

# Easy-Mix PE-PP 45



## Fast | high-strength | process-safe

WEICON Easy-Mix PE-PP 45 is a 2-component construction adhesive based on methyl acrylate. It is especially suitable for structural, high-strength bondings of low surface energy plastics such as PE, PP and TPE. Pre-treatment is unnecessary, as the “integrated primer” in the adhesive activates the surfaces and enables high-strength bonding.

The Dispenser Easy-Mix D 50 is required for processing Easy-Mix products in 50 ml cartridges.

### Characteristics

Base	methyl acrylate	
Texture	pasty	
Colour	nearly colourless, translucent	
Minimum shelf life	at room temperature	3 mon.
Minimum shelf life	from +2 °C to +7 °C	6 Mon.

### Processing

Processing procedure	Easy-Mix	
Mixing ratio by weight	10:1	
Viscosity of the mixture	45.000 mPa·s	
Density of the mixture	1,07 g/cm³	
Gap bridging up to max.	0.2 mm	

### Curing

Pot life	at 20 °C	2-3 min.
Handling strength	(35 % strength)	120-180 min.
Working strength after	(50 % strength)	180-240 min.
Final strength	(100 % strength)	24 h

### Note

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WEICON Middle East L.L.C.  
United Arab Emirates  
phone +971 4 880 25 05  
info@weicon.ae

WEICON Inc.  
Canada  
phone +1 877 620 8889  
info@weicon.ca

WEICON Czech Republic s.r.o.  
Czech Republic  
phone +42 (0) 417 533 013  
info@weicon.cz

WEICON Ibérica S.L.  
Spain  
phone +34 (0) 914 7997 34  
info@weicon.es

WEICON GmbH & Co. KG  
(Headquarters) Germany  
phone +49 (0) 551 9322 0  
info@weicon.de

WEICON Italia S.r.l.  
Italy  
phone +39 (0) 010 2924 871  
info@weicon.it

WEICON Romania SRL  
Romania  
phone +40 (0) 3 65 730 763  
office@weicon.com

WEICON SA (Pty) Ltd  
South Africa  
phone +27 (0) 21 709 0088  
info@weicon.co.za

WEICON South East Asia Pte Ltd  
Singapore  
Phone +65 6710 7671  
info@weicon.com.sg

WEICON Kimya Sanayi Tic. Ltd. Şti.  
Türkiye  
phone +90 (0) 212 465 33 65  
info@weicon.com.tr

### Mechanical properties after curing

Lap shear strength material thickn. 1,5mm DIN EN 1465	17 N/mm²
Steel 1.0338 sandblasted	16 N/mm²
Stainless steel V2A sandblasted	14 N/mm²
PVC-rigid roughened	16 N/mm²
CFRP	17 N/mm²
GFRP	6 N/mm²
Polyamide 6.6	2 N/mm²
PE-HD	7 N/mm²
PP (polypropylene)	8 N/mm²

### Thermal parameters

Temperature resistance	-50 °C to +80 °C
Tg after curing at room temperature (DSC)	46,3 °C
Temperature conductivity	0,127 mm²/s
Thermal conductivity	DIN EN ISO 22007-4 0,21 W/m·K
Heat capacity	DIN EN ISO 22007-4 1,534 J/(g·K)

### Electrical parameters

Resistance	2,20 · 10¹²
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### Approvals / Guidelines

MIL-Spec	complies with	MIL-A-47284A
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### 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

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.

# Easy-Mix PE-PP 45

## Scope of delivery

Adhesive | Mixing Nozzle 10:1 B | Instructions for use

## Accessories

- 10023115 Mixing Nozzle 10:1 B, 10 PCE, orange
- 10023333 Dispenser PE-PP, 1 PCE
- 10023341 Special Piston, 1 PCE
- 10102860 WEICON Manual Dispenser, 1 x 10:1

## 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

- 10057687 Easy-Mix PE-PP 45 Structural Acrylic Adhesive, 45 ml, nearly colourless, translucent

To the product detail page:



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WEICON Ibérica S.L.  
Spain  
phone +34 (0) 914 7997 34  
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