

Epoxy Minute Adhesive



high-temperature resistant | viscous | fast-curing

WEICON Epoxy Minute Adhesive is a universally applicable, two-component epoxy resin system. The adhesive is resistant to high temperatures up to +180 °C, viscous and self-levelling. It has a very short pot life and cures quickly. Epoxy Minute Adhesive bonds many different materials to each other, such as metal, plastic, fibre composite, ceramic, glass, stone or wood.

The transparent adhesive is suitable for craft applications or demanding DIY projects. It can also be used in trade fair and shop fitting, as well as for construction and assembly work.

Characteristics

Base	Epoxy
Filler	unfilled
Texture	liquid
Colour	transparent, light yellow
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 4.500 mPa·s
Density of the mixture	1,2 g/cm³
Gap bridging up to max.	2 mm

Curing

Pot life	at 20 °C, 10 g batch 4-5 min.
Handling strength	(35 % strength) 13 min.
Working strength after	(80 % strength) 20 min.
Final strength	(100 % strength) 24 h
Shrinkage	1,41 %

Note

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Mechanical properties after curing

- Measured after curing at	24 h RT + 24 h 60 °C
Tensile strength	DIN EN ISO 527-2 50 N/mm²
Elongation at break (tensile)	DIN EN ISO 527-2 2,7 %
E-modulus (tensile)	DIN EN ISO 527-2 2.200 - 2.400 MPa
Compressive strength	DIN EN ISO 604 55 MPa
Bending strength	DIN EN ISO 178 58 MPa
Hardness (Shore D)	DIN ISO 7619 82 ±3
Lap shear strength material thickn. 1,5mm DIN EN 1465	
Steel 1.0338 sandblasted	22 N/mm²
Stainless steel V2A sandblasted	26 N/mm²
Aluminium sandblasted	13 N/mm²
Galvanized steel	16 N/mm²
PVC-rigid roughened	13 N/mm²

Thermal parameters

Temperature resistance	-50 °C to +180 °C (-58°F to +356°F)
Tg after curing at room temperature (DSC)	44,7 °C
Tg after tempering (at 90°C) (DSC)	46,1 °C

Electrical parameters

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

Approvals / Guidelines

ISSA Code	75.629.50
IMPA Code	812980
MIL-Spec	complies with MIL-T-83523

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 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

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

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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 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

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

10057686	Epoxy Minute Adhesive, 24 ml (Set), transparent, light yellow
10000133	Epoxy Minute Adhesive, 24 ml, transparent, light yellow

To the product detail page:



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