

## 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	pasty
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>

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,

### 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.

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