

易混合型金属粘合剂



用于金属粘接的最佳选择，半流体，固化迅速

WEICON Easy-Mix 易混合型金属粘合剂还可应用于其他多种材质，如塑料、纤维复合型材料、陶瓷、玻璃、石材和木材等。该产品既可用于调整较大偏差，也可作为浇铸材料使用。

技术参数

基础成分	环氧树脂
质地	半流体状
颜色	灰绿色
重量混合比例（树脂/固化剂）	1:1
混合物密度	1,8 g/cm ³
温度为+20°C时的混合物密度	300.000 mPa·s
最大粘接缝隙	4 mm
操作温度	+10 至 +30 °C
固化温度	+6 至 +40 °C
温度为+20°C、混合物重量为10g时的可操作时间	4 - 5 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	2 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	10 Mpa
拉伸	24 Mpa
折弯	58 Mpa
在室温下固化后的玻璃转换温度	44,3 °C
90 °C回火处理后的玻璃转换温度	32,5 °C
弹性模量	4.000 - 4.500 Mpa
邵氏硬度 D	70
依据 DIN EN 1465，平均拉伸剪切强度为	
钢质表面 喷砂处理	20 N/mm ²
铝质表面 喷砂处理	19 N/mm ²
硬质PVC表面 粗糙处理	11 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。

线性收缩率	0,3 %
耐温性	-50 至 +145 °C
热扩散率 (23 °C)	0,286 mm ² /s
热传导率	0,51 W/m·K
比热容	0,904 J/(g·K)
电阻率	4,57 · 10 ⁻¹² Ωm

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）。

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

在室内恒温+20°C、干燥且未拆封的情况下，WEICON环氧树脂可存放至少18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、毒理性、生态性的详细参数以及我们JEG材料安全数据表（www.weicon.com）的具体信息。

包装

10652050 易混合型金属粘合剂 50 ml

产品配件

10650006 易混合型胶嘴，
10653050 易混合型胶枪D 50, D50
10953001 处理抹刀，
12955175 精密胶嘴，

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Easy-Mix Metal Epoxy Adhesive



Ideal for bonding of metal parts
self-levelling, viscous
fast curing

WEICON Easy-Mix Metal can be used on numerous materials such as metal, plastic, fibre reinforced materials, ceramics, glass, stone and wood.

Suitable for bonds requiring larger tolerances to be bridged and for grouting works.

Technical Data

Base	Epoxy resin
Texture	viscous
Colour	grey-green
Mixing ratio by weight (Resin / Hardener)	1:1
Density of the mixture	1,8 g/cm ³
Viscosity of the mixture at 20°C (+68°F)	300.000 mPa·s
Adhesive gap bridging up to max.	4 mm
Processing temperature	+10 to +30 °C
Curing temperature	+6 to +40 °C
Pot life at 20°C (+68°F) for 10ml material	4 -5 min.
Handling strength (35% strength) after	40 min.
Capable of bearing mechanical loads (50% strength) after	2 h
Final strength (100%) after	24 h
Medium strength of the pure epoxy resin according to DIN EN 1465	
Pressure	10 Mpa
Pull	24 Mpa
Bending	58 Mpa
Tg after curing at room temperature	44,3 °C
Tg after tempering (at 90 °C)	32,5 °C
E-Modul	4.000 - 4.500 Mpa
Shore hardness D	70
Medium 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.

Steel sand blasted	20 N/mm ²
Alu sandblasted	19 N/mm ²
PVC hard-roughened	11 N/mm ²
Linear shrinkage	0,3 %
Temperature resistance	-50 to +145 °C
Thermal diffusivity (23 °C)	0,286 mm ² /s
Thermal conductivity	0,51 W/m·K
Specific heat capacity	0,904 J/(g·K)
Resistivity	4,57 · 10 ¹² 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 kept at a constant room temperature of about +20°C and unopened in dry conditions, WEICON Epoxy Adhesives will keep for at least 18 months. Avoid direct sunlight. If these storage instructions are disregarded, the storage life will be reduced to 6 months. Epoxy resins are fundamentally liable to crystallise at temperatures of less than +5°C. This effect is accentuated by wide variations in temperature such as can frequently occur during transport in winter. This also has a negative effect on working qualities, curing and technical details, although these effects can be reversed by warming up to a maximum of +50°C (no naked flame). In the case of WEICON Epoxy Adhesives, careful selection and combination of the base resins (bisphenol A and F) ensures a reduction of crystallisation.

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:

10652050 Easy-Mix Metal Epoxy Adhesive 50 ml

Accessories:

10650006 Mixing Nozzles,

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Technical Datasheet

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10653050 Dispenser D 50, 50 ml
10953001 Processing Spatula,
12955175 Dosing Tips,

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