

**Description:**

epple K 20 R is a fast-curing adhesive on the basis of a thermoplastic caoutchouc.

**Field of application:**

epple K 20 R offers a wide range of application possibilities. It can be applied as pressure-sensitive adhesive or as laminating adhesive with high adhesive strength. Being applied as contact adhesive, epple K 20 R bonds the most different materials, e. g. paper, textiles, leather, rubber, wood and PU-foam. It is particularly suitable for the adhesion of profiles and mould articles out of solid rubber and expanded rubber, as well as for the bonding of elastomers to metal surfaces.

**Application / surface:**

- ⇒ The surfaces of the assembly components have to be clean and free from dust and grease.
- ⇒ Apply to the adhesive faces on one or both sides. With very absorbing surfaces, eventually apply the adhesive twice.
- ⇒ The assembly components can be connected after an evaporation time of approx. 2 minutes

**Cleaning of tools:**

Thinner epple 11 or epple 456.

Chemical Basis										
1 comp.	2 comp.	solvent-containing	solvent-free	aqueous	EP	PU	Acrylate	Chloroprene	Polyvinylacetate	Caoutchouc

Properties of the liquid adhesive		
Property	Standard	Value
Viscosity	DIN EN ISO 3219	12,0 Pas
Density	DIN 53479	0,94 g/cm <sup>3</sup>
Colour		black
Solid content		40 %
Storage	12 months in closed original containers, stored in a dry and cool but frost-free place (ideal storage temperature: 5 - 30 °C).	

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Properties of the adhesive		
Property	Standard	Value
Curing ventilation time time to tangibility time to final strength	-	2 min 20 min 24 h
Curing conditions / contact pressure	-	-
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) steel / steel (bare) aluminium / aluminium brass / brass stainless steel / stainless steel	DIN EN 1465	- - - - -
Adhesive strength in the peel test 180 °	DIN EN 1464	-
Surface cleavability	-	-
Glass transition temperature	DIN IEC 61006	-
Storage / change of adhesive strength 80°C / 7 days / air [steel / steel (blasted SA2,5)] 80°C / 4 hours / air [steel / steel (blasted SA2,5)]	DIN EN 1465	- -
Temperature resistance	-	- 40 °C to + 120 °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, tenside solutions, saline solutions, light acids, light leaches.
Insulating resistance film thickness 2 mm	DIN IEC 60167	-
Volume resistance film thickness 2 mm	DIN IEC 60093	-

08/07

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