

Easy-Mix RK-7300 Structural Acrylic Adhesive



Excellent adhesion to plastics and EPDM | high strength | highly viscous | impact-resistant

WEICON Easy-Mix RK-7300 is a fast-curing, solvent-free structural and construction adhesive based on MMA (methyl methacrylate). It adheres perfectly to a variety of materials and has a high adhesive strength. It can be applied universally for static and dynamic loads. High-strength bondings are also possible in case of low surface energy plastics, such as PE or PP. Its high-viscosity characteristics also permit material pairings with different expansion coefficients, such as plastic / aluminium or steel. Special fillers (glass beads) ensure a consistent adhesive gap of 0.25 mm. Maximum gap-bridging: 1 mm.

Characteristics

Base	methyl methacrylate
Texture	pasty
Colour	translucent / hazy white
Minimum shelf life	at room temperature 6 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	170.000-200.000 mPa·s
Density of the mixture	1,00 g/cm³
Gap bridging up to max.	1 mm

Curing

Pot life	at 20 °C 8 min.
Handling strength	(35 % strength) 60 min.
Working strength after	(50 % strength) 480 min.
Final strength	(100 % strength) 24 h

Mechanical properties after curing

Lap shear strength material thickn. 1,5mm DIN EN 1465	
Steel 1.0338 sandblasted	5 N/mm²
Stainless steel V2A sandblasted	4 N/mm²
Aluminium sandblasted	5 N/mm²
PVC-rigid roughened	11 N/mm²
CFRP	7 N/mm²
ABS	8 N/mm²
PC (polycarbonate)	6 N/mm²
GFRP	7 N/mm²
PMMA	6 N/mm²
Polyamide 6.6	3 N/mm²
POM (polyoxymethylene)	5 N/mm²
PE-HD	5 N/mm²
PP (polypropylene)	6 N/mm²
PTFE (polytetrafluoroethylene)	2 N/mm²
EPDM (Shore A70)	1 N/mm²

Thermal parameters

Temperature resistance	-55°C to +100°C
Tg after curing at room temperature (DSC)	51,5 °C
Temperature conductivity	0,118 mm²/s
Thermal conductivity	DIN EN ISO 22007-4 0,15 W/m·K
Heat capacity	DIN EN ISO 22007-4 1,489 J/(g·K)

Electrical parameters

Resistance	DIN EN 62631-3-1 1,25 · 10¹³ Ω·m
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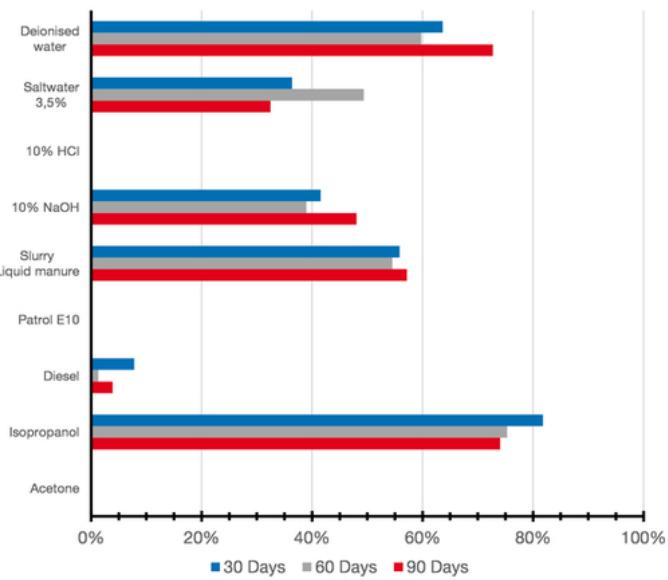
Approvals / Guidelines

ISSA Code	75.509.37
MIL-Spec	complies with MIL-A-47284A

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.

Tensile strength after storage



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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Surface Pre-Treatment

Clean and dry bonding surfaces are essential for flawless adhesive bonding (e.g. cleaning and degreasing with WEICON Surface Cleaner). Smooth surfaces can be roughened mechanically.

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 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

- 10029793 Quadro Mixing Nozzle B, 1 PCE, grey
- 10005237 Dispenser Easy-Mix D 50, 1 PCE
- 10000913 Glass Fibre Cloth Tape, 1 PCE, white
- 10068261 Dosing Tip, 1 PCE
- 10101999 WEICON Manual Dispenser, 1 x 1:1 | 2:1

Conversion table

(°C x 1.8) + 32 = °F	Nm x 8.851 = lb·in
mm/25.4 = inch	Nm x 0.738 = lb·ft
µm/25.4 = mil	Nm x 141.62 = oz·in
N x 0.225 = lb	mPa·s = cP
N/mm² x 145 = psi	N/cm x 0.571 = lb/in
MPa x 145 = psi	kV/mm x 25.4 = V/mil

Available sizes

- 10047457 Easy-Mix RK-7300 Structural Acrylic Adhesive, 50 ml, translucent / hazy white

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