

Fast-Metal Minute Adhesive



**with a high solids content, pasty
very short pot life, fast-curing
gap-filling, residual elastic**

WEICON Fast-Metal Minute Adhesive is ideal for repairs and bondings with larger bonding gaps or bigger tolerances. The gap filling properties make it suitable for rough and poorly fitting surfaces but also to fill in cracks, cavities and unlevelled surfaces.

Fast-Metal Minute Adhesive can be used on numerous materials such as metal, plastic, fibre reinforced materials, ceramics, glass, stone and wood.

Technical Data

Base	Epoxy resin highly filled
Texture	pasty consistency, crack-filler
Colour	grey
Mixing ratio by weight (Resin / Hardener)	1:1
Density of the mixture	1,8 g/cm ³
Viscosity of the mixture at 20°C (+68°F)	300.000 mPa·s
Adhesive gap bridging up to max.	4 mm
Processing temperature	+10 to +30 °C
Curing temperature	+6 to +40 °C
Pot life at 20°C (+68°F) for 10ml material	3 -4 min.
Handling strength (35% strength) after	40 min.
Capable of bearing mechanical loads (50% strength) after	2 h
Final strength (100%) after	24 h
Medium strength of the pure epoxy resin according to DIN EN 1465	
Pressure	10 Mpa
Pull	24 Mpa
Bending	58 Mpa
E-Modul	4.000 - 4.500 Mpa
Shore hardness D	70

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.

Medium shear strength according to DIN EN 1465 at	
Steel sand blasted	20 N/mm ²
Alu sandblasted	19 N/mm ²
PVC hard-roughened	11 N/mm ²
Linear shrinkage	0,3 %
Temperature resistance	-50 to +145 °C
Thermal diffusivity (23 °C)	0,286 mm ² /s
Thermal conductivity	0,51 W/m·K
Specific heat capacity	0,904 J/(g·K)
Resistivity	4,57 · 10 ¹² Ωm
ISSA-Code	75.629.51
IMPA-Code	812981

Surface pre-treatment

To ensure a perfect bond, the surfaces to be joined must be clean and dry (e.g., clean and degrease using WEICON Surface Cleaner).

Processing

Fast-Metal Minute Adhesive can be processed directly from the double cartridge. Reject the first centimetre of the dosed bead. Mix the product thoroughly. Apply adhesive mixture quickly to only one of the surfaces to be bonded. Join both surfaces immediately afterwards.

Storage

When kept at a constant room temperature of about +20°C and unopened in dry conditions, WEICON Epoxy Adhesives will keep for at least 18 months. Avoid direct sunlight. If these storage instructions are disregarded, the storage life will be reduced to 6 months. Epoxy resins are fundamentally liable to crystallise at temperatures of less than +5°C. This effect is accentuated by wide variations in temperature such as can frequently occur during transport in winter. This also has a negative effect on working qualities, curing and technical details, although these effects can be reversed by warming up to a maximum of +50°C (no naked flame). In the case of WEICON Epoxy Adhesives, careful selection and combination of the base resins (bisphenol A and F) ensures a reduction of crystallisation.

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) must be observed.

Available sizes:

10551024 Fast-Metal Minute Adhesive 24 ml