

# Aluminium Minute Adhesive



**Aluminium-filled | gap-filling | fastcuring | high peel and impact strength**

WEICON Aluminium Minute Adhesive is an odourless, two-component epoxy adhesive filled with aluminium. It cures fast at room temperature and practically without shrinkage. After curing, the adhesive can be machined (filing, drilling, milling). Aluminium Minute Adhesive is gap-filling and non-dripping (thixotropic) and shows very high tensile, impact and peel strength. The adhesive is particularly suitable for bonding aluminium and other light metals. It can be used for filling cracks and holes on aluminium housings, for example, and for repairing light alloy wheels. In order to achieve optimal adhesion, the bonding surfaces should be dry and free from grease or dirt. Scraping or sanding the surfaces before cleaning additionally improves adhesion.

## Characteristics

|         |                            |
|---------|----------------------------|
| Base    | Epoxy resin, highly filled |
| Texture | pasty, gap-filling         |
| Colour  | aluminium                  |

## 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 | 125.000 mPa·s          |
| Density of the mixture             | 1,23 g/cm <sup>3</sup> |
| Gap bridging up to max.            | 4 mm                   |

## Curing

|  |          |
|--|----------|
| Pot life at 20 °C, 10 ml batch         | 4-5 min. |
| Handling strength (35 % strength)      | 25 min.  |
| Working strength after (50 % strength) | 2 h      |
| Final strength (100 % strength)        | 24 h     |
| Shrinkage                              | 0,3 %    |

## Mechanical properties after curing

|                      |                  |                   |
|----------------------|------------------|-------------------|
| Tensile strength     | DIN EN ISO 527-2 | 34 MPa            |
| E-modulus (tensile)  | DIN EN ISO 527-2 | 4.000 - 4.500 MPa |
| Compressive strength | DIN EN ISO 604   | 8 MPa             |
| Bending strength     | DIN EN ISO 178   | 58 MPa            |
| Hardness (Shore D)   | DIN ISO 7619     | 45                |

Lap shear strength material thickn. 1,5mm DIN EN 1465

|                          |                      |
|--------------------------|----------------------|
| Steel 1.0338 sandblasted | 20 N/mm <sup>2</sup> |
| Aluminium sandblasted    | 19 N/mm <sup>2</sup> |
| PVC-rigid roughened      | 11 N/mm <sup>2</sup> |

## Thermal parameters

|                        |   |
|------------------------|---|
| Temperature resistance | -50°C to +120 °C, briefly up to +150 °C |
|------------------------|---|

## Electrical parameters

|                     |                       |          |
|---------------------|-----------------------|----------|
| Dielectric strength | DIN EN 60243-1 (20°C) | 16 kV/mm |
|---------------------|-----------------------|----------|

## Instructions for use

When using WEICON products, the physical, safety-related, toxicological and ecological data and regulations in our EC safety data sheets ([www.weicon.com](http://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 Aluminium Minute Adhesive can be processed straight from the double cartridge. Dismiss the first centimetre of the adhesive bead. Mix product thoroughly. Apply adhesive to the bonding surface quickly. Then join both bonding surfaces immediately.

## Storage

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. 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).

## Scope of delivery

Adhesive

**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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## Accessories

- 10005237 Dispenser Easy-Mix D 50, 1 PCE
- 10005236 Quadro Mixing Nozzle A, 1 PCE
- 10068261 Dosing Tip, 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

- 10051229 Aluminium Minute Adhesive, 24 ml, aluminium
- 10058776 Aluminium Minute Adhesive, 1 Set, aluminium

To the product detail page:



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