

# Aluminium Minute Adhesive



resistant to high temperatures | pasty | high impact resistance

Adhesive for bonding aluminium and other light metals to each other. WEICON Aluminium Minute Adhesive can be used to fill cracks and holes, for example in aluminium housings, and for repairing light alloy wheels.

Aluminium Minute Adhesive is a low-odour, two-component, aluminium-filled epoxy adhesive. It is resistant to high temperatures up to +180 °C and cures quickly at room temperature. After curing, the adhesive can be machined (filing, drilling, milling). Aluminium Minute Adhesive is gap-filling and non-dripping (thixotropic) and offers very high tensile and impact strength. To achieve optimal adhesion, the bonding surfaces should be dry and free from grease or dirt. Scraping or sanding the surfaces before cleaning additionally improves adhesion.

## Characteristics

Base	Epoxy
Filler	filled
Texture	viscous
Colour	aluminium
Minimum shelf life	at room temperature 18 mon.

## Processing

Processing temperature	+15 °C to +40 °C
Component temperature	>3°C above dew point
Cure temperature	+6 °C to +40 °C
Relative air humidity	max. 85%
Mixing ratio by volume	1:1
Viscosity of the mixture	at +20 °C 11.000 mPa·s
Density of the mixture	1,2 g/cm <sup>3</sup>
Gap bridging up to max.	4 mm

## Note

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

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

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

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

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

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

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

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

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

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

## Curing

Pot life	at 20 °C, 10 g batch	4-5 min.
Handling strength	(35 % strength)	30 min.
Working strength after	(80 % strength)	1 h
Final strength	(100 % strength)	24 h
Shrinkage		0,8 %

## Mechanical properties after curing

- Measured after curing at		24 h RT + 24 h 60 °C
Tensile strength	DIN EN ISO 527-2	34 N/mm <sup>2</sup>
Elongation at break (tensile)	DIN EN ISO 527-2	1,1 %
E-modulus (tensile)	DIN EN ISO 527-2	2.200 - 2.700 MPa
Compressive strength	DIN EN ISO 604	40 MPa
Bending strength	DIN EN ISO 178	58 MPa
Hardness (Shore D)	DIN ISO 7619	76 ± 3
Lap shear strength material thickn. 1,5mm DIN EN 1465		
Steel 1.0338 sandblasted		18 N/mm <sup>2</sup>
Stainless steel V2A sandblasted		19 N/mm <sup>2</sup>
Aluminium sandblasted		15 N/mm <sup>2</sup>
Galvanized steel		17 N/mm <sup>2</sup>
PVC-rigid roughened		11 N/mm <sup>2</sup>

## Thermal parameters

Temperature resistance	-50 °C to +180 °C (-58 °F to +356 °F)
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## Electrical parameters

Dielectric strength	DIN EN 60243-1 (20°C)	16 kV/mm
Magnetic		no

## 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).

## Application

WEICON Aluminium Minute Adhesive can be processed straight from the double cartridge. Dismiss the first centimetre of the adhesive bead. Mix product thoroughly. Apply adhesive to the bonding surface quickly. Then join both bonding surfaces immediately.

## 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

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

## Scope of delivery

Adhesive | Quadro Mixing Nozzle A

## Accessories

10005236 Quadro Mixing Nozzle A, 1 PCE, blue  
10068261 Dosing Tip A Size 0,5 mm, 1 PCE

## 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

10051229 Aluminium Minute Adhesive, 24 ml, aluminium  
10058776 Aluminium Minute Adhesive, 24 ml (Set), aluminium

To the product detail page:



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