

Easy-Mix RK-7200



transparent
high strength
impact resistant, residual elasticity

WEICON Easy-Mix RK-7200 is a high strength, solvent-free and fast-curing structural adhesive. It is based on MMA (methyl methacrylate) and has an excellent adhesion on many materials.

Because of the transparent curing, RK-7200 is particularly suitable for transparent joints where the bonding seam should not be visible. This adhesive can also be used for structural bondings where a coloured adhesive would not fit optically to the construction parts.

Thus, transparent plastics like e. g. acrylic glass (PMMA) and other materials can be bonded in a clean and appealing way.

Technical data

Basis	Methyl methacrylate
Mixing ratio Resin / Hardener	1:1
Colour after curing	transparent, colourless
Density of the mixture	1,2 g/cm ³
Pot life at +20 °C	approx. 2 - 3 min.
Viscosity of the mixture	5.000 - 8.000 mPa.s
Handling strength (35%) after	approx. 10 min.
Mechanical loads (50% strength) after	approx. 120 min.
Final strength (100%) after	approx. 6 hours
Adhesive gap bridging	0,1 - 2,0 mm
Average strength (+20 °C) acc. to DIN 1465	
on GRP	7,0 / 9,0 (GRP-UP / GRP-EP) N/mm ²
on PVC	PVC 4 N/mm ²
on Aluminium	18 N/mm ²
on Steel bright	20 N/mm ²
on Stainless steel	18 N/mm ²
on PMMA	12 N/mm ²
Average E-module (+20 °C)	400 - 700 N/mm ²
Shore hardness D DIN EN ISO 868	45 - 55 D
Tensile strength ISO 527 max.	8,5 N/mm ²
Tensile Extension ISO 527 max.	23 %
Temperature resistance	-40 up to +110 °C
Thermoforming resistance	+ 49 °C
TGA decomposition temperature (Onset temp.)	+135 °C
Accessory	Mixing Nozzle 16.L, art.-no. 10650005
Accessory	Easy-Mix Hand Dispenser, art.-no. 10653050

Pretreatment of the surface

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. are only to 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

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) must be observed.

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