

## RK-1300



膏状  
高强度  
固化迅速

WEICON RK 1300结构胶具备极高的耐冲击、剥离和剪切强度。

该产品含一支胶水和一瓶催化剂，使用前无需将两者进行混合，适用于各种材质。

WEICON RK 1300尤其适用于金属和硬质塑料的粘接。

WEICON RK 1300能够用于机械制造、车辆工程、工具和模具制造、建筑和家具行业，以及诸多其他行业。

## 技术参数

基础成分	甲基丙烯酸甲酯
固化后的颜色	深米色，不透明
混合物密度	1,2 g/cm <sup>3</sup>
混合物粘度	21.000 mPa·s
操作步骤	无需混合
质地	膏状
达到初始强度（35%强度）所需时间	6 分钟
达到机械强度（50%强度）所需时间	9 分钟
固化所需最低温度	+18 °C
达到最终强度（100%强度）所需时间	24 h
最大粘接缝隙	0,4 - 0,8 mm
依据 DIN EN 1465，拉伸剪切强度为：	
铝	20 N/mm <sup>2</sup>
钢质表面 喷砂处理	25 N/mm <sup>2</sup>
不锈钢	25 N/mm <sup>2</sup>
PC（聚碳酸酯）	10 N/mm <sup>2</sup>
PMMA	9 N/mm <sup>2</sup>
ABS	6 N/mm <sup>2</sup>
硬质PVC	7 N/mm <sup>2</sup>
玻璃纤维增强塑料	16 N/mm <sup>2</sup>

## 提示

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CFK	24 N/mm <sup>2</sup>
聚酰胺6.6	2 N/mm <sup>2</sup>
耐温性	-50至+130，短时可达+180 °C
ISSA 编码	75.629.52
IMPA 编码	812991

## 表面预处理

为确保粘接效果，待粘接的物体表面需干燥、清洁（可使用WEICON表面清洁剂进行清洁与去脂）。若需达到更高的粘接强度，可事先用喷砂或研磨工具对物体表面进行粗糙处理。部分塑料，尤其是聚酰胺、聚四氟乙烯、聚烯烃等，必须经过如氟化反应、低压等离子、电晕火焰冲刷等表面特殊处理后方可粘接。

## 操作

## RK催化剂的使用

粘接缝隙的大小决定了催化剂是否应单侧涂抹亦或双侧涂抹（可采用刷、喷或浸渍方式）。若粘接缝隙不超过0.4 mm，则只需在待粘接物体的单侧涂抹RK催化剂；若粘接缝隙达到0.8 mm，且/或粘接表面为粗糙、多孔或惰性材质（铬合金、镍等）时，则需要双侧使用RK催化剂。光滑的塑料和金属表面大约需要30 g/m<sup>2</sup>催化剂；粗糙、多孔的表面大约需要150 g/m<sup>2</sup>催化剂。催化剂在室温（20°C）环境下的挥发时间为至少5分钟。该系列产品的优势突出体现在，涂上催化剂的那一侧可以在室温（20°C）条件下存放最多30天，而后与涂上胶水的一侧进行粘接，其粘接效果不受长时间储存的影响。

## RK胶水的使用

胶水通常仅需单侧涂抹，且涂抹在未使用催化剂的一侧。在双侧均使用催化剂的情况下，粘接缝隙最大可达0.80 mm。当粘接缝隙介于0.15 mm至0.25 mm时，胶水的拉伸剪切强度为最高。

## 操作温度

涂胶操作应在室温（大约20°C）环境下进行。较高的温度（如40°C）会使可操作时间及固化时间缩短大约30%；较低的温度（大约10°C）则会使可操作时间及固化时间延长大约50%；当温度低于5°C时，则几乎不会发生任何化学反应。

## 储藏

WEICON RK结构胶在原装密封且室温稳定维持于+20°C的干燥环境中可至少储存12个月。若存放温度介于+1°C至+7°C之间，则保质期将延长至24个月。当温度超过+40°C且空气湿度较高时，保质期将缩短至6个月。

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## 技术参数表

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### 安全与健康

使用WEICON产品时，需注意产品的物理性、安全性、毒性、生态性的详细参数以及我们EG材料安全数据表 ( www.weicon.com ) 的具体信息。

### 包装

10560060	RK-1300 60 g
10560330	RK-1300 330 g
10560800	RK-1300 1,0 kg
10561906	RK-1300 6,0 kg

### 产品配件

10653050	易混合型胶枪D 50, D50
10953001	处理抹刀, 短
10953003	处理抹刀, 长
13955050	棉球,

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# RK-1300 Structural Acrylic Adhesive



**pasty  
strong  
fast-curing**

WEICON RK-1300 Structural Adhesive has high impact, peel, and shear strength.

The system consists of adhesive and activator which are used in the "no mix" procedure. This makes processing easier by eliminating mixing procedures. The product is particularly suitable for bonding large surfaces of many different materials such as metals, ferrites and rigid plastics.

WEICON RK-1300 can be used in mechanical and apparatus engineering, vehicle construction, tool and mould making, the building and furniture industry and in many other industrial applications.

## Technical Data

Base	Methyl methacrylate
Colour after curing	beige, opaque
Density of the mixture	1,2 g/cm <sup>3</sup>
Viscosity of the mixture	21.000 mPa·s
Application procedure	No-Mix
Texture	pasty
Handling strength (35% strength) after	6 min.
Capable of bearing mechanical loads (50% strength) after	9 min.
Processing temperature	+10 to +40 °C
Curing temperature	+18 °C
Final strength (100%) after	24 h
Adhesive gap bridging	0,4 - 0,8 mm
Shear strength according to DIN EN 1465 at:	
Aluminium	20 N/mm <sup>2</sup>
Steel sand blasted	25 N/mm <sup>2</sup>
Stainless Steel	25 N/mm <sup>2</sup>
PC	10 N/mm <sup>2</sup>

## 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.

PMMA	9 N/mm <sup>2</sup>
ABS	6 N/mm <sup>2</sup>
Hard-PVC	7 N/mm <sup>2</sup>
GRP	16 N/mm <sup>2</sup>
CFK	24 N/mm <sup>2</sup>
Polyamide 6.6	2 N/mm <sup>2</sup>
Temperature resistance	-50 to +130 briefly to +180 °C
ISSA-Code	75.629.52
IMPA-Code	812991

## Surface pre-treatment

To ensure perfect bonding, the surfaces to be joined must be clean and dry (to clean and degrease use WEICON Surface Cleaner). The highest strength values can be achieved through additional pre-treatment of the surfaces, such as roughening using blasting or abrasive agents. Several plastics, in particular polyamide, PTFE, polyolefin etc. can only be bonded after special surface treatment, for example using fluoridation, low-pressure plasma, corona, flame impingement etc.

## Processing

### Processing of the RK Activator

The RK Activator is applied, depending on the size of the bonding gap, on either one side or both sides of the surfaces to be bonded (brush, spray, dip). In case of bond lines with a max. of 0.4 mm in width, the Activator only needs to be applied on one side, for bond lines of up to a max. of 0.8 mm in width and/or rough, porous or passive surfaces (chrome, nickel etc) the Activator must be applied on both sides. For smooth plastic and metal surfaces, approx. 30 g/m<sup>2</sup> is necessary, for rough and porous surfaces up to 150 g/m<sup>2</sup> of Activator may be necessary. The evaporation time at room temperature (+20°C) is at least 5 minutes. A significant advantage to other adhesive systems is that the coated components can be stored up to 30 days at room temperature (+20°C) without losing effectiveness.

### Processing of the RK Adhesive

The Adhesive is applied only on one side and normally on the surface which is not coated with Activator. The size of the bonding gap can be up to 0.80 mm (only if the Activator is applied on both sides). Bonding gaps of 0.15 mm to 0.25 mm in width always have the highest tensile shear strength.

For smooth plastic and metal surfaces, approx. 180g/m<sup>2</sup> of the adhesive are needed, for rough and porous surfaces approx. 300g/m<sup>2</sup>.

### Processing temperature

The processing should take place at room temperature (approx. +20°C). Higher temperatures, e.g. +40°C shorten the positioning and curing times by approx. 30%, lower temperatures of approx. +10°C increase the respective times by approx. 50% and at down +5°C almost no reaction occurs anymore.

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**Storage**

WEICON RK Construction Adhesives have a shelf life of at least 12 months if stored in a dry room at a constant temperature of approx. +20°C. At temperatures between +1°C and +7°C the shelf life can be extended up to 24 months. This applies for closed original units which have not been directly or indirectly exposed to sunlight. In case of storage temperatures exceeding +40°C and high humidity, the shelf-life is shortened to 6 months.

**Safety and health**

When using WEICON products, the physical, safety technical, toxicological and ecological data and regulations in our EC safety data sheets ([www.weicon.com](http://www.weicon.com)) must be observed.

**Available sizes:**

10560060	RK-1300 Structural Acrylic Adhesive 60 g
10560330	RK-1300 Structural Acrylic Adhesive 330 g
10560800	RK-1300 Structural Acrylic Adhesive 1,0 kg
10561906	RK-1300 Structural Acrylic Adhesive 6,0 kg

**Accessories:**

10653050	Dispenser D 50, 50 ml
10953001	Processing Spatula, short
10953003	Processing Spatula, long
13955050	Primer Applicator,

**Note**

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