Technical Data Sheet
Adhesive epple-easy 5621-new

Issue: 10-2021

Description:

epple-easy 5621-new is a two-component, solvent-free adhesive on the basis of epoxy. It is characterised by a short time to tangibility, as well as by an improved adhesive strength on plastics.

Application:

epple-easy 5621-new is particularly suitable for the bonding of metal with plastics. Thanks to its short pot life, fixing of the adherends for a longer period of time is not necessary.

Specific properties:

The product is being applied by means of a dual cartridge, so that manual mixing is not necessary.

Type of mixer:

mini (50 ml): MB 5.4-16-S

Cartridge gun:

Gun mini DMA 50 with tappet PLA 050-01

Application / Surface:

- The surface has to be clean and free from dust and grease.
- The assembly components need to be fixed appropriately until tangibility is reached.
- For further information regarding the use of the dual cartridges please see our application instructions for epple-easy on our website www.epple-chemie.de und “equipment and accessories”.

Cleaning of tools:

Thinner 11

Packaging:

Cartridge, pail

Basis / Characteristics

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

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Properties of the liquid adhesive			
Property	**Component A**	**Component B**	**Following to standard**
Viscosity	35 – 60 Pas	60 – 75 Pas	DIN EN ISO 3219
Viscosity of mixture	45 – 65 Pas		DIN EN ISO 3219
Density	1.1 – 1.2 g/cm³ / 20 °C	1.1 – 1.2 g/cm³ / 20 °C	DIN 53479
Mixing rate	50 parts by weight 50 parts by volume	50 parts by weight 50 parts by volume	gravimetric volumetric
Colour of mixture	transparent yellowish		-
Loss on drying up to 140 °C	-		
Pot life	6 – 11 min		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.		

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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	 - 1 hour 3 days	-
Curing conditions / **Contact pressure**	Fix it until handling is possible.	-
Hardness (after 7 days at 20 °C) Shore-A Shore-D Pendulum hardness / König	 82 – 92 67 – 77 26 – 46 s	 DIN 53505 DIN 53505 DIN 53157
Tensile lap-shear strength (after 7 days at ambient) Steel / steel (blasted SA 2,5)	 >10 N/mm²	 DIN EN 1465
Tack	none	-
Temperature resistance (after 7 days at 20 °C)	-20 °C to +80 °C	-
Absorption of water 20 °C / 7 days	-	ISO 62
Chemical resistance (after 7 days; max. 3 months)	ATF-oil, engine oil short term resistant against: water, detergent, solvents and fuels	epple-standard

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