

Minute Adhesive yellow



Casting compound | fast-curing | impact-resistant

WEICON Minute Adhesive yellow is an impact-resistant casting compound, which cures fast and is impact-resistant. The casting resin is self-levelling, shock-resistant, shows high adhesive strength, and is solvent-free. The casting compound adheres very well to circuit boards and electronic components.

It is used in electronics to protect electronic components, semiconductors and assemblies. It protects the components from moisture, dust and dirt as well as from mechanical stress.

Minute Adhesive yellow is suitable for applications in various areas, such as for grouting work in electrical engineering and the electronics industry and for casting cable connections. Due to its distinct yellow colour, Minute Adhesive yellow facilitates visual inspection.

The epoxy resin system has a short pot life of 4-5 minutes and can also be used as an adhesive due to its strong adhesion and fast cure time. The compound adheres very well to a wide variety of surfaces, such as metal, plastics, fibreglass-reinforced plastics, glass, and ceramics.

Characteristics

Base	Epoxy resin, non-filled
Texture	viscous
Colour	yellow

Processing

Processing temperature	+10°C to +30°C
Curing temperature	+6 °C - +40 °C
Mixing ratio by weight	1:1
Viscosity of the mixture	at +20 °C 8.500 mPa·s
Density of the mixture	1,2 g/cm ³
Gap bridging up to max.	2 mm

Note: Alle in diesem Technischen Datenblatt enthaltenen Angaben und Empfehlungen stellen keine zugesicherten Eigenschaften dar. Sie beruhen auf unseren Forschungsergebnissen und Erfahrungen. Sie sind jedoch unverbindlich, da wir für die Einhaltung der Verarbeitungsbedingungen nicht verantwortlich sein können, da uns die speziellen Anwendungsverhältnisse beim Verwenden nicht bekannt sind. Eine Gewährleistung kann nur für die stets gleichbleibende hohe Qualität unserer Erzeugnisse übernommen werden. Wir empfehlen, durch ausreichende Eigenversuche festzustellen, ob von dem angegebenen Produkt die von Ihnen gewünschten Eigenschaften erbracht werden. Ein Anspruch daraus ist ausgeschlossen. Für falschen oder zweckfremden Einsatz trägt der Verarbeiter die alleinige Verantwortung.

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Curing

Pot life	at 20 °C, 10 ml batch	4-5 min.
Handling strength	(35 % strength)	30 min.
Working strength after	(50 % strength)	1 h
Final strength	(100 % strength)	24 h
Shrinkage		2,0 %

Mechanical properties after curing

Tensile strength	DIN EN ISO 527-2	40 MPa
E-modulus (tensile)	DIN EN ISO 527-2	2.000 - 2.500 MPa
Compressive strength	DIN EN ISO 604	9 MPa
Bending strength	DIN EN ISO 178	58 MPa
Hardness (Shore D)	DIN ISO 7619	65
Lap shear strength material thicken. 1,5mm DIN EN 1465		
Steel 1.0338 sandblasted		20 N/mm ²
Aluminium sandblasted		19 N/mm ²
PVC-rigid roughened		13 N/mm ²

Thermal parameters

Temperature resistance	-50°C to +80°C
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Electrical parameters

Dielectric strength	DIN EN 60243-1 (20°C)	20 kV/mm
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Approvals / Guidelines

IMPA Code	812980
ISSA Code	75.629.50

Instructions for use

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.

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 Easy-Mix products can be processed straight from the double cartridge by means of the included static mixer. Dismiss the first 5 cm of the adhesive bead. The adhesive is applied to just one side. The specified pot life refers to a material batch of 10 ml at room temperature. Larger batch quantities will result in faster curing. Higher temperatures also reduce the pot life and curing time. (General rule: every increase by +10 °C above room temperature results in a decrease of the pot life and curing time by

half). Temperatures below +16 °C increase the pot life and curing time significantly. From approx. +5°C and below, no reaction takes place.

Shelf life

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 six months.

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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, 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 combinations of base resins (bisphenol A and F).

Accessories

10650001 Quadro Mixing Nozzle
10650002 Helix Mixing Nozzle, 1 PCE

Conversion table

$(^{\circ}\text{C} \times 1,8) + 32 = ^{\circ}\text{F}$	$\text{Nm} \times 8,851 = \text{lb}\cdot\text{in}$
$\text{mm}/25,4 = \text{inch}$	$\text{Nm} \times 0,738 = \text{lb}\cdot\text{ft}$
$\mu\text{m}/25,4 = \text{mil}$	$\text{Nm} \times 141,62 = \text{oz}\cdot\text{in}$
$\text{N} \times 0,225 = \text{lb}$	$\text{mPa}\cdot\text{s} = \text{cP}$
$\text{N}/\text{mm}^2 \times 145 = \text{psi}$	$\text{N}/\text{cm} \times 0,571 = \text{lb}/\text{in}$
$\text{MPa} \times 145 = \text{psi}$	$\text{kV}/\text{mm} \times 25,4 = \text{V}/\text{mil}$

Available sizes

10553024 Minute Adhesive yellow, 24 ml, yellow