

Epoxy Minute Adhesive



viscous, self-levelling
very short pot life, fast-curing
transparent

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

Epoxy Minute Adhesive is suited for construction and assembly work whenever the use of the WEICON Easy-Mix System is inefficient.

Technical Data

Base	Epoxy resin unfilled
Composition	viscous
Colour	transparent
Mixing ratio by weight (Resin / Hardener)	1:1
Density of the mixture	1,15 g/cm ³
Viscosity of the mixture at 20°C (+68°F)	8.500 mPa·s
Adhesive gap bridging up to max.	2 mm
Processing temperatur	+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	30 min.
Capable of bearing mechanical loads (50% strength) after	1 h
Final strength (100%) after	24 h
Medium strength of the pure epoxy resin according to DIN 53281-83	
Pressure	9 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.

Pull	40 Mpa
Bending	58 Mpa
E-Modul	2.000 - 2.500 Mpa
Shore hardness D	65
Medium shear strength according to DIN 53283 at	
Steel sand blasted	20 N/mm ²
Alu sandblasted	19 N/mm ²
PVC hard-roughened	13 N/mm ²
Linear shrinkage	2,0 %
Temperature resistance	-50 to +80 °C
ISSA-Code	75.629.50
IMPA-Code	81 29 80

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

Epoxy 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:

10550024 Epoxy Minute Adhesive 24 ml

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

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

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

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

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

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

Technical Datasheet

Create Date: 17.11.2017 - Seite 2/2

Accessories:

10650005	Mixing Nozzles Easy-Mix, Quadro
11202400	Sealant and Adhesive Remover, 400 ml
11207400	Surface Cleaner, 400 ml
11850200	Hand Protective Foam, 200 ml
12955170	Dosing Tips, Size 0
12955175	Dosing Tips, Typ A Size 0,5

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.

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

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

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

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

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

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