Structural Acrylic Adhesives
RK structural adhesives and Plastic-Bond

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.

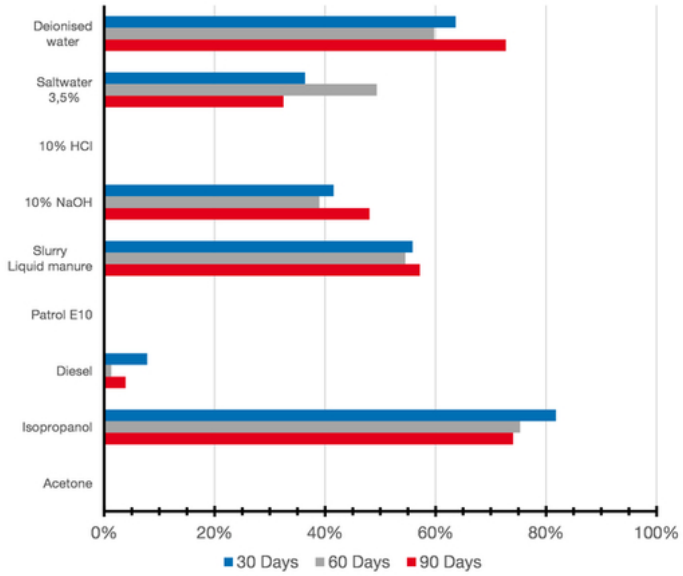
Characteristics		
Base		methyl methacrylate
Texture		pasty
Colour		translucent / hazy white
Minimum shelf life	at room temperature	6 mon.
Processing		
Processing procedure		Easy-Mix
Processing temperature		+10°C to +40°C
Curing temperature		> +16 °C
Mixing ratio by weight		1:1
Viscosity of the mixture		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 (polytetrafluorethylene)		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
Approvals / Guidelines		
ISSA Code		75.509.37

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.

Lap shear strength after storage



Determined on V4A

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 pretreatment

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. +5C and below, no reaction takes place.

Storage

WEICON structural acrylic 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	Mixing Nozzle MBQ

Accessories

10005237	Dispenser Easy-Mix D 50, 1 PCE
10108052	
10000913	Glass Fibre Cloth Tape, 1 PCE, white
10068261	Dosing Tip A Size 0,5 mm, 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/mm^2 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

To the product detail page:

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