

**Description:**

epple 5851 is a two-component contact adhesive on the basis of chloroprene, which cures to a highly elastic adhesive film.

Field of application:

epple 5851 is used as contact adhesive, so that both assembly parts need to be coated with the adhesive (approx. 150 – 300 g/m²) after mixing the two components. The assembly parts can be jointed by compression after an airing time of a few minutes (dust-free surfaces). Thanks to its wide bonding spectrum, **epple 5851** is mainly used for the bonding of plastics among each other or with metals, as well as for the bonding of rubber parts. **epple 5851** provides an elevated thermal resistance compared with our one-component version **epple 4851**.

Application / surface:

- The surfaces of the assembly components have to be clean and free from dust and grease.
- Decant component B into the tin of component A. Mix the two components thoroughly and homogeneously. Eventually fill over the mixture into another, clean container and stir the material again.
- 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	EP	PU	Acrylate	Chloroprene	Polyvinyl-acetate	Terpolymer
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Properties of the liquid adhesive

Property	Value	Component A	Component B
Viscosity	DIN EN ISO 3219	9,0 Pas – 12 Pas	0,01 Pas – 0,1 Pas
Viscosity of mixture	DIN EN ISO 3219	4,0 Pas – 7,0 Pas	
Density	DIN 53479	0,88 g/cm ³ - 0,92 g/cm ³	0,98 g/cm ³ - 1,02 g/cm ³
Mixing rate	gravimetric volumetric	90 parts by weight 91 parts by volume	10 parts by weight 9 parts by volume
Colour of mixture		light brown	
Solid content		27 % – 33 %	
Pot life	DIN VDE 0291-2	7 h	
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 (tangible), max. 2 h 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	1,2 N/mm ² 5,6 N/mm ² - -
Adhesive strength in the peel test 180 °	DIN EN 1464	6,6 N/cm
Surface cleavability	-	none
Glass transition temperature	DIN IEC 61006	-
Storage / change of adhesive strength	DIN EN 1465	-
Temperature resistance	-	- 30 °C to + 150 °C
Thermal conductivity	ISO 8894-1	-
Absorption of water 20 °C / 7 days 20 °C / 30 days 100 °C / 30 min	ISO 62	- - -
Chemical resistance	epple-standard	water, atmospheric conditions
Insulating resistance film thickness 2 mm	DIN IEC 60167	-
Volume resistance film thickness 2 mm	DIN IEC 60093	-