

RK-1300 & RK-1500 的催化剂



结构胶RK 1300/1500的催化剂

技术参数

催化剂粘度	质地极稀
催化剂密度	0,87 g/cm ³
催化剂颜色	无色, 透明
催化剂的用量 (取决于待粘接材料表面的特性)	30 - 150 g/m ²
+20°C时催化剂挥发所需时间	5 分钟
+20°C时催化剂使用后的最长有效期限	30 天

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/m²催化剂; 粗糙、多孔的表面大约需要150 g/m²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, 而后再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

胶水通常仅需求单侧涂抹, 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。

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

10562100 RK-1300 & RK-1500 的催化剂 100 g
10562901 RK-1300 & RK-1500 的催化剂 1 L

提示

本资料中列出的所有产品, 其参数和建议是我们在实验室的测试结果及经验总结, 不得被视为对产品特性的保证。由于每一个用的实际应用情况并不在我们的认知、控制及责任范围内, 我们对这些信息并不承担任何义务。我们保证我们的产品符合并遵守我们销售条款中承诺的高品质、无瑕疵的要求。我们建议用户通过自行试验来论证其希望选用的产品是否完全符合预期。因用户未遵照指定的操作方法使用产品而造成损失的情况, 用户将独自承担全部责任。

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Activator for RK-1300 & RK-1500



Activator for RK-1300/1500

Technical Data

Viscosity Activator	very thin liquid
Specific weight	0,87 g/cm ³
Colour Activator	colourless, transparent
Consumption depending on surface structure	30 - 150 g/m ²
Evaporation time of the activator at +20°C	5 min.
Effectiveness of the Activator after application at +20°C	30 day(s)

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/m² is necessary, for rough and porous surfaces up to 150 g/m² 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.

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.

Storage

WEICON RK-Activator has a shelf life of at least 6 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 sunrays. In case of storage temperatures exceeding +40°C and high humidity, the shelf-life is considerably shortened.

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) must be observed.

Available sizes:

10562100	Activator for RK-1300 & RK-1500 100 g
10562901	Activator for RK-1300 & RK-1500 1 L

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.

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