

Easy-Mix PE-PP 50 Structural Acrylic Adhesive



transparent | for low surface energy plastics | for small bonding gaps

WEICON Easy-Mix PE-PP 50 is a 2-component construction adhesive based on methyl acrylate. Due to its transparent curing, it is particularly suitable for visually appealing, high-strength adhesive bonding of low surface energy plastics, such as PE, PP and TPE. Thanks to its special formula, the adhesive is suitable for zero-gap bonds and for connecting surfaces with extremely small bonding gaps of less than 0.2 mm. The structural adhesive has a fast strength build-up and a high final strength. It is impact-resistant, ageing-resistant, chemical-resistant, and slightly thixotropic. PE-PP 50 has a short pot life of six minutes and a processing time of twelve minutes. It is applied with a 1:1 system and does not require pre-treatment of the bonding surfaces, as the adhesive has an integrated primer. For the application of the Easy-Mix product, the Dispenser Easy-Mix D 50 is required.

Characteristics

Base	methyl methacrylate
Texture	pasty
Colour	transparent

Processing

Processing procedure	Easy-Mix
Mixing ratio by weight	1:1
Viscosity of the mixture	20.000 mPa·s
Density of the mixture	1 g/cm ³
Gap bridging up to max.	0 - 1,00 mm

Curing

Pot life	at 20 °C	6 min.
Handling strength	(35 % strength)	12 min.
Final strength	(100 % strength)	24 h

Mechanical properties after curing

Lap shear strength material thickn. 1,5mm DIN EN 1465	
Steel 1.0338 sandblasted	12 MPa
Stainless steel V2A sandblasted	11 MPa
Aluminium sandblasted	12 MPa
Galvanized steel	7 MPa
PVC-rigid roughened	12 MPa
CFRP	12 MPa
ABS	3 MPa
PC (polycarbonate)	6 MPa
GFRP	15 MPa
PMMA	8 MPa
Polyamide 6.6	2 MPa
PE-HD	12 MPa
PP (polypropylene)	8 MPa

Thermal parameters

Temperature resistance	-50 °C to +80 °C, briefly up to +100 °C
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Instructions for use

When using WEICON products, the physical, safety-related, toxicological and ecological data and regulations in our EC safety data sheets (www.weicon.com) must be observed.

Surface pre-treatment

Clean and dry bonding surfaces are essential for flawless adhesive bonding (e.g. cleaning and degreasing with WEICON Surface Cleaner). Smooth surfaces can be roughened mechanically.

Mixing

PE-PP 50 products can be processed straight from the double cartridge by means of the included static mixer. Dismiss the first 5 cm of the adhesive bead. The adhesive is applied to just one side. The specified pot life refers to a material batch of 10 ml at room temperature. Larger batch quantities will result in faster curing. Higher temperatures also reduce the pot life and curing time. (General rule: every increase by +10 °C above room temperature results in a decrease of the pot life and curing time by half). Temperatures below +16 °C increase the pot life and curing time significantly. From approx. +5C and below, no reaction takes place.

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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.

Easy-Mix PE-PP 50 Structural Acrylic Adhesive

Structural Acrylic Adhesives

PE-PP

Shelf life

12 months at +2°C to +7°C;
3 months at +20°C to +25°C

Scope of delivery

Adhesive | Quadro Mixing Nozzle

Accessories

10653050 Dispenser Easy-Mix D 50, 1 PCE
10650005 Quadro Mixing Nozzle, 1 PCE

Conversion table

(°C x 1,8) + 32 = °F	Nm x 8,851 = lb·in
mm/25,4 = inch	Nm x 0,738 = lb·ft
µm/25,4 = mil	Nm x 141,62 = oz·in
N x 0,225 = lb	mPa·s = cP
N/mm ² x 145 = psi	N/cm x 0,571 = lb/in
MPa x 145 = psi	kV/mm x 25,4 = V/mil

Available sizes

10665024 Easy-Mix PE-PP 50 Structural Acrylic Adhesive,
24 ml, transparent
10665025 Easy-Mix PE-PP 50 Structural Acrylic Adhesive,
24 ml, transparent

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