

Easy-Mix RK-7100 Structural Acrylic Adhesive



**fast-curing
high strength
impact resistant, residual elasticity**

WEICON Easy-Mix RK-7100 can be used to bond numerous materials such as plastics, metals and ceramics to themselves and among. It is particularly convenient for structural bondings if high-strength connections are required. The adhesive is very viscous and is therefore suitable also for applications on vertical surfaces.

WEICON Easy-Mix RK-7100 can be used universally and, for example, in plastics technology, metal construction, car body and vehicle construction, machine construction, electrical engineering, model and mould making and in trade show and exhibition construction.

Technical Data

Base	Methyl methacrylate
Colour after curing	cream white, milky
Mixing ratio resin/hardener	1:1
Density of the mixture	0,98 - 1,02 g/cm ³
Viscosity of the mixture	40.000 - 60.000 mPa·s
Application procedure	Easy-Mix
Composition	viscous
Pot-life at +20°C (+68°F)	5 min.
Handling strength (35% strength) after	25 min.
Capable of bearing mechanical loads (50% strength) after	60 min.
Processing temperature	+10 to +40 °C
Curing temperature	+18 °C

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.

Final strength (100%) after	12 h
Adhesive gap bridging	0,1 - 5,0 mm
Shear strength according to DIN 53281 at:	
Aluminium	20 N/mm ²
Steel sand blasted	23 N/mm ²
Stainless Steel	22 N/mm ²
PC	12 N/mm ²
PMMA	9 N/mm ²
ABS	7 N/mm ²
Hard-PVC	12 N/mm ²
GRP	21 N/mm ²
CRP	22 N/mm ²
Polyamide 6.6	1 N/mm ²
Temperature resistance	-55 to +125 °C

Surface pre-treatment

The prerequisite for perfect adhesion are clean and dry surfaces (e.g. cleaning and degreasing with WEICON Surface Cleaner). The highest strength values can be achieved through additional pre-treatment of the surfaces, such as roughening using blasting or abrasive agents. Several plastics, in particular polyamide, Teflon®, polyolefin etc. can only be bonded after special surface treatment, for example using fluoridation, low-pressure plasma, corona, flame impingement etc.

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

The shelf life is 12 months when stored unopened at a normal climate (+23°C and 50 % rel. humidity).

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.

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Technical Datasheet

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Available sizes:

10566050 Easy-Mix RK-7100 Structural Acrylic
Adhesive 50 ml

Accessories:

10650005 Mixing Nozzles Easy-Mix, Quadro
10653050 Dispenser D 50,
11202400 Sealant and Adhesive Remover, 400 ml
11207400 Surface Cleaner, 400 ml
11850200 Hand Protective Foam, 200 ml
12955175 Dosing Tips, Typ A Size 0,5

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