# Easy-Mix PE-PP 50 Structural Acrylic Adhesive




**transparent | for low surface energy plastics | for small bonding gaps**

WEICON Easy-Mix PE-PP 50 is a 2-component construction adhesive based on methyl acrylate. Due to its transparent curing, it is particularly suitable for visually appealing, high-strength adhesive bonding of low surface energy plastics, such as PE, PP and TPE.

Thanks to its special formula, the adhesive is suitable for zero-gap bonds and for connecting surfaces with extremely small bonding gaps of less than 0,2 mm.

The structural adhesive has a fast strength build-up and a high final strength. It is impact-resistant, ageing-resistant, chemical-resistant, and slightly thixotropic.

PE-PP 50 has a short pot life of six minutes and a processing time of twelve minutes. It is applied with a 1:1 system and does not require pre-treatment of the bonding surfaces, as the adhesive has an integrated primer.

For the application of the Easy-Mix product, the Dispenser Easy-Mix D 50 is required.

**Characteristics**

| | | |
|---|---|---|
| Base | | methyl methacrylate |
| Texture | | pasty |
| Colour | | transparent |
| Minimum shelf life | at room temperature | 3 mon. |
| Minimum shelf life | from +2 °C to +7 °C | 12 Mon. |

**Processing**

| | | |
|---|---|---|
| Processing procedure | | Easy-Mix |
| Mixing ratio by weight | | 1:1 |
| Viscosity of the mixture | | 20.000 mPa·s |
| Density of the mixture | | 1 g/cm³ |
| Gap bridging up to max. | | 0 - 1,00 mm |

**Curing**

| | | |
|---|---|---|
| Pot life | at 20 °C | 6 min. |
| Handling strength | (35 % strength) | 12 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 | 12 MPa |
| Stainless steel V2A sandblasted | 11 MPa |
| Aluminium sandblasted | 12 MPa |
| Galvanized steel | 7 MPa |
| PVC-rigid roughened | 12 MPa |
| CFRP | 12 MPa |
| ABS | 3 MPa |
| PC (polycarbonate) | 6 MPa |
| GFRP | 15 MPa |
| PMMA | 8 MPa |
| Polyamide 6.6 | 2 MPa |
| PE-HD | 12 MPa |
| PP (polypropylene) | 8 MPa |

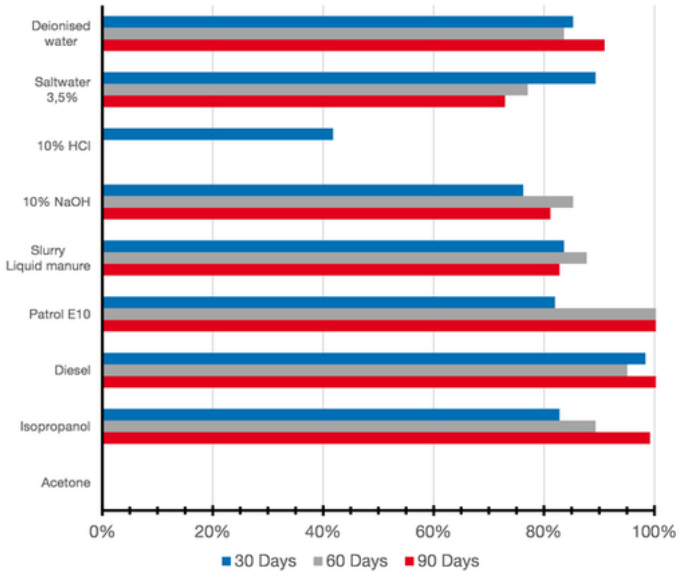
**Thermal parameters**

| | |
|---|---|
| Temperature resistance | -50 °C to +80 °C, briefly up to +100 °C |

## 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




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*Determined on V4A*

## 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.

## Mixing

PE-PP 50 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.

## Application

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## 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.

## Accessories

| | |
|---|---|
| 10005237 | Dispenser Easy-Mix D 50, 1 PCE |
| 10108052 | |
| 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

| | |
|---|---|
| 10058667 | Easy-Mix PE-PP 50 Structural Acrylic Adhesive, 50 ml, transparent |
| 10062144 | Easy-Mix PE-PP 50 Structural Acrylic Adhesive, 24 ml, transparent |
| 10062146 | Easy-Mix PE-PP 50 Structural Acrylic Adhesive, 24 ml (Set), transparent |

To the product detail page:

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