

# Easy-Mix RK-7100 Structural Acrylic Adhesive



## Fast-curing | high-strength | impact-resistant | residual elasticity

The structural acrylic adhesive WEICON Easy-Mix RK-7100 can be used to bond numerous materials, such as plastics, metals and ceramics with high tensile, shear and peel strength. It is particularly suitable for structural bondings where high strength connections are required. It is highly viscous and is therefore suitable for processing on vertical surfaces. RK-7100 is universally applicable and can be used, for example, in plastics technology, in metal construction, in car body and vehicle construction, in mechanical engineering, in electrical engineering, model and mould making, and in trade show and exhibition construction.

### Characteristics

Base	methyl methacrylate	
Texture	viscous	
Minimum shelf life	at room temperature	12 mon.

### Processing

Processing procedure	Easy-Mix	
Processing temperature	+10°C to +40°C	
Curing temperature	> +16 °C	
Mixing ratio by weight	1:1	
Viscosity of the mixture	40.000-60.000 mPa·s	
Density of the mixture	0,98-1,02 g/cm³	
Gap bridging up to max.	5 mm	

### Curing

Pot life	at 20 °C	5 min.
Handling strength	(35 % strength)	25 min.
Working strength after	(50 % strength)	60 min.
Final strength	(100 % strength)	12 h

### Mechanical properties after curing

Tensile strength	DIN EN ISO 527-2	24 N/mm²
Elongation at break (tensile)	DIN EN ISO 527-2	28 %
E-modulus (tensile)	DIN EN ISO 527-2	1200 - 1700 MPa
Lap shear strength material thckn. 1,5mm DIN EN 1465		
Steel 1.0338 sandblasted		23 N/mm²
Stainless steel V2A sandblasted		22 N/mm²
Aluminium sandblasted		20 N/mm²
PVC-rigid roughened		12 N/mm²
CFRP		22 N/mm²
ABS		7 N/mm²
PC (polycarbonate)		12 N/mm²
GFRP		21 N/mm²
PMMA		9 N/mm²
Polyamide 6.6		1 N/mm²

### Thermal parameters

Temperature resistance	-55°C to +125°C	
Tg after curing at room temperature (DSC)	-40,3 °C	
Temperature conductivity	0,125 mm²/s	
Thermal conductivity	DIN EN ISO 22007-4	0,22 W/m·K
Heat capacity	DIN EN ISO 22007-4	1,517 J/(g·K)

### Electrical parameters

Resistance	DIN EN 62631-3-1	6,26 · 10 <sup>10</sup> Ω·m
Dielectric strength	DIN EN 60243-1 (20°C)	24 / 30 (*6150) kV/mm

### 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

For a flawless adhesive bond, surfaces must be clean and dry (e.g.

clean and degrease with Surface Cleaner). Higher strengths can be achieved by further pre-treatment of the surfaces, such as roughening by blasting or grinding. Some low-energy plastics, especially PTFE and polyolefins etc., can only be bonded after special pre-treatment of the surfaces by e.g. fluorination, low-pressure plasma, corona, flame treatment, or similar.

### Application

RK-7100 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. +5C and below, no reaction takes place.

### 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) 10 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

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## Storage

WEICON acrylic structural adhesives should be stored in a dry place at a constant room temperature. Unopened containers can be stored at temperatures from +18 °C to +25 °C. Protect from direct sunlight. Storage in a refrigerated environment increases the shelf life.

## Scope of delivery

Adhesive | Quadro Mixing Nozzle B

## Accessories

- 10005237 Dispenser Easy-Mix D 50, 1 PCE
- 10029793 Quadro Mixing Nozzle B, 1 PCE, grey
- 10068261 Dosing Tip A Size 0,5 mm, 1 PCE
- 10101999 WEICON Manual Dispenser, 1 x 1:1 | 2:1

## Conversion table

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

## Available sizes

- 10030534 Easy-Mix RK-7100 Structural Acrylic Adhesive, 50 ml, off-white, milky
- 10051232 Easy-Mix RK-7100 Structural Acrylic Adhesive, 50 ml, black

To the product detail page:



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Singapore  
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