

Epoxy Minute Adhesive



Viscous | self-levelling | very short pot life | fast-curing | transparent

WEICON Epoxy Minute Adhesive can be used on numerous materials such as metal, plastic, fibre-reinforced materials, ceramics, glass, stone and wood.

The adhesive is suitable for work in construction and assembly work, and whenever only small quantities of adhesive are required.

Characteristics

Base	Epoxy resin
Filler	unfilled
Texture	viscous
Colour	transparent

Processing

Processing temperature	+10°C to +30°C
Cure temperature	+6 °C to +40 °C
Mixing ratio by weight	1:1
Viscosity of the mixture	at +20 °C 8.500 mPa·s
Density of the mixture	1,15 g/cm ³
Gap bridging up to max.	2 mm

Curing

Pot life	at 20 °C, 10 ml batch	3-4 min.
Handling strength	(35 % strength)	30 min.
Working strength after	(50 % strength)	1 h
Final strength	(100 % strength)	24 h
Shrinkage		2,0 %

Mechanical properties after curing

Tensile strength	DIN EN ISO 527-2	40 MPa
E-modulus (tensile)	DIN EN ISO 527-2	2.000 - 2.500 MPa
Compressive strength	DIN EN ISO 604	9 MPa
Bending strength	DIN EN ISO 178	58 MPa
Hardness (Shore D)	DIN ISO 7619	65

Lap shear strength material thickn. 1,5mm DIN EN 14665

Steel 1.0338 sandblasted	20 N/mm ²
Aluminium sandblasted	19 N/mm ²
PVC-rigid roughened	13 N/mm ²

Thermal parameters

Temperature resistance	-50°C to +80°C
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Electrical parameters

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

ISSA Code	75.629.50
IMPA Code	812980

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

WEICON Easy-Mix products 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

When stored in unopened condition in a dry place at constant room temperature of approx. +20°C, WEICON Epoxy Adhesives have a shelf life of at least 18 months. Protect from direct sunlight. In case of non-observance of these storage instructions, the shelf life is reduced to 6 months. In general, epoxy resins 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 Adhesives, crystallisation is reduced by the careful choice and combinations of base resins (bisphenol A and F).

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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Epoxy Minute Adhesive

Scope of delivery

Adhesive | Quadro Mixing Nozzle A

Accessories

10005236 Quadro Mixing Nozzle A, 1 PCE, blue

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

1000133 Epoxy Minute Adhesive, 24 ml, transparent
10057686 Epoxy Minute Adhesive, 1 Set, transparent

To the product detail page:



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