

# Easy-Mix Metal Epoxy Adhesive



**Ideal for bonding of metal parts**  
**self-levelling, viscous**  
**fast curing**

WEICON Easy-Mix Metal can be used on numerous materials such as metal, plastic, fibre reinforced materials, ceramics, glass, stone and wood.

Suitable for bonds requiring larger tolerances to be bridged and for grouting works.

## Technical Data

Base	Epoxy resin
Texture	viscous
Colour	grey-green
Mixing ratio by weight (Resin / Hardener)	1:1
Density of the mixture	1,8 g/cm <sup>3</sup>
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	4 -5 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
Tg after curing at room temperature	44,3 °C
Tg after tempering (at 90 °C)	32,5 °C
E-Modul	4.000 - 4.500 Mpa
Shore hardness D	70
Medium shear strength according to DIN EN 1465 at	

## Note

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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 +145 °C
Thermal diffusivity (23 °C)	0,286 mm <sup>2</sup> /s
Thermal conductivity	0,51 W/m·K
Specific heat capacity	0,904 J/(g·K)
Resistivity	4,57 · 10 <sup>12</sup> Ωm

## 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

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

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](http://www.weicon.com)) must be observed.

## Available sizes:

10652050 Easy-Mix Metal Epoxy Adhesive 50 ml

## Accessories:

10650006 Mixing Nozzles,

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) 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

## Technical Datasheet

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10653050 Dispenser D 50, 50 ml  
10953001 Processing Spatula,  
12955175 Dosing Tips,

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(Headquarters)  
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info@weicon.de  
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phone +971 4 880 25 05  
info@weicon.ae  
www.weicon.ae

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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

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Singapore  
phone (+65) 6710 7671  
info@weicon.com.sg  
www.weicon.com.sg

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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

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Italy  
phone (+39) 0102924871  
info@weicon.it  
www.weicon.it