

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

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/cm ³
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

Mechanical properties after curing

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

Thermal parameters

Temperature resistance	-50 °C to +80 °C	
Tg after curing at room temperature (DSC)	46,3 °C	
Temperature conductivity	0,127 mm ² /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 · 10 ¹²
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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) 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.

Processing

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

6 months at 0°C to +4°C 3 months at 20°C to +25°C

Scope of delivery

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

Accessories

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

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.

Easy-Mix PE-PP 45

Conversion table

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

Available sizes

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

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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) 010 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