

Technical Datasheet

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Plastic-Bond



excellent adhesion on plastics
high strength
shock and impact resistant

WEICON Plastic-Bond is a solvent-free structural adhesive with very good adhesion to plastics, aluminum, steel and much more. The adhesive is suitable for static as well as dynamic loads, has a high impact and peel strength and a maximum gap filling capacity of 5 mm.

Plastic-Bond is particularly suitable for structural bondings where high strength connections are required. It has a high viscosity and is suitable for processing on vertical surfaces.

The structural adhesive is universally applicable and can be used, for example, in plastics technology, in metal construction, in car body and vehicle construction, in mechanical engineering, in electrical engineering, in wood processing or in construction works at exhibitions.

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	A-B-method
Texture	thixotropic
Pot life at +20°C (+68°F)	15 min.
Handling strength (35% strength) after	40 min.
Capable of bearing mechanical loads (50% strength) after	60 min.
Processing temperature	+10 to +40 °C
Curing temperature	+18 °C
Final strength (100%) after	12 h
Adhesive gap bridging	0,1 - 5,0 mm
Shear strength according to DIN EN 1465 at:	

Aluminium	20 N/mm ²
Steel sand blasted	23 N/mm ²
Stainless Steel	22 N/mm ²
PC	11 N/mm ²
PMMA	9 N/mm ²
ABS	7 N/mm ²
Hard-PVC	12 N/mm ²
GRP	21 N/mm ²
CFK	22 N/mm ²
Polyamide 6.6	1 N/mm ²
Temperature resistance	-55 to +125 °C
IMPA-Code	812993

Surface pre-treatment

The prerequisite for perfect adhesion are clean and dry surfaces (e.g. cleaning and degreasing with WEICON Surface Cleaner). The best results are achieved when the surfaces to be bonded are mechanically roughened. The adhesive is applied only on one side.

Processing

Plastic-Bond 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

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.

Available sizes:

10565024 Plastic-Bond 24 ml

Accessories:

10650005 Mixing Nozzles Easy-Mix,