

Easy-Mix HT 180



耐高温，耐压，耐冲击

WEICON 耐高温型易混合HT 180是一款以环氧树脂为基础的双组份粘合剂。它耐高温达 +180°C，短时可达+230°C。

该产品粘度较高，亦适合于垂直平面的粘接。它 耐压、耐冲击，可操作时间长，室温固化，固化 后可机械加工。它特殊的填充成分让它能够让粘 接缝隙保持平整。

该款胶水尤其适用于复合材料与金属的粘接，在 未固化时可点焊。

除此之外，耐高温型易混合HT 180还能用于粘 接缝隙较大的塑料、陶瓷、玻璃、石材和木材 的粘接。该产品特殊的填充成分让它能将填充 缝隙保持在最小0.20-0.25 mm。

该产品耐高温，完全固化后可使用热敏涂料对其 进行涂漆操作（粉末喷涂）。

技术参数

| | |
|----------------------------|-----------------------|
| 基础成分 | 环氧树脂矿物质填充 |
| 质地 | 膏状, 填充型 |
| 颜色 | 黑色 |
| 重量混合比例（树脂/固化剂） | 2:1 |
| 混合物密度 | 1,1 g/cm ³ |
| 温度为+20°C时的混合物密度 | 膏状 |
| 最大粘接缝隙 | 4 mm |
| 操作温度 | +10 至 +40 °C |
| 固化温度 | +10 至 +50 °C |
| 温度为+20°C、混合物重量为10g时的可操作时间 | 60 分钟 |
| 达到初始强度（35%强度）所需时间 | 120 分钟 |
| 达到机械强度（50%强度）所需时间 | 4 h |
| 达到最终强度（100%强度）所需时间 | 24 h |
| 依据 DIN EN 1465，纯环氧树脂的平均强度为 | |
| 压力 | 52 Mpa |
| 拉伸 | 27 Mpa |
| 折弯 | 46 Mpa |

提示

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| | |
|--------------------------|----------------------------|
| 在室温下固化后的玻璃转换温度 | 54,4 °C |
| 120 °C回火处理后的玻璃转换温度 | 44,7 °C |
| 弹性模量 | 2.300 - 2.700 Mpa |
| 邵氏硬度 D | 80 |
| 依据 DIN EN 1465，平均拉伸剪切强度为 | |
| 钢质表面 镀锌处理 | 8 N/mm ² |
| 钢质表面 喷砂处理 | 23 N/mm ² |
| 铝质表面 喷砂处理 | 13 N/mm ² |
| V2A级钢 打磨处理 | 24 N/mm ² |
| 硬质PVC表面 粗糙处理 | 11 N/mm ² |
| CFK | 22 N/mm ² |
| 线性收缩率 | 0,3 % |
| 耐温性 | -50至+180，短时可达+230 °C |
| 热扩散率 (23 °C) | 0,172 mm ² /s |
| 热传导率 | 0,26 W/m·K |
| 比热容 | 1,335 J/(g·K) |
| 电阻率 | 2,48 · 10 ¹¹ 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）。

操作

WEICON易混合系列可通过产品附带的胶嘴，直接从胶瓶中挤出。将最初的5 cm弃置。粘接时只需要单侧涂胶。

本资料中所提供的可加工时间是10毫升胶水在室温条件下的测试结果。若材料用量大于该数值，固化时间会缩短，这是由环氧树脂典型的热反应所致（放热反应）。更高的环境温度也会缩短固化时间（根据经验，以室温为基准，环境温度每增加10°C，可操作时间和固化时间将减半）。若温度低于16°C，则可操作时间和固化时间将被极大延长；温度低于5°C，则不会发生任何化学反应。

储藏

WEICON HT 180 在室内恒温+20°C、干燥且未开封的情况下，可存放至少24个月。避免阳光直射。未遵循说明书指示，储藏期将缩短至6个月。环氧树脂很容易在低于5°C情况下结晶。温度大范围变化会加重结晶，冬季运输过程中经常出现这种状况。尽管这些影响可以通过加热产品至最高50°C（禁止明火）来缓解，但这对产品的操作、固化和技术特性仍会产生负面影响。WEICON环氧树脂粘合剂的基础树脂成分（双酚A和F）经过精心配比，能有效减少特殊环境中结晶现象的产生。

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。

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技术参数表

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| | |
|----------|-----------------------|
| 包装 | |
| 10650850 | Easy-Mix HT 180 50 ml |
| 产品配件 | |
| 10650006 | 易混合型胶嘴, |
| 10653050 | 易混合型胶枪D 50, D50 |

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Easy-Mix HT 180 Epoxy Adhesive



high-temperature resistant
steady
shock and impact resistant

WEICON Easy-Mix HT 180 is a 2-component adhesive on epoxy resin basis and has a high temperature resistance of up to +180°C; short term to +230°C.

The adhesive is highly viscous and stable which makes it also suitable for vertical applications. It is shock and impact resistant, has a long pot life, cures at room temperature, can be processed mechanically and his special fillers allow a constant bonding line. The adhesive is particularly suitable for the bonding of composite materials and metal and can be spot-welded while curing.

Easy-Mix HT 180 can furthermore be utilised for plastics, ceramic, glass, stone or wood and is suitable for adhesions where larger tolerances have to be bridged. Due to special fillers it is possible to achieve a constant and reliable bonding line of at least 0.20 - 0.25 mm.

The high temperature resistance permits the bonding of components which require powder-coating after complete curing.

Technical Data

| | |
|--|---------------------------------|
| Base | Epoxy resin mineral-filled |
| Texture | paste consistency, crack-filler |
| Colour | black |
| Mixing ratio by weight (Resin / Hardener) | 2:1 |
| Density of the mixture | 1,1 g/cm³ |
| Viscosity of the mixture at 20°C (+68°F) | paste |
| Adhesive gap bridging up to max. | 4 mm |
| Processing temperature | +10 to +40 °C |
| Curing temperature | +10 to +50 °C |
| Pot life at 20°C (+68°F) for 10ml material | 60 min. |
| Handling strength (35% strength) after | 120 min. |
| Capable of bearing mechanical loads (50% strength) after | 4 h |

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.

| | |
|--|-------------------------------|
| Final strength (100%) after | 24 h |
| Medium strength of the pure epoxy resin according to DIN EN 1465 | |
| Pressure | 52 Mpa |
| Pull | 27 Mpa |
| Bending | 46 Mpa |
| Tg after curing at room temperature | 54,4 °C |
| Tg after tempering (at 120 °C) | 44,7 °C |
| E-Modul | 2.300 - 2.700 Mpa |
| Shore hardness D | 80 |
| Medium shear strength according to DIN EN 1465 at | |
| Galvanized steel | 8 N/mm² |
| Steel sand blasted | 23 N/mm² |
| Alu sandblasted | 13 N/mm² |
| V2A polished | 24 N/mm² |
| PVC hard-roughened | 11 N/mm² |
| CFK | 22 N/mm² |
| Linear shrinkage | 0,3 % |
| Temperature resistance | -50 to 180 briefly to +230 °C |
| Thermal diffusivity (23 °C) | 0,172 mm²/s |
| Thermal conductivity | 0,26 W/m·K |
| Specific heat capacity | 1,335 J/(g·K) |
| Resistivity | 2,48 · 10 ¹¹ Ωm |

Surface pre-treatment

To ensure a perfect bond, the surfaces to be joined must be clean and dry (e.g., clean and degrease using WEICON Surface Cleaner).

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

When unopened and stored at a constant room temperature of approx. +20°C in a dry place, WEICON HT 180 has a shelf life of at least 24 months. Protect from direct sunlight. In case of non-observance of these storage instructions, the shelf life is reduced to 6 six months. In general, epoxy resins tend to crystallise at temperatures below +5°C. This effect is increased by large temperature fluctuations, e.g. during transport especially in the winter months. This has a negative impact on processing, curing

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Technical Datasheet

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and technical data, can, however, be reversed by heating the product (up to max. +50°C, no open flame). In WEICON Epoxy Adhesives, crystallisation is reduced by the careful choice and combinations of base resins (bisphenol A and F).

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:

10650850 Easy-Mix HT 180 Epoxy Adhesive 50 ml

Accessories:

10650006 Mixing Nozzles,
10653050 Dispenser D 50, 50 ml

Note

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