

TECHNICAL INFORMATION

Date of
preparation: 28
March 2025



Date of update:
28 March
2025.

Website1
from 3

Product name: two-component epoxy adhesive APP EP4. APP No.: 040514.

Two-component, fast-setting, universal epoxy adhesive that cures in 5-7 minutes at ambient temperature.

Packaging. 2 x 12.5 ml – two combined plastic syringes.

Product and additives.

- Component A APP EP4,
- Component B APP EP4.

Basic components. Epoxy and polyamide resin and additives.

Colour. Colourless transparent.

Consistency. Viscous liquid with a characteristic odour.

Density (20 °° °C).

- Component A: $1.10 \pm 0.10 \text{ g/cm}^3$,
- Component B: $1.10 \pm 0.10 \text{ g/cm}^3$,
- Mixture: 1.04 g/cm^3 .

Bond strength. 10-11 MPa.

Shear strength
(25 °° °C).

- after 2 hours - 4.5 N/mm^2
- after 24 hours - 5.5 N/mm^2
- after 72 hours - 5.5 N/mm^2

Working temperature. from -50 °° °C to +100 °° °C

Chemical resistance
after curing. Acids: good Alkalis: good Oils:
good to water: good

Application

- Designed for bonding many metallic and non-metallic materials and composites.
- Permanently bonds plastics, ceramics, porcelain, glass, jewellery components, wood, and building products.
- Excellent for filling parts exposed to variable thermal cycles and vibrations.
- For industrial production, assembly, repairs, e.g. of household appliances, etc.

The above information is based on our current knowledge of our products and their possible applications. It does not guarantee specific properties or suitability for use in specific conditions. Please observe the notes and warnings on the product labels and in the safety data sheet. We accept no liability if the final result of the work is influenced by factors beyond our control.

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Properties

- Cures quickly with excellent adhesion at room temperature.
- Good resistance to acids, alkalis and other chemicals.
- Very good mechanical properties.
- Very good electrical insulation properties.
- Good resistance to shock, vibration and bending.

Substrate

Suitable substrates.

Designed for bonding many metallic and non-metallic materials. Permanently bonds plastics, ceramics, porcelain, glass, jewellery components, wood and building products.

Caution!

Do not use for bonding flexible and soft materials. Do not use for bonding PE, PP, PTFE.

Substrate preparation.



Before applying the adhesive, clean the surfaces to be bonded of any old adhesive residue and, for best results, sand with fine sandpaper or non-woven fabric and degrease with acetone (PVC, glass, aluminium).

- acetone (PVC, glass, aluminium),
- alcohol-based remover,
- APP BENZ, APP BR 01, APP W900 or APP WB910 remover.

Application

Using two syringes, squeeze out the same amount of components A and B and mix them together.

Apply a thin layer of the prepared mixture to both surfaces to be joined, remove excess adhesive, press the joined parts together for 4 to 6 minutes. For best results, use at a temperature not lower than 20–° °C.

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Website3
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Drying



The curing of APP EP4 adhesive begins immediately after mixing component A with component B.

At +23°C:

- joint curing: 5-7 minutes
- full strength: after 1 hour.

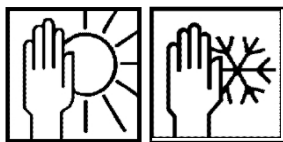
Caution!

Avoid contact with solvents, acids and oxidisers during curing.

Cleaning equipment:

Alcohol and acetone.

Storage:



Store in closed original packaging in a dry and well-ventilated room.

Storage temperature: +5°C to +25°C. Keep away from acids and oxidising agents.

Health and safety regulations:



For professional use only.

See: text on product labels or in the hazardous product data sheet.

The user must comply with the health and safety regulations in force in their country.

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