

Overview

Structural Acrylic Adhesives

Construction Adhesives based on methacrylate (MMA)

Structural adhesive for bonding metals, ceramic, glass, most plastics (also low-energy, only type RK-7300 and PE-PP), and many more. Very good adhesion properties and quick fixation.

Can be used for lighting and advertising fixture, mould making, plastics technology, trade show and exhibition construction, electrical engineering, furniture and interior design, mechanical engineering, vehicle construction and many other industrial applications.



Processing
Properties
Colour after curing
Pot life at +20°C (+68°F)
Adhesive gap bridging
Temperature resistance
Average strength acc. to DIN 5328
- Aluminium
- Steel
- Stainless Steel
- PC (polycarbonate)
- PMMA
- ABS
- rigid PVC
- GFK
- CFK
- Polyamide 6.6
- POM (Polyoxymethylen)
- PE-HD
- PP (polypropylene)
- PTFE (polytetrafluorethylene)
- EPDM (Shore A70)

RK-1300	RK-1500
No-Mix	No-Mix
pasty	liquid
beige, opaque	yellow, transparent
-	-
max. 0,40 mm (Activator application on one side*)	
max. 0,80 mm (Activator application on one side*)	
-50°C to +130°C (-58 to +266°F), briefly (30 minutes) to +180°C (+356°F)	
20 N/mm² (2.900 psi)	20 N/mm² (2.900 psi)
25 N/mm² (3.600 psi)	25 N/mm² (3.600 psi)
25 N/mm² (3.600 psi)	30 N/mm² (4.350 psi)
10 N/mm² (1.450 psi)	10 N/mm² (1.450 psi)
9 N/mm² (1.310 psi)	8 N/mm² (1.160 psi)
6 N/mm² (900 psi)	6 N/mm² (900 psi)
7 N/mm² (1.000 psi)	11 N/mm² (1.600 psi)
16 N/mm² (2.320 psi)	20 N/mm² (2.900 psi)
24 N/mm² (3.500 psi)	27 N/mm² (3.920 psi)
2 N/mm² (300 psi)	3 N/mm² (400 psi)
-	-
-	-
-	-
-	-
-	-

RK-7000	RK-7100	RK-7200	RK-7300	PE-PP 45
Easy-Mix	Easy-Mix	Easy-Mix	Easy-Mix	Easy-Mix
viscous	viscous	viscous	pasty	pasty
cream white, milky	cream white, milky	transparent	translucent/creamy white	yellowish, transparent
approx. 15 Min.	approx. 5 Min.	approx. 1 - 2 Min.	approx. 8 Min.	2 - 3 Min.
0,1 - 5,0 mm	0,1 - 5,0 mm	0,1 - 2,0 mm	0,25 - 1,0 mm	0,25 - 1,0 mm
-55 to +125°C (-67 to +257°F)	-55 to +125°C (-67 to +257°F)	-40 to +120°C (-40 to +248°F)	-55 to +100°C (-67 to +212°F)	-50 to +80°C (-58 to +176°F)
20 N/mm² (2.900 psi)	20 N/mm² (2.900 psi)	8 N/mm² (1.160 psi)	5 N/mm² (730 psi)	14 N/mm² (2.030 psi)
23 N/mm² (3.300 psi)	23 N/mm² (3.300 psi)	18 N/mm² (2.600 psi)	5 N/mm² (730 psi)	17 N/mm² (2.470 psi)
22 N/mm² (3.190 psi)	22 N/mm² (3.190 psi)	18 N/mm² (2.600 psi)	4 N/mm² (580 psi)	16 N/mm² (2.320 psi)
11 N/mm² (1.600 psi)	12 N/mm² (1.740 psi)	7 N/mm² (1.020 psi)	6 N/mm² (870 psi)	6 N/mm² (870 psi)
9 N/mm² (1.310 psi)	9 N/mm² (1.310 psi)	9 N/mm² (1.310 psi)	6 N/mm² (870 psi)	7 N/mm² (1.000 psi)
7 N/mm² (1.000 psi)	7 N/mm² (1.000 psi)	7 N/mm² (1.000 psi)	8 N/mm² (1.160 psi)	11 N/mm² (1.600 psi)
12 N/mm² (1.740 psi)	12 N/mm² (1.740 psi)	8 N/mm² (1.160 psi)	11 N/mm² (1.600 psi)	14 N/mm² (2.030 psi)
21 N/mm² (3.000 psi)	21 N/mm² (3.000 psi)	9 N/mm² (1.310 psi)	7 N/mm² (1.000 psi)	17 N/mm² (2.470 psi)
22 N/mm² (3.190 psi)	22 N/mm² (3.190 psi)	12 N/mm² (1.740 psi)	7 N/mm² (1.000 psi)	16 N/mm² (2.320 psi)
1 N/mm² (150 psi)	1 N/mm² (150 psi)	2 N/mm² (290 psi)	3 N/mm² (440 psi)	6 N/mm² (870 psi)
-	-	-	5 N/mm² (730 psi)	2 N/mm² (290 psi)
-	-	-	5 N/mm² (730 psi)	7 N/mm² (1.000 psi)
-	-	-	6 N/mm² (870 psi)	8 N/mm² (1.160 psi)
-	-	-	2 N/mm² (290 psi)	-
-	-	-	1 N/mm² (150 psi)	-

Plastic-Bond
A-B procedure
viscous
cream white, milky
approx. 15 Min.
0,1 - 5,0 mm
-55 to +125°C (-67 to +257°F)
20 N/mm² (2.900 psi)
23 N/mm² (3.300 psi)
22 N/mm² (3.190 psi)
11 N/mm² (1.600 psi)
9 N/mm² (1.310 psi)
7 N/mm² (1.000 psi)
12 N/mm² (1.740 psi)
21 N/mm² (3.000 psi)
22 N/mm² (3.190 psi)
1 N/mm² (150 psi)
-
-
-
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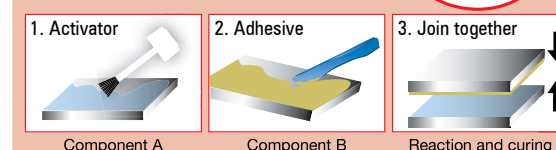


Depending on the geometry and size of the surfaces or the required cycle time, different processing methods are available:

WEICON „No-Mix“
WEICON Easy-Mix
A-B procedure



WEICON „No-Mix“ procedure



The WEICON „No-Mix“ procedure is suited for manufacturing processes with staggered assembly and positioning processes and high cycle times during serial production.

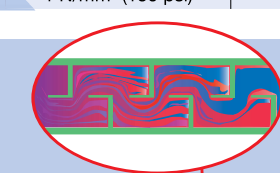
- No mixing
- Avoiding pot life

RK-1300:	60 g ✓ 10560060	330 g ✓ 10560330	1,0 kg ✓ 10560800	6,0 kg ✓ 10561906
RK-1500:	60 g ✓ 10563860	310 g ✓ 10563330	1,0 kg ✓ 10563800	6,0 kg ✓ 10563906

WEICON Easy-Mix Dosing System

Thanks to the modern mixing and dosing system, all types can be dosed cleanly and accurately automatically, mixed and applied in only one working operation. In this way, a uniform quality and process assurance is guaranteed in a production series.

RK-7000	RK-7100	RK-7200	RK-7300	PE-PP 45
50 g ✓ 10565050	50 g ✓ 10566050	50 g ✓ 10564050	50 g ✓ 10569050	38 ml ✓ 10660038



Quadro Mixing Nozzle
10650005

Mixing Nozzle PE-PP
10660002



A-B procedure

Easy handling by manual mixing (1:1), optionally also with the quadro mixing nozzle.



*This information is dependent on the type of materials to be bonded and their respective properties. In case of porous materials or passive surfaces, such as chrome, nickel, etc., the Activator should be applied on both sides. (Bond lines of 0.15 mm to 0.25 mm in width have the highest stability).