

# Easy-Mix RK-7000 Structural Acrylic Adhesive



**Slow-curing | high-strength | impact-resistant | residual elasticity**

WEICON Easy-Mix RK-7000 can be used to bond numerous materials such as plastics, metals and ceramics with high tensile, shear and peel strength. It is particularly suitable for structural bondings where high strength connections are required. It is highly viscous and is therefore suitable for processing on vertical surfaces. WEICON RK-7000 is universally applicable and can be used, for example, in plastics technology, in metal construction, in car body and vehicle construction, in mechanical engineering, in electrical engineering, in wood processing or in trade show and exhibition construction.

## Characteristics

Base	methyl methacrylate	
Texture	viscous	
Colour	off-white, milky	
Minimum shelf life	at room temperature	12 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	40.000-60.000 mPa·s	
Density of the mixture	0,98-1,02 g/cm <sup>3</sup>	
Gap bridging up to max.	5 mm	

## Curing

Pot life	at 20 °C	15 min.
Handling strength	(35 % strength)	40 min.
Working strength after	(50 % strength)	60 min.
Final strength	(100 % strength)	12 h

## Mechanical properties after curing

Tensile strength	DIN EN ISO 527-2	24 N/mm <sup>2</sup>
Elongation at break (tensile)	DIN EN ISO 527-2	28 %
E-modulus (tensile)	DIN EN ISO 527-2	1200 - 1500 MPa
Lap shear strength material thicken. 1,5mm DIN EN 1465		
Steel 1.0338 sandblasted		23 N/mm <sup>2</sup>
Stainless steel V2A sandblasted		22 N/mm <sup>2</sup>
Aluminium sandblasted		20 N/mm <sup>2</sup>
PVC-rigid roughened		12 N/mm <sup>2</sup>
CFRP		22 N/mm <sup>2</sup>
ABS		7 N/mm <sup>2</sup>
PC (polycarbonate)		11 N/mm <sup>2</sup>
GFRP		21 N/mm <sup>2</sup>
PMMA		9 N/mm <sup>2</sup>
Polyamide 6.6		1 N/mm <sup>2</sup>

## Thermal parameters

Temperature resistance		-55°C to +125°C
Tg after curing at room temperature (DSC)		-39,8 °C
Temperature conductivity		0,118 mm <sup>2</sup> /s
Thermal conductivity	DIN EN ISO 22007-4	0,2 W/m·K
Heat capacity	DIN EN ISO 22007-4	1,453 J/(g·K)

## Electrical parameters

Resistance	DIN EN 62631-3-1	1,83 · 10 <sup>11</sup> Ω·m
Dielectric strength	DIN EN 60243-1 (20°C)	21 kV/mm

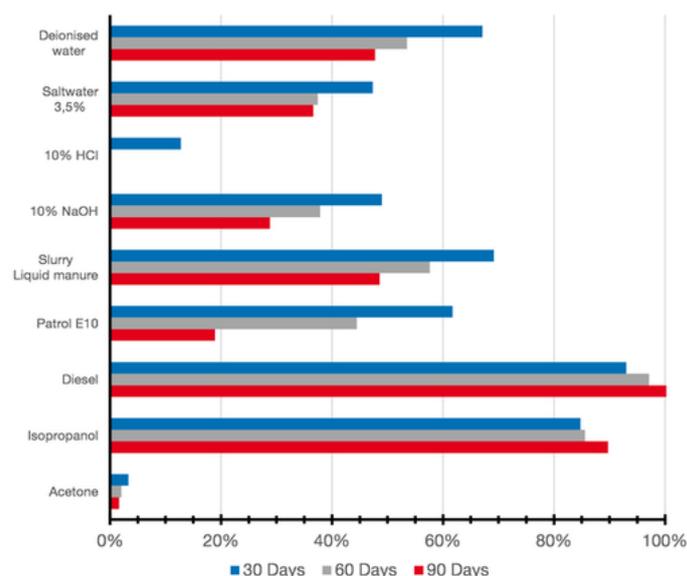
## Approvals / Guidelines

ISSA Code	75.629.55
IMPA Code	812994

## 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.

## Tensile strength after storage



## Note

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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) 10 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

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## Surface Pre-Treatment

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

clean and degrease with Surface Cleaner). Higher strengths can be achieved by further pre-treatment of the surfaces, such as roughening by blasting or grinding. Some low-energy plastics, especially PTFE and polyolefins etc., can only be bonded after special pre-treatment of the surfaces by e.g. fluorination, low-pressure plasma, corona, flame treatment, or similar.

## Application

Easy-Mix RK-7000 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 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 | Quadro Mixing Nozzle B

## Accessories

10005237	Dispenser Easy-Mix D 50, 1 PCE
10068334	Cartridge gun VBA (MR) 400A Alu Frame, 1 PCE
10029793	Quadro Mixing Nozzle B, 1 PCE, grey
10068261	Dosing Tip A Size 0,5 mm, 1 PCE
10028608	Dispenser Easy-Mix D 400, 1 PCE
10101999	WEICON Manual Dispenser, 1 x 1:1   2:1

## 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

10018563	Easy-Mix RK-7000 Structural Acrylic Adhesive, 50 ml, off-white, milky
10033395	Easy-Mix RK-7000 Structural Acrylic Adhesive, 400 ml, off-white, milky

To the product detail page:



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