

# 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>

## 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.

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 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

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:

10660045 Easy-Mix PE-PP 45 Structural Acrylic Adhesive 45 ml

## Accessories:

10660002 Mixing Nozzles PE-PP,  
10663038 Dispenser PE-PP,  
10663045 Dispenser PE-PP,  
10663110 Special Piston,

WEICON GmbH & Co. KG  
(Headquarters)  
Germany  
phone +49 (0) 251 9322 0  
info@weicon.de  
www.weicon.de

WEICON Middle East L.L.C.  
United Arab Emirates  
phone +971 4 880 25 05  
info@weicon.ae  
www.weicon.ae

WEICON Inc.  
Canada  
phone +1 877 620 8889  
info@weicon.ca  
www.weicon.ca

WEICON Kimya Sanayi Tic. Ltd. Şti.  
Turkey  
phone +90 (0) 212 465 33 65  
info@weicon.com.tr  
www.weicon.com.tr

WEICON Romania SRL  
Romania  
phone +40 (0) 3 65 730 763  
office@weicon.com  
www.weicon.com.ro

WEICON SA (Pty) Ltd  
South Africa  
phone +27 (0) 21 709 0088  
info@weicon.co.za  
www.weicon.co.za

WEICON South East Asia Pte Ltd  
Singapore  
phone +65 (65) 6710 7671  
info@weicon.com.sg  
www.weicon.com.sg

WEICON Czech Republic s.r.o.  
Czech Republic  
phone +42 (0) 417 533 013  
info@weicon.cz  
www.weicon.cz

WEICON Ibérica S.L.  
Spain  
phone +34 (0) 914 7997 34  
info@weicon.es  
www.weicon.es

WEICON Italia S.r.l.  
Italy  
phone (+39) 0102924871  
info@weicon.it  
www.weicon.it