

易混合型 RK-7200



透明
高强度
剩余弹性, 耐冲击

结构胶 RK 7200以MMA (甲基丙烯酸甲酯) 为基础成分, 高强度, 固化迅速, 不含溶剂, 适用于各种材质。

该产品固化后无色透明, 因而特别适用于塑料与玻璃的粘接。此外, RK 7200还适合结构型粘合, 因为有颜色的粘接缝隙会影响粘接部件的整体视觉效果。

该产品还可以粘接透明的塑料材质 (如有机玻璃) 以及其他金属, 可实现同材及异材粘接。

技术参数

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| 基础成分 | 甲基丙烯酸甲酯 |
| 混合比例 (树脂/固化剂) | 1:1 |
| 固化后颜色 | 透明, 无色 |
| 混合物密度 | 1,2 g/cm ³ |
| 混合物粘度 | 5.000 - 8.000 mPa·s |
| 操作步骤 | 易混合 |
| 质地 | 半流体状 |
| 温度为+20°C时的可操作时间 | 1 - 2 分钟 |
| 达到初始强度 (35%强度) 所需时间 | 8 分钟 |
| 达到机械强度 (50%强度) 所需时间 | 120 分钟 |
| 达到最终强度 (100%强度) 所需时间 | 6 h |
| 最大粘接缝隙 | 0,1 - 2,0 mm |
| 依据 DIN EN 1465, 拉伸剪切强度为: | |
| 铝 | 8 N/mm ² |
| 钢质表面 喷砂处理 | 18 N/mm ² |
| 不锈钢 | 18 N/mm ² |
| PC (聚碳酸酯) | 7 N/mm ² |
| 在室温下固化后的玻璃转换温度 | -17,5 °C |
| PMMA | 9 N/mm ² |

提示

本资料中列出的所有产品, 其参数和建议是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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| ABS | 7 N/mm ² |
| 硬质PVC | 8 N/mm ² |
| 玻璃纤维增强塑料 | 9 N/mm ² |
| CFK | 12 N/mm ² |
| 聚酰胺6.6 | 2 N/mm ² |
| 耐温性 | -40 至 +120 °C |

表面处理

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

WEICON Easy-Mix 易混合系列产品可借助于随包装附赠的胶嘴, 直接从胶瓶中挤出。将最先挤出的5 cm胶水弃置。涂胶时仅需单侧涂抹。技术数据表上显示的可操作时间是在室温环境下、10 ml胶水的可操作时间。胶水的用量越多, 则可操作时间便越短。更高的温度同样也会缩短可操作时间和固化时间 (经验法则: 温度每上升10°C, 可操作和固化时间都将缩短一半)。当温度低于+16°C时, 可操作及固化时间将极大延长。当温度低于+5°C时, 胶水则不会发生任何化学反应。

储藏

0°C至+4°C温度环境下可储存6个月, +20°C至+25°C温度环境下可储存3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

10564050 易混合型 RK-7200 50 g

产品配件

10650005 易混合型胶嘴,
10653050 易混合型胶枪D 50, D50
12955175 精密胶嘴,

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Easy-Mix RK-7200 Structural Acrylic Adhesive



transparent
high strength
impact resistant, residual elasticity

WEICON Easy-Mix RK-7200 is a high strength, solvent-free and fast-curing structural adhesive. It is based on MMA (methyl methacrylate) and has an excellent adhesion on many materials.

Because of the transparent curing, RK-7200 is particularly suitable for transparent joints where the bonding seam should not be visible. This adhesive can also be used for structural bondings where a coloured adhesive would not fit optically to the construction parts.

Thus, transparent plastics like e. g. acrylic glass (PMMA) and other materials can be bonded in a clean and appealing way.

Technical Data

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|--|-------------------------|
| Base | Methyl methacrylate |
| Mixing ratio resin/hardener | 1:1 |
| Colour after curing | transparent, colourless |
| Density of the mixture | 1,2 g/cm ³ |
| Viscosity of the mixture | 5.000 - 8.000 mPa·s |
| Application procedure | Easy-Mix |
| Texture | viscous |
| Pot life at +20°C (+68°F) | 1 -2 min. |
| Handling strength (35% strength) after | 8 min. |
| Capable of bearing mechanical loads (50% strength) after | 120 min. |
| Processing temperature | +10 to +40 °C |
| Curing temperature | +18 °C |
| Final strength (100%) after | 6 h |
| Adhesive gap bridging | 0,1 - 2,0 mm |
| Shear strength according to DIN EN 1465 at: | |
| Aluminium | 8 N/mm ² |
| Steel sand blasted | 18 N/mm ² |

| | |
|-------------------------------------|----------------------|
| Stainless Steel | 18 N/mm ² |
| PC | 7 N/mm ² |
| Tg after curing at room temperature | -17,5 °C |
| PMMA | 9 N/mm ² |
| ABS | 7 N/mm ² |
| Hard-PVC | 8 N/mm ² |
| GRP | 9 N/mm ² |
| CFK | 12 N/mm ² |
| Polyamide 6.6 | 2 N/mm ² |
| Temperature resistance | -40 to +120 °C |

Surface pre-treatment

The prerequisite for perfect adhesion are clean and dry surfaces (e.g. cleaning and degreasing with 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, Teflon®, polyolefin etc. can only be bonded after special surface treatment, for example using fluoridation, low-pressure plasma, corona, flame impingement etc.

Processing

WEICON Easy-Mix products can be processed directly from the double cartridges with the help of the included static mixer. Reject the first 5 cm of the dosed bead. Apply adhesive to only one of the surfaces to be bonded. The pot life given is for a material quantity of 10 ml at room temperature. If larger quantities are used, the curing time will be faster. Similarly, higher ambient temperatures shorten the cure times (as a rule of thumb, every +10°C increase above room temperature will halve working and curing time). Temperatures below +16°C will extend working and curing times considerably, while below about +5°C, no reaction will take place at all.

Storage

6 months at 0°C to +4°C 3 months at 20°C to 25°C

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:

10564050 Easy-Mix RK-7200 Structural Acrylic Adhesive 50 g

Accessories:

10650005 Mixing Nozzles Easy-Mix,
10653050 Dispenser D 50, 50 ml
12955175 Dosing Tips,

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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