Şti.  
Türkiye  
phone +90 (0) 212 465 33 65  
info@weicon.com.tr