

塑料粘合剂



对塑料的附着力出色 高强度 耐冲击 具剩余弹性

WEICON塑料粘合剂是一款不含溶剂的结构胶，它对塑料、铝、钢等均具有极强的附着力。它能够承受静态与动态载荷，耐冲击强度及剪切强度高，最大粘接缝隙为5mm。

塑料粘合剂尤其适用于高强度的结构性粘接。该款胶水粘度极高，因而亦适用于垂直表面的粘接操作。

该产品通用于各个行业领域，如金属加工、汽车制造、机械制造、电子技术、木材加工及展台搭建等。

技术参数

基础成分	甲基丙烯酸甲酯
固化后的颜色	乳白色
混合比例（树脂/固化剂）	1:1
混合物密度	0,98 - 1,02 g/cm ³
混合物粘度	40.000 - 60.000 mPa·s
操作步骤	AB面操作方式
质地	质地粘稠
温度为+20°C时的可操作时间	15 分钟
达到初始强度（35%强度）所需时间	40 分钟
达到机械强度（50%强度）所需时间	60 分钟
操作温度	+10 至 +40 °C
固化所需最低温度	+18 °C
达到最终强度（100%强度）所需时间	12 h
最大粘接缝隙	0,1 - 5,0 mm
依据 DIN EN 1465，拉伸剪切强度为：	
铝	20 N/mm ²
钢质表面 喷砂处理	23 N/mm ²
不锈钢	22 N/mm ²
PC（聚碳酸酯）	11 N/mm ²
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。

ABS	7 N/mm ²
硬质PVC	12 N/mm ²
玻璃纤维增强塑料	21 N/mm ²
CFK	22 N/mm ²
聚酰胺6.6	1 N/mm ²
耐温性	-55 至 +125 °C
IMPA 编码	812993

表面预处理

为了达到完美的粘接效果，待粘接的物体表面必须保持洁净、干燥（可事先使用表面清洁剂进行预处理）。对粘接表面进行粗糙处理能够提高粘接效果。一些表面张力较低的材料（特别是PTFE和聚烯烃等）只能在表面特殊处理（例如氟化反应、低压等离子体、电晕火焰冲刷等）后，方能进行粘接。

操作

直接将塑料粘合剂挤出胶瓶即可使用。最初挤出的数厘米胶水应弃置。将挤出的胶水均匀搅拌，快速涂抹在待粘接的物体表面，随后即刻进行粘接。

储藏

未拆封室温（+23°C，50 %相对空气湿度）环境可储存12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

10565024 塑料粘合剂 24 ml

产品配件

10650005 易混合型胶嘴，

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Plastic-Bond



excellent adhesion on plastics
high strength
shock and impact resistant

WEICON Plastic-Bond is a solvent-free structural adhesive with very good adhesion to plastics, aluminum, steel and much more. The adhesive is suitable for static as well as dynamic loads, has a high impact and peel strength and a maximum gap filling capacity of 5 mm.

Plastic-Bond is particularly suitable for structural bondings where high strength connections are required. It has a high viscosity and is suitable for processing on vertical surfaces.

The structural adhesive is universally applicable and can be used, for example, in plastics technology, in metal construction, in car body and vehicle construction, in mechanical engineering, in electrical engineering, in wood processing or in construction works at exhibitions.

Technical Data

Base	Methyl methacrylate
Colour after curing	cream white, milky
Mixing ratio resin/hardener	1:1
Density of the mixture	0,98 - 1,02 g/cm³
Viscosity of the mixture	40.000 - 60.000 mPa·s
Application procedure	A-B-method
Texture	thixotropic
Pot life at +20°C (+68°F)	15 min.
Handling strength (35% strength) after	40 min.
Capable of bearing mechanical loads (50% strength) after	60 min.
Processing temperature	+10 to +40 °C
Curing temperature	+18 °C
Final strength (100%) after	12 h
Adhesive gap bridging	0,1 - 5,0 mm
Shear strength according to DIN EN 1465 at:	

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.

Aluminium	20 N/mm²
Steel sand blasted	23 N/mm²
Stainless Steel	22 N/mm²
PC	11 N/mm²
PMMA	9 N/mm²
ABS	7 N/mm²
Hard-PVC	12 N/mm²
GRP	21 N/mm²
CFK	22 N/mm²
Polyamide 6.6	1 N/mm²
Temperature resistance	-55 to +125 °C
IMPA-Code	812993

Surface pre-treatment

The prerequisite for perfect adhesion are clean and dry surfaces (e.g. cleaning and degreasing with WEICON Surface Cleaner). The best results are achieved when the surfaces to be bonded are mechanically roughened. The adhesive is applied only on one side.

Processing

Plastic-Bond can be processed directly from the double cartridge. Reject the first centimetre of the dosed bead. Mix the product thoroughly. Apply adhesive mixture quickly to only one of the surfaces to be bonded. Join both surfaces immediately afterwards.

Storage

The shelf life is 12 months when stored unopened at a normal climate (+23°C and 50 % rel. humidity).

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:

10565024 Plastic-Bond 24 ml

Accessories:

10650005 Mixing Nozzles Easy-Mix,

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