

# Aluminium Minute Adhesive



## Highly-filled, paste-like, gap-filling, fast-curing, high peel and impact strength

WEICON Aluminium Minute Adhesive is an odourless, two-component epoxy adhesive filled with aluminium. It cures fast at room temperature and practically without shrinkage. After curing, the adhesive can be machined (filing, drilling, milling). Aluminium Minute Adhesive is gap-filling and non-dripping (thixotropic) and shows very high tensile, impact and peel strength.

The adhesive is particularly suitable for bonding aluminium and other light metals. It can be used for filling cracks and holes on aluminium housings, for example, and for repairing light alloy wheels.

In order to achieve optimal adhesion, the bonding surfaces should be dry and free from grease or soilings. Scraping or sanding the surfaces before cleaning additionally improves adhesion.

## Technical Data

Base	epoxy resin, highly filled
Texture	paste-like, gap-filling
Colour	aluminium
Mixing ratio by weight (Resin / Hardener)	1:1
Density of the mixture	1.23 g/cm <sup>3</sup>
Viscosity of the mixture at 20°C (+68°F)	125.000 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	4-5 min.
Handling strength (35% strength) after	25 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	8 Mpa
Pull	34 Mpa
Bending	58 Mpa

### 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.

E-Modul	4.000 - 4.500 Mpa
Shore hardness D	45
Medium shear strength according to DIN EN 1465 at	
Steel sand blasted	20 N/mm <sup>2</sup>
Alu sandblasted	19 N/mm <sup>2</sup>
PVC hard-roughened	11 N/mm <sup>2</sup>
Linear shrinkage	0,3 %
Temperature resistance	-50 to + 120 (-58°F bis + 248°F) short-term up to +150 (+302°F) °C

## Surface pre-treatment

Clean and dry bonding surfaces are essential for flawless adhesive bonding (e.g. cleaning and degreasing with WEICON Surface Cleaner).

## Processing

WEICON Aluminium Minute Adhesive can be processed straight from the double cartridge. Dismiss the first centimetre of the adhesive bead. Mix product thoroughly. Apply adhesive to the bonding surface quickly. Then join both bonding surfaces immediately.

## Storage

When stored in unopened condition in a dry place at constant room temperature of approx. +20°C, WEICON Epoxy Adhesives have a shelf life of at least 18 months. Protect from direct sunlight. In case of non-observance of these storage instructions, the shelf life is reduced to 6 months. In general, epoxy resins tend to crystallise at temperatures below +5°C. This effect is increased by large temperature fluctuations, e.g. during transport especially in the winter months. This has a negative impact on processing, curing and technical data, it can, however, be reversed by heating the product (up to max. +50°C, no open flame). In WEICON Epoxy Adhesives, crystallisation is reduced by the careful choice and combination of base resins (bisphenol A and F).

## Safety and health

When using WEICON products, the physical, safety-related, toxicological and ecological data and regulations in our EC safety data sheets ([www.weicon.com](http://www.weicon.com)) must be observed.

## Available sizes:

1055204	Aluminium Minute Adhesive 24 ml
1055205	Aluminium Minute Adhesive Set, 24 ml