

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/cm ³
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

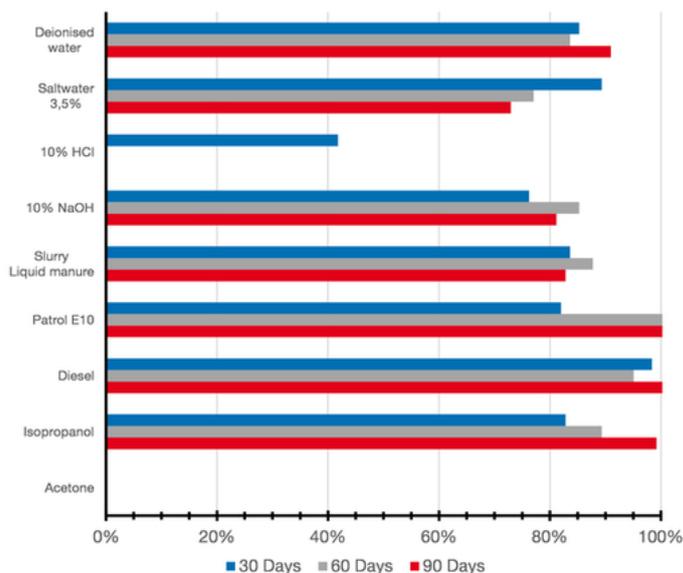
Thermal parameters

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

Tensile strength after storage



Note

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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.

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.

Scope of delivery

Adhesive | Helix Mixing Nozzle

Accessories

- 10005237 Dispenser Easy-Mix D 50, 1 PCE
- 10029793 Quadro Mixing Nozzle B, 1 PCE, grey
- 10030395 Helix Mixing Nozzle B, 1 PCE, white
- 10068261 Dosing Tip A Size 0,5 mm, 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

- 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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