Technical Data Sheet
Adhesive epple-bond 8211

Issue: 03-2020

Description:

epple-bond 8211 is a solvent-free, one-component adhesive on the basis of cyanoacrylate. It cures within a few seconds to a tough adhesive joint. **epple-bond 8211** is of low viscosity.

Application:

epple-bond 8211 is suitable for the bonding of metals, plastics, rubber and other elastomers. It is of good aging resistance and provides high adhesive strength on the various assembly components.

Curing takes place in contact with air humidity, so that tangibility is reached sooner with high atmospheric humidity.

Application / Surface:

- The surface has to be clean and free from dust and grease.
- **epple-bond 8211** is to be applied as thin as possible to one adhesive face and the components have to be connected immediately. Spot-bonding has proven to be the best method here.
- The gap length may not exceed 0.2 mm.
- If possible, stir-up the adhesive before use.

Cleaning of tools:

Thinner 11

Packaging:

Plastic bottle

Basis / Characteristics

Components		Solvent-			Chemical Basis					
1-comp.	2-comp.	**free**	containing	aqueous	EP	PU	**Cyan-acrylate**	Chloro-prene	Polyvinyl-acetate	Terpoly-mer

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Properties of the liquid adhesive		
Property	**Value**	**Following to standard**
Viscosity	9 - 15 mPas	DIN EN ISO 3219
Density	1.00 – 1.15 g/cm^3 / 20 °C	DIN 53479
Colour	uncoloured, clear	-
Loss on drying up to 140 °C	0 %	-
Storage	12 months in closed original containers, stored in a dry and cool but frost-free place. Ideal storage temperature: 5 - 15 °C.	

Diese Druckschrift soll Sie beraten. Die darin gemachten Angaben entsprechen unserem besten Wissen, jedoch kann eine Verbindlichkeit daraus nicht hergeleitet werden.

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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	 none 40 s (steel / steel) 60 min	-
Curing conditions / Contact pressure	no pressure necessary, fixation	-
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 (bare)	 15 - 20 N/mm^2	 DIN EN 1465
Surface adhesion	none	-
Temperature resistance (after 7 days at 20 °C)	 -55 °C to +95 °C	-
Absorption of water 20 °C / 7 days	 -	 ISO 62
Chemical resistance (after 7 days; max. 3 months)	mineral oils rapeseed methyl ester (RME, Biodiesel)	epple-standard

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