

易混合型 RK-7300



对塑料及EPDM的黏附性极高，高强度，具剩余弹性，耐冲击

WEICON 结构胶RK 7300是一款以MMA丙烯酸甲酯为基础成分的结构胶，它固化迅速，不含溶剂。该产品对各种材质都具有出色的粘附力，强度极高。

它能够承受各种静态和动态的压力，且可以高强度粘接低表面张力的塑料材质，如聚乙烯和聚丙烯。

该产品的剩余弹性使其能够粘接膨胀系数相异的材质，如塑料与铝或塑料与钢。

特殊的填充成分（玻璃珠）让粘接缝隙能稳定保持在0.25 mm。最大粘接缝隙为1 mm。

技术参数

基础成分	甲基丙烯酸甲酯
固化后的颜色	半透明/雾白色
混合比例（树脂/固化剂）	1:1
混合物密度	1,00 g/cm ³
混合物粘度	170.000 - 200.000 mPa·s
操作步骤	易混合
质地	膏状
温度为+20°C时的可操作时间	8 分钟
达到初始强度（35%强度）所需时间	60 分钟
达到机械强度（50%强度）所需时间	480 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	24 h
最大粘接缝隙	0,25 - 1,0 mm
依据 DIN EN 1465，拉伸剪切强度为：	
铝	5 N/mm ²
钢质表面 喷砂处理	5 N/mm ²
不锈钢	4 N/mm ²

提示

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PC (聚碳酸酯)	6 N/mm ²
在室温下固化后的玻璃转换温度	51,5 °C
PMMA	6 N/mm ²
ABS	8 N/mm ²
硬质PVC	11 N/mm ²
玻璃纤维增强塑料	7 N/mm ²
CFK	7 N/mm ²
聚酰胺6.6	3 N/mm ²
POM (聚甲醛)	5 N/mm ²
HDPE (高密度聚乙烯)	5 N/mm ²
PP (聚丙烯)	6 N/mm ²
PTFE (聚四氟乙烯)	2 N/mm ²
EPDM (邵氏硬度A70)	1 N/mm ²
耐温性	-55至+100 °C
热扩散率 (23 °C)	0,118 mm ² /s
热传导率	0,15 W/m·K
比热容	1,489 J/(g·K)
电阻率	1,25 · 10 ¹³ Ωm

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）。光滑表面需先用机械方式进行粗糙处理。

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。

WEICON GmbH & Co. KG
(Headquarters)
Germany
phone +49 (0) 251 9322
0
info@weicon.de
www.weicon.de

WEICON SA (Pty) Ltd
South Africa
phone +27 (0) 21 709
0088
info@weicon.co.za
www.weicon.co.za

WEICON Middle East L.L.C.
United Arab Emirates
phone +971 4 880 25 05
info@weicon.ae
www.weicon.ae

WEICON South East Asia Pte Ltd
Singapore
phone (+65) 6710 7671
info@weicon.com.sg
www.weicon.com.sg

WEICON Inc.
Canada
phone +1 877 620 8889
info@weicon.ca
www.weicon.ca

WEICON Czech Republic
s.r.o.
Czech Republic
phone +42 (0) 417 533 013
info@weicon.cz
www.weicon.cz

WEICON Kimya Sanayi Tic. Ltd.
Şti.
Turkey
phone +90 (0) 212 465 33 65
info@weicon.com.tr
www.weicon.com.tr

WEICON Ibérica S.L.
Spain
phone +34 (0) 914 7997 34
info@weicon.es
www.weicon.es

WEICON Romania SRL
Romania
phone +40 (0) 3 65 730
763
office@weicon.com
www.weicon.com.ro

WEICON Italia S.r.l.
Italy
phone (+39) 0102924871
info@weicon.it
www.weicon.it

技术参数表

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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

未开封室温（+23°C，50%相对空气湿度）环境可储存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

10569050 易混合型 RK-7300 50 g

产品配件

10650005 易混合型胶嘴,
10653050 易混合型胶枪D 50, D50
10850005 玻璃纤维布胶带, 50 mm x 1 m
12955175 精密胶嘴,

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(Headquarters)
Germany
phone +49 (0) 251 9322
0
info@weicon.de
www.weicon.de

WEICON SA (Pty) Ltd
South Africa
phone +27 (0) 21 709
0088
info@weicon.co.za
www.weicon.co.za

WEICON Middle East L.L.C.
United Arab Emirates
phone +971 4 880 25 05
info@weicon.ae
www.weicon.ae

WEICON South East Asia Pte Ltd
Singapore
phone (+65) 6710 7671
info@weicon.com.sg
www.weicon.com.sg

WEICON Inc.
Canada
phone +1 877 620 8889
info@weicon.ca
www.weicon.ca

WEICON Czech Republic
s.r.o.
Czech Republic
phone +42 (0) 417 533 013
info@weicon.cz
www.weicon.cz

WEICON Kimya Sanayi Tic. Ltd.
Şti.
Turkey
phone +90 (0) 212 465 33 65
info@weicon.com.tr
www.weicon.com.tr

WEICON Ibérica S.L.
Spain
phone +34 (0) 914 7997 34
info@weicon.es
www.weicon.es

WEICON Romania SRL
Romania
phone +40 (0) 3 65 730
763
office@weicon.com
www.weicon.com.ro

WEICON Italia S.r.l.
Italy
phone (+39) 0102924871
info@weicon.it
www.weicon.it

Easy-Mix RK-7300 Structural Acrylic Adhesive



excellent adhesion on plastics and EPDM
high strength
highly viscous, impact resistant

WEICON Easy-Mix RK-7300 is a fast curing, solvent free structure and construction adhesive based on MMA (methyl methacrylate). RK-7300 adheres perfectly on a variety of materials and has a high adhesive strength.

It can be applied universally for static and dynamic loads. High strength bondings are also possible in case of low energy plastics, such as PE or PP.

Its high viscosity characteristics also permits material pairing with different expansion coefficients, such as plastic / aluminium or steel.

Special fillers (glass beads) ensure a consistent bonding line of 0.25 mm; maximum gap-bridging: 1 mm.

Technical Data

Base	Methyl methacrylate
Colour after curing	translucent / creamy white
Mixing ratio resin/hardener	1:1
Density of the mixture	1,00 g/cm ³
Viscosity of the mixture	170.000 - 200.000 mPa·s
Application procedure	Easy-Mix
Texture	pasty
Pot life at +20°C (+68°F)	8 min.
Handling strength (35% strength) after	60 min.
Capable of bearing mechanical loads (50% strength) after	480 min.
Processing temperature	+10 to +40 °C
Curing temperature	+18 °C
Final strength (100%) after	24 h
Adhesive gap bridging	0,25 - 1,0 mm
Shear strength according to DIN EN 1465 at:	

Aluminium	5 N/mm ²
Steel sand blasted	5 N/mm ²
Stainless Steel	4 N/mm ²
PC	6 N/mm ²
Tg after curing at room temperature	51,5 °C
PMMA	6 N/mm ²
ABS	8 N/mm ²
Hard-PVC	11 N/mm ²
GRP	7 N/mm ²
CFK	7 N/mm ²
Polyamide 6.6	3 N/mm ²
POM (polyoxymethylene)	5 N/mm ²
PE-HD	5 N/mm ²
PP (polypropylene)	6 N/mm ²
PTFE (polytetrafluorethylene)	2 N/mm ²
EPDM (Shore A 70)	1 N/mm ²
Temperature resistance	-55 to +100 °C
Thermal diffusivity (23 °C)	0,118 mm ² /s
Thermal conductivity	0,15 W/m·K
Specific heat capacity	1,489 J/(g·K)
Resistivity	1,25 · 10 ¹³ Ωm

Surface pre-treatment

The prerequisite for perfect adhesion are clean and dry surfaces (e.g. cleaning and degreasing with WEICON Surface Cleaner). Smooth surfaces can be roughened mechanically.

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

Note

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WEICON GmbH & Co. KG
(Headquarters)
Germany
phone +49 (0) 251 9322 0
info@weicon.de
www.weicon.de

WEICON Middle East L.L.C.
United Arab Emirates
phone +971 4 880 25 05
info@weicon.ae
www.weicon.ae

WEICON Inc.
Canada
phone +1 877 620 8889
info@weicon.ca
www.weicon.ca

WEICON Kimya Sanayi Tic. Ltd. Şti.
Turkey
phone +90 (0) 212 465 33 65
info@weicon.com.tr
www.weicon.com.tr

WEICON Romania SRL
Romania
phone +40 (0) 3 65 730 763
office@weicon.com
www.weicon.com.ro

WEICON SA (Pty) Ltd
South Africa
phone +27 (0) 21 709 0088
info@weicon.co.za
www.weicon.co.za

WEICON South East Asia Pte Ltd
Singapore
phone (+65) 6710 7671
info@weicon.com.sg
www.weicon.com.sg

WEICON Czech Republic s.r.o.
Czech Republic
phone +42 (0) 417 533 013
info@weicon.cz
www.weicon.cz

WEICON Ibérica S.L.
Spain
phone +34 (0) 914 7997 34
info@weicon.es
www.weicon.es

WEICON Italia S.r.l.
Italy
phone (+39) 0102924871
info@weicon.it
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Technical Datasheet

Create Date:17.08.2020 - Seite2/2

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

The shelf life is 6 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:

10569050 Easy-Mix RK-7300 Structural Acrylic Adhesive 50 g

Accessories:

10650005 Mixing Nozzles Easy-Mix,
10653050 Dispenser D 50, 50 ml
10850005 Glass Fibre Cloth Tape, 50 mm x 1 m
12955175 Dosing Tips,

Note

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www.weicon.de

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United Arab Emirates
phone +971 4 880 25 05
info@weicon.ae
www.weicon.ae

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Canada
phone +1 877 620 8889
info@weicon.ca
www.weicon.ca

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Turkey
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info@weicon.com.tr
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Romania
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office@weicon.com
www.weicon.com.ro

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South Africa
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info@weicon.co.za
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info@weicon.cz
www.weicon.cz

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Spain
phone +34 (0) 914 7997 34
info@weicon.es
www.weicon.es

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Italy
phone (+39) 0102924871
info@weicon.it
www.weicon.it