Epoxy Resin Systems
**Epoxy adhesives**

# WEICON Easy-Mix HT 250 Epoxy Adhesive


UL-TESTED

**Very high temperature resistance up to +200 °C (+392 °F), briefly up to +250 °C (+482 °F) |high adhesion to metals | high thermal conductivity and high resistance to aggressive media and powder coatings**

WEICON Easy-Mix HT 250 is a 2-component adhesive based on epoxy resin with a high temperature resistance up to +200 °C; briefly up to +250 °C. The 2-C epoxy resin system shows particularly high adhesion to metals and fibreglass. Its excellent suitability for special applications is demonstrated by the high thermal conductivity combined with the high temperature resistance. The adhesive keeps over 80 % of its strength even at constantly high temperatures. This enables the bonding of components, which are thermo-coated (powder-coated) after curing. The epoxy resin adhesive has a high resistance to aggressive substances, such as hot and cold water, motor oil and glycol. For the application of the Easy-Mix product, the Dispenser Easy-Mix D 50 is required.

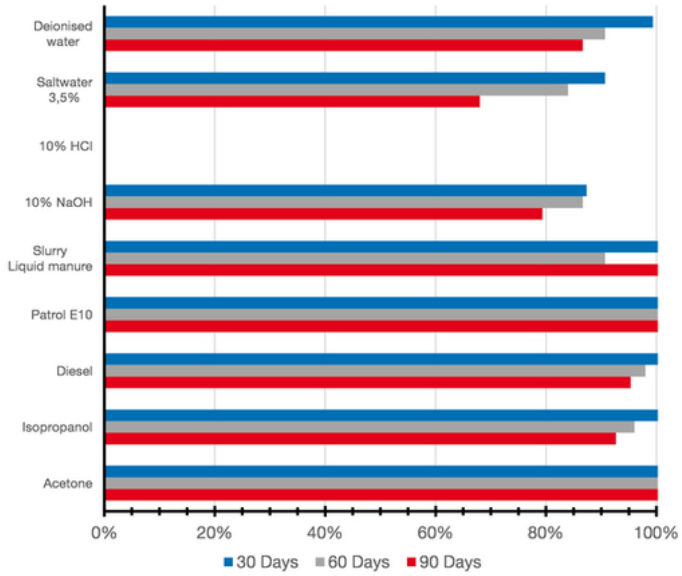
| **Characteristics** | | |
|---|---|---|
| Base | | epoxy resin |
| Texture | | viscous |
| Colour | | light grey |
| Minimum shelf life | at room temperature | 18 mon. |
| **Processing** | | |
| Processing temperature | | +10 °C to +40 °C |
| Curing temperature | | +10 °C - +50 °C |
| Mixing ratio by volume | | 2:1 |
| Viscosity of the mixture | at +20 °C | 38.000 mPa·s |
| Density of the mixture | | 2,1 g/cm³ |
| Gap bridging up to max. | | 4 mm |

| **Curing** | | |
|---|---|---|
| Pot life | at 20 °C, 10 ml batch | 150 min. |
| Working strength after | (50 % strength) | 8 h |
| Final strength | (100 % strength) | 24 (30 min. \| 80°C) h |
| **Mechanical properties after curing** | | |
| Tensile strength | DIN EN ISO 527-2 | 50 MPa |
| Elongation at break (tensile) | DIN EN ISO 527-2 | 2.9 % |
| Hardness (Shore D) | DIN ISO 7619 | > 90 |
| Lap shear strength material thickn. 1,5mm DIN EN 1465 | | |
| Steel 1.0338 sandblasted | | 20 N/mm² |
| Aluminium sandblasted | | 15 N/mm² |
| ABS | | 6 N/mm² |
| PC (polycarbonate) | | 4 N/mm² |
| GFRP | | 10 N/mm² |
| **Thermal parameters** | | |
| Temperature resistance | | -50 bis 200, briefly up to +250 °C |
| Tg after curing at room temperature | (DSC) | ~ +65 °C |
| Tg after tempering (at 80°C) | (DSC) | +130 °C |
| Thermal expansion coefficient | ISO 11359 | 5·10^-5K^-1 1/m·K |
| Thermal conductivity | | 1,4 W/m·K |
| **Electrical parameters** | | |
| Dielectric strength | DIN EN 60243-1 (20°C) | >24 kV/mm |
| **Approvals / Guidelines** | | |
| 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



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## Surface Pre-Treatment

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

## Curing

In order to obtain a permanently high temperature resistance, it should be annealed by heating at 80 °C for 30 minutes after 24 hours.

## 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 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 | Helix Mixing Nozzle B

## Accessories

| | |
|---|---|
| 10005237 | Dispenser Easy-Mix D 50, 1 PCE |
| 10030395 | Helix Mixing Nozzle B, 1 PCE, white |
| 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

| | |
|---|---|
| 10056568 | WEICON Easy-Mix HT 250 Epoxy Adhesive, 50 ml, light grey |

To the product detail page:



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