

# Easy-Mix PE-PP 50 Structural Acrylic Adhesive



Final strength (100%) after	24 h
Adhesive gap bridging	0 - 1,00 mm
Shear strength according to DIN EN 1465 at:	
PE	12 N/mm <sup>2</sup>
PP	8 N/mm <sup>2</sup>
Steel sand blasted	12 N/mm <sup>2</sup>
Stainless Steel	11 N/mm <sup>2</sup>
Aluminium SG	12 N/mm <sup>2</sup>
PC	6 N/mm <sup>2</sup>
PMMA	8 N/mm <sup>2</sup>
ABS	3 N/mm <sup>2</sup>
Hard-PVC	12 N/mm <sup>2</sup>
Galvanized steel	7 N/mm <sup>2</sup>
GRP	15 N/mm <sup>2</sup>
CFK	12 N/mm <sup>2</sup>
GFK	15 N/mm <sup>2</sup>
Polyamide 6.6	2 N/mm <sup>2</sup>
Temperature resistance	-50 to +80 (briefly to 100) °C

**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.

**Technical Data**

Base	Methyl methacrylate
Colour after curing	almost colourless, translucent
Mixing ratio resin/hardener	1:1
Density of the mixture	1 g/cm <sup>3</sup>
Viscosity of the mixture	20.000 mPa·s
Application procedure	Easy-Mix
Texture	pasty
Pot life at +20°C (+68°F)	6 min.
Handling strength (35% strength) after	12 min.

**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.

**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 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**

12 months at +2 °C to +7°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:**

10665050 Easy-Mix PE-PP 50 Structural Acrylic Adhesive 50 ml

**Accessories:**

10650005 Mixing Nozzles Easy-Mix,  
10653050 Dispenser Easy-Mix D 50,