Technical Data Sheet
Adhesive epple K25 R

Issue: 04-2021

Description:

epple K25 R is a fast-curing adhesive on the basis of a thermoplastic caoutchouc.

Application:

epple K25 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 K25 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 surface has 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
- If possible, stir-up the adhesive before use.

Cleaning of tools:

Thinner 11 or thinner 456

Packaging:

Tin, pail

Basis / Characteristics

Components		Solvent-			Chemical Basis					
1-comp.	2-comp.	free	**containing**	aqueous	EP	PU	Acrylate	Chloro-prene	Polyvinyl-acetate	**Caout-chouc**

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Properties of the liquid adhesive		
Property	**Value**	**Following to standard**
Viscosity	5 – 10 Pas	DIN EN ISO 3219
Density	0.9 – 1.0 g/cm^3 / 20 °C	DIN 53479
Colour	black	-
Loss on drying up to 140 °C	58 – 62 %	-
Storage	24 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 cured adhesive

Property	Value	Following to standard
Curing Ventilation time Time to handling strength Time to final strength	 2 min 20 min 24 h	-
Curing conditions / Contact pressure	-	-
Hardness (after 7 days at 20 °C) Shore-A Shore-D Pendulum hardness / König	 - - -	 DIN 53505 DIN 53505 DIN 53157
Adhesive strength in the tensile shear test (after 7 days at 20 °C) Steel / steel (blasted SA 2,5)	 -	 DIN EN 1465
Surface adhesion	-	-
Temperature resistance (after 7 days at 20 °C)	 -25 °C to +120 °C	-
Absorption of water 20 °C / 7 days	 -	 ISO 62
Chemical resistance (after 7 days; max. 3 months)	Water tenside solutions saline solutions diluted acids (5%) diluted alkalines (5%)	epple-standard