

# Easy-Mix PE-PP 45



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

Basis	Methylmethacrylate
Properties	pasty
Viscosity of the mixture at + 20 °C	45.000 mPa.s
Mixing proportion by volume resin / hardener	10 : 1
Density of the mixture	1,07 g/cm <sup>3</sup>
Pot life at + 20 °C	2 - 3 min.
Processing temperature	+ 20 bis + 25 °C
Curing temperature	+ 15 bis + 70 °C
Gap covering power	bis max. 1,00 mm
Handling strength (35% strength) after	120 bis 180 min.
Mechanical durability (50% strength) after	240 min.
Final hardness (100%) strength after	24 h
Average tensile shear strength after 7 days with DIN 5:	
Aluminium, sand-blasted	15,7 N/mm <sup>2</sup>
Polypropylen	7,6 N/mm <sup>2</sup>
Polyethylen HD	7,4 N/mm <sup>2</sup>
Polyethylen LD	2,8 N/mm <sup>2</sup>
Polyethylen UHMW	5,2 N/mm <sup>2</sup>
Steel, sand-blasted	17,2 N/mm <sup>2</sup>
Stainless steel, sand-blasted	15,9 N/mm <sup>2</sup>
Copper, sand-blasted	15,7 N/mm <sup>2</sup>
ABS, roughened	10,5 N/mm <sup>2</sup>
Hard PVC, roughened	14,1 N/mm <sup>2</sup>
GRP, roughened	17,0 N/mm <sup>2</sup>
Average strength at +20 °C acc. to DIN 53281-83	13 mPa.s
Temperature resistance	- 50 bis + 80 °C
Shore hardness D	55
Expansion	max. 5,3 %

## Pretreatment of the surface

The prerequisite for perfect adhesion are clean and dry surfaces (e.g. cleaning and degreasing with Cleaner S or Plastic Cleaner). Smooth surfaces can be roughened mechanically, for example with grinding

paper grain size P 120.

## 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

## Note

Any product specifications and recommendations given herein 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 warrant the continuously high quality of our products being free from defects in accordance with and subject to our General Sales Conditions. 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.

## Health and Safety

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.

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