

## 易混合PE-PP 45



## 快速，高强度，操作精准

WEICON快速易混合型PE-PP 45一款以丙烯酸甲酯为基础成分的双组分结构性粘合剂，特别适用于惰性塑料（例如PE，PP和TPE）的高强度结构性粘接。

## 技术参数

基础成分	甲基丙烯酸甲酯
固化后的颜色	几乎无色，半透明
混合比例（树脂/固化剂）	10:1
混合物密度	1,07 g/cm <sup>3</sup>
混合物粘度	45.000 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	2-3 分钟
达到初始强度（35%强度）所需时间	120-180 分钟
达到机械强度（50%强度）所需时间	180-240 分钟
达到最终强度（100%强度）所需时间	24 h
最大粘接缝隙	0,2 - 1,0 mm
依据 DIN EN 1465，拉伸剪切强度为：	
铝	14 N/mm <sup>2</sup>
钢质表面 喷砂处理	17 N/mm <sup>2</sup>
不锈钢	16 N/mm <sup>2</sup>
PC（聚碳酸酯）	6 N/mm <sup>2</sup>
在室温下固化后的玻璃转换温度	46,3 °C
PMMA	7 N/mm <sup>2</sup>
ABS	11 N/mm <sup>2</sup>
硬质PVC	14 N/mm <sup>2</sup>
玻璃纤维增强塑料	17 N/mm <sup>2</sup>
CFK	16 N/mm <sup>2</sup>
聚酰胺6.6	6 N/mm <sup>2</sup>
POM（聚甲醛）	2 N/mm <sup>2</sup>

## 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。

HDPE（高密度聚乙烯）	7 N/mm <sup>2</sup>
PP（聚丙烯）	8 N/mm <sup>2</sup>
耐温性	-50 至 +80 °C
热扩散率（23 °C）	0,127 mm <sup>2</sup> /s
热传导率	0,21 W/m·K
比热容	1,534 J/(g·K)
电阻率	2,20 · 10 <sup>12</sup> Ωm

## 表面处理

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。

## 操作

WEICON易混合型产品的混合工作可借助搅拌胶嘴直接完成。最初挤出的5厘米胶水应弃置。仅需将粘合剂涂抹于待粘接表面的其中一面即可。本资料中所提供的可加工时间是10ml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。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）。

## 储藏

在0°C至+4°C的温度环境中可保存6个月，在+20°C至+25°C的温度环境中可保存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

10660038 易混合PE-PP 45 38 ml 雾白色

## 产品配件

10660002 胶嘴PE-PP,  
10663038 胶枪PE-PP,  
10663110 特殊推进器,

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# Easy-Mix PE-PP 45 Structural Acrylic Adhesive



**fast**  
**high strength**  
**process-safe**

WEICON Easy-Mix PE-PP 45 is a two-component construction adhesive on the basis of methyl acrylate. It is in particular suitable for structural, high-strength bonding of low energy plastics like PE, PP and TPE.

## Technical Data

Base	Methyl methacrylate
Colour after curing	almost colourless, translucent
Mixing ratio resin/hardener	10:1
Density of the mixture	1,07 g/cm <sup>3</sup>
Viscosity of the mixture	45.000 mPa·s
Application procedure	Easy-Mix
Texture	paste
Pot life at +20°C (+68°F)	2-3 min.
Handling strength (35% strength) after	120-180 min.
Capable of bearing mechanical loads (50% strength) after	180-240 min.
Final strength (100%) after	24 h
Adhesive gap bridging	0,2 - 1,0 mm
Shear strength according to DIN EN 1465 at:	
Aluminium	14 N/mm <sup>2</sup>
Steel sand blasted	17 N/mm <sup>2</sup>
Stainless Steel	16 N/mm <sup>2</sup>
PC	6 N/mm <sup>2</sup>
Tg after curing at room temperature	46,3 °C
PMMA	7 N/mm <sup>2</sup>
ABS	11 N/mm <sup>2</sup>
Hard-PVC	14 N/mm <sup>2</sup>
GRP	17 N/mm <sup>2</sup>
CFK	16 N/mm <sup>2</sup>

## 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.

Polyamide 6.6	6 N/mm <sup>2</sup>
POM (polyoxymethylene)	2 N/mm <sup>2</sup>
PE-HD	7 N/mm <sup>2</sup>
PP (polypropylene)	8 N/mm <sup>2</sup>
Temperature resistance	-50 to +80 °C
Thermal diffusivity (23 °C)	0,127 mm <sup>2</sup> /s
Thermal conductivity	0,21 W/m·K
Specific heat capacity	1,534 J/(g·K)
Resistivity	2,20 · 10 <sup>12</sup> 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

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 w

## 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](http://www.weicon.com)) must be observed.

## Available sizes:

10660038 Easy-Mix PE-PP 45 Structural Acrylic Adhesive 38 ml translucent

## Accessories:

10660002 Mixing Nozzles PE-PP,  
10663038 Dispenser PE-PP,  
10663110 Special Piston,

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