

**Description:**

epple 4851 is an one-component contact adhesive on the basis of chloroprene which cures to a highly elastic adhesive film.

Field of application:

epple 4851 is used a contact adhesive, so that both assembly parts need to be coated with the adhesive (approx. 150 – 300 g/m²). The components can be jointed by compression after evaporation of the solvents (dust-free surfaces). Thanks to its wide adhesion spectrum, epple 4851 is mainly used for the bonding of different plastics among each other or with metals, as well as for the bonding of rubber parts.

Application / surface:

- The surfaces of the assembly components have to be clean and free from dust and grease.
- Apply evenly to the adhesive faces on one or both sides. With very absorbing surfaces, eventually apply the adhesive twice and allow to evaporate.
- The assembly components need to be fixed appropriately until tangibility is reached.

Cleaning of tools:

Thinner epple 11.

Chemical Basis

1 comp.	2 comp.	solvent-containing	solvent-free	aqueous	EP	PU	Acrylate	Chloroprene	Polyvinylacetate	Terpolymer
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Properties of the liquid adhesive

Property	Standard	Value
Viscosity	DIN EN ISO 3219	9,0 Pas – 12,0 Pas
Density	DIN 53479	0,88 g/cm ³ - 0,92 g/cm ³
Colour		yellowish
Solid content		27 % - 33 %
Pot life	DIN VDE 0291-2	-
Storage	12 months in closed original containers, stored in a dry and cool but frost-free place (ideal storage temperature: 5 - 30 °C). Stir-up before use.	

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Properties of the adhesive		
Property	Standard	Value
Curing ventilation time time to tangibility time to final strength	-	10 min touch-dry max. 2h 10 min. 24 h
Curing conditions / contact pressure	-	approx. 2 bar
Hardness Shore-A Shore-D pendulum hardness / König	DIN 53505 DIN 53505 DIN 53157	- - -
Adhesive strength in the shear tension test steel / steel (blasted SA2,5) wood / wood	DIN EN 1465	0,7 N/mm ² 2,6 N/mm ² -
Adhesive strength in the peel test 180 ° rubber / wood	DIN EN 1464	5,0 N/cm
Surface cleavability	-	none
Glass transition temperature	DIN IEC 61006	-
Storage / change of adhesive strength 120 °C / 7 days / [steel / steel (blasted SA2,5)] 120 °C / 35 days / air [steel / steel (blasted SA2,5)] 120 °C / 7 days [wood / wood] 120 °C / 35 days [wood / wood]	DIN EN 1465	0,7 N/mm ² 1,3 N/mm ² 2,8 N/mm ² 2,7 N/mm ²
Temperature resistance	-	- 30 °C to + 80 °C
Thermal conductivity	ISO 8894-1	-
Absorption of water 20 °C / 7 days 20 °C / 30 days 100 °C / 30 minutes	ISO 62	- - -
Chemical resistance	epple-standard	water, climatic influences
Insulating resistance film thickness 2 mm	DIN IEC 60167	
Volume resistance film thickness 2 mm	DIN IEC 60093	

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