

## 易混合型 RK-7000



## 固化较慢，高强度，耐冲击，具剩余弹性

WEICON RK 7000 可粘接各种材质，如塑料、金属及陶瓷等；同材及异材均可粘接，且能够达到极高的抗拉、剪切及剥离强度。

该产品尤其适合搞强度的结构性粘接。它呈半流体质地，因而亦可用于垂直平面的粘接。

结构胶 RK 7000 的应用范围广泛，如塑料技术、金属制造、车辆工程、机械制造、电气工程、木材加工和交易会与展台搭建等。

## 技术参数

基础成分	甲基丙烯酸甲酯
固化后的颜色	乳白色
混合比例（树脂/固化剂）	1:1
混合物密度	0,98 - 1,02 g/cm <sup>3</sup>
混合物粘度	40.000 - 60.000 mPa·s
操作步骤	易混合
质地	半流体状
温度为+20°C时的可操作时间	15 分钟
达到初始强度（35%强度）所需时间	40 分钟
达到机械强度（50%强度）所需时间	60 分钟
操作温度	+10 至 +40 °C °C
固化所需最低温度	+18 °C
达到最终强度（100%强度）所需时间	12 h
最大抗拉强度 依据 ISO 527	24 N/mm <sup>2</sup>
抗拉弹性模量（DIN EN ISO 527）	1200 - 1500 Mpa
断裂延伸率（DIN EN ISO 527）	28 %
最大粘接缝隙	0,1 - 5,0 mm
依据 DIN EN 1465，拉伸剪切强度为：	
铝	20 N/mm <sup>2</sup>
钢质表面 喷砂处理	23 N/mm <sup>2</sup>
不锈钢	22 N/mm <sup>2</sup>

## 提示

本资料中列出的所有产品，其参数和建议是在实验室的测试结果及经验总结，不得被视为对产品特性的保证。由于每一个用的实际应用情况并不在我们的认知、控制及责任范围内，我们对这些信息并不承担任何义务。我们保证我们的产品符合并遵守我们销售条款中承诺的高品质、无瑕疵的要求。我们建议用户通过自行试验来论证其希望选用的产品是否完全符合预期。因用户未遵照指定的操作方法使用产品而造成损失的情况，用户将独自承担全部责任。

PC (聚碳酸酯)	11 N/mm <sup>2</sup>
在室温下固化后的玻璃转换温度	-39,8 °C
PMMA	9 N/mm <sup>2</sup>
ABS	7 N/mm <sup>2</sup>
硬质PVC	12 N/mm <sup>2</sup>
玻璃纤维增强塑料	21 N/mm <sup>2</sup>
CFK	22 N/mm <sup>2</sup>
聚酰胺6.6	1 N/mm <sup>2</sup>
耐温性	-55 至 +125 °C
热扩散率 (23 °C)	0,118 mm <sup>2</sup> /s
热传导率	0,20 W/m·K
比热容	1,453 J/(g·K)
电阻率	1,83 · 10 <sup>11</sup> Ωm
ISSA 编码	75.629.55
IMPA 编码	812994

## 表面处理

为确保粘接效果，待粘接的物体表面需干燥、清洁（可使用 WEICON 表面清洁剂进行清洁与去脂）。若需达到更高的粘接强度，可事先用喷砂或研磨工具对物体表面进行粗糙处理。部分塑料，尤其是聚酰胺、聚四氟乙烯、聚烯烃等，必须经过如氟化反应、低压等离子、电晕火焰冲刷等表面特殊处理后方可粘接。

## 操作

直接将塑料粘合剂挤出胶嘴即可使用。最初挤出的数厘米胶水平应弃置。将挤出的胶水均匀搅拌，快速涂抹在待粘接的物体表面，随后即刻进行粘接。

## 储藏

未拆封室温（+23°C，50%相对空气湿度）环境可储存12个月。

## 安全与健康

使用 WEICON 产品时，需注意产品的物理性、安全性、毒性、生态性的详细参数以及我们 E-G 材料安全数据表（www.weicon.com）的具体信息。

## 包装

10565050 易混合型 RK-7000 50 g

## 产品配件

10650005 易混合型胶嘴，  
10653050 易混合型胶枪 D 50, D50  
12955175 精密胶嘴，

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# Easy-Mix RK-7000 Structural Acrylic Adhesive



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

RK-7000 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 RK-7000 can be used universally and, for example, in plastics technology, metal construction, car body and vehicle construction, machine construction, electrical engineering, wood processing 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 <sup>3</sup>
Viscosity of the mixture	40.000 - 60.000 mPa·s
Application procedure	Easy-Mix
Texture	viscous
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
Tensile strength ISO 527 max.	24 N/mm <sup>2</sup>
Strength-E-Module (DIN EN ISO 527)	1200 - 1500 Mpa
Elongation at break (DIN EN ISO 527)	28 %
Adhesive gap bridging	0,1 - 5,0 mm
Shear strength according to DIN EN 1465 at:	

Aluminium	20 N/mm <sup>2</sup>
Steel sand blasted	23 N/mm <sup>2</sup>
Stainless Steel	22 N/mm <sup>2</sup>
PC	11 N/mm <sup>2</sup>
Tg after curing at room temperature	-39,8 °C
PMMA	9 N/mm <sup>2</sup>
ABS	7 N/mm <sup>2</sup>
Hard-PVC	12 N/mm <sup>2</sup>
GRP	21 N/mm <sup>2</sup>
CFK	22 N/mm <sup>2</sup>
Polyamide 6.6	1 N/mm <sup>2</sup>
Temperature resistance	-55 to +125 °C
Thermal diffusivity (23 °C)	0,118 mm <sup>2</sup> /s
Thermal conductivity	0,20 W/m·K
Specific heat capacity	1,453 J/(g·K)
Resistivity	1,83 · 10 <sup>11</sup> Ωm
ISSA-Code	75.629.55
IMPA-Code	812994

## Surface pre-treatment

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

## 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](http://www.weicon.com)) must be observed.

## 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.

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## Technical Datasheet

Create Date:17.08.2020 - Seite2/2

### Available sizes:

10565050 Easy-Mix RK-7000 Structural Acrylic Adhesive 50 g

### Accessories:

10650005 Mixing Nozzles Easy-Mix,  
10653050 Dispenser D 50, 50 ml  
12955175 Dosing Tips,

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