



H.B. Fuller Company
P.O. Box 64683
St. Paul, MN 55164-0683

EY4014
PRODUCT NUMBER

Page 1 of 3

TECHNICAL DATA SHEET

EY4014 A/B

(Previously, Cycleweld C-14A + C-14B)

GENERAL PURPOSE EPOXY ADHESIVE

DESCRIPTION

This product is a versatile, high strength, thermosetting adhesive for adhering a wide variety of fabricating materials, including Delrin®. It produces high shear strengths by catalytic curing, cures with or without heat at contact pressure, and has high shear strength at moderate heat. Typical temperature use range is -40°F to 200°F, but can withstand short term exposure to lower and higher temperatures when minimal forces are exerted on the adhesive.

TYPICAL PHYSICAL PROPERTIES and GENERAL INFORMATION

Property	Part A	Part B	Blend
BLENDING RATIO BY VOLUME	100	8.5	
BLENDING RATIO BY WEIGHT	100	7	
COLOR	YELLOW	COLORLESS	YELLOW
COLOR MODIFIER	CLEAR		LIGHT
DENSITY, ASTM D0792, WEIGHT PER U.S. GALLON (lb-mass/gal)	9.49 - 9.91	8	9.6
GEL TEMPERATURE, TMTS144, GEL TIME TEMPERATURE (F.) (deg. F)			76 - 78
GEL TIME, GEL TIME IN MINUTES (107 GRAMS MIN: 106 MAX: 108) (minute)			20 - 30
HARDNESS, SHORE D			74 - 76
ODOR	SULFUR	FISHY	
SOLID CONTENT (NON-VOLATILES) (percent)	99.9	100	
TENSILE STRENGTH, ASTM D1002, TENSILE LAP SHEAR STR. ALUM @ 77 F (lb-f/in ²)			3,000 - 4,000
VISCOSITY (TMTS001) (cP)	40,000	24	30,000

DIRECTIONS FOR USE

SURFACE PREPARATION: Surfaces must be clean, dry and free from grease, oil, paint, wax and weak oxide films and other surface contaminants. Chemical etching, sanding or grit blasting often give the best results.

PROPORTIONING AND MIXING: Just prior to using, blend the two components, Part A and Part B, in the ratio above in a wide shallow dish, stirring for 2-3 minutes, being certain to scrape in all material from the walls and bottom of the mixing container.



H.B. Fuller

H.B. Fuller Company
P.O. Box 64683
St. Paul, MN 55164-0683

EY4014

PRODUCT NUMBER

Page 2 of 3

APPLICATION: Using a clean applicator, spread the adhesive on one surface and immediately join the parts being bonded, using contact pressure, a jig or clamp at 3 PSI or less. A brush spreader or spatula can be used. The best results are obtained, when the thickness at the bondline is between 3 and 6 mils

COVERAGE: 20-25 Sq. inches per gram at 5 MIL thickness
10,000 Sq. inches per pound at 5 MIL thickness

***CURE SCHEDULE:**

5 hrs at 77 F Normal handling
18 hrs at 77 F 60% cure for finishing operations
7 days at 77 F Full cure
2 hrs at 120F Full cure
.5 hrs at 180F Full cure

STORAGE AND HANDLING

Use good personal hygiene. Avoid eye and skin contact. Wash contaminated clothing before reuse. Store material in a closed container in a cool, dry place. Storage in areas above 80F may reduce shelf life.

Since emptied containers retain product residue, follow label warnings even after container is emptied.

Consult Material Safety Data Sheet for further information.



H.B. Fuller

H.B. Fuller Company
P.O. Box 64683
St. Paul, MN 55164-0683

EY4014

PRODUCT NUMBER

Page 3 of 3

LIMITED WARRANTY AND TERMS

H.B. Fuller Company ("Fuller") warrants that, for a Warranty Period of one year (or the period specified on the applicable Technical Data Sheet, whichever is less) from the date of shipment from Fuller to the Initial Purchaser, that this Fuller product was manufactured in accordance with Fuller's specifications in effect on the date of manufacture. These specifications are available upon request. This Warranty does not cover test data, or any defects, damages or other harms caused to any extent or in any way by failure to follow applicable Fuller instructions, if any, or abuse or misuse of the product.

WARRANTIES DISCLAIMED -- THE WARRANTY STATED IN THE PARAGRAPH ABOVE IS IN PLACE OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED. Fuller EXPRESSLY DISCLAIMS ANY OTHER WARRANTIES, INCLUDING WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE. ALTHOUGH Fuller MAY HAVE SUGGESTED THE PRODUCT OR DEVELOPED THE PRODUCT AT THE PURCHASER'S REQUEST, IT IS THE PURCHASER'S RESPONSIBILITY TO TEST AND DETERMINE THE SUITABILITY OF THE PRODUCT FOR THE PURCHASER'S INTENDED USE AND PURPOSE, AND PURCHASER ASSUMES ALL RISK AND LIABILITY WHATSOEVER REGARDING SUCH SUITABILITY.

LIMITATIONS OF REMEDIES AND DAMAGES -- FOR ANY VALID CLAIM PRESENTED UNDER THE LIMITED WARRANTY, Fuller WILL REPLACE THE PRODUCT, OR AT ITS OPTION, REFUND THE PURCHASE PRICE. THIS REPLACEMENT/REFUND REMEDY IS THE PURCHASER'S SOLE AND EXCLUSIVE REMEDY AGAINST Fuller. THE PURCHASER AGREES THAT NO OTHER REMEDY (INCLUDING BUT NOT LIMITED TO LOST PROFITS, LOST SALES, INJURY TO PERSON OR PROPERTY OR ANY OTHER INCIDENTAL OR CONSEQUENTIAL LOSS) SHALL BE AVAILABLE TO PURCHASER FOR CLAIMS ARISING OUT OF ANY USE OF THE PRODUCT REGARDLESS OF THE LEGAL THEORY (CONTRACT, TORT OR OTHER). IN NO EVENT WILL Fuller BE OBLIGATED TO PAY DAMAGES TO PURCHASER IN ANY AMOUNT EXCEEDING THE PRICE THAT THE PURCHASER PAID FOR THE PRODUCT.

LIMITATION OF ACTIONS AND VENUE -- Any claim made or action commenced by Purchaser under Fuller's limited warranty as set forth herein must be brought within one year from the date of shipment from Fuller to the Purchaser. Purchaser agrees that all disputes arising from Fuller's sale of product to Purchaser shall be brought, if at all, in and before a court located in the State of Minnesota, to the exclusion of the courts of any other state.

CONDITIONAL ACCEPTANCE -- Fuller's acceptance of Purchaser's order for this product is expressly conditional on Purchaser's assent to terms and conditions set forth herein.

ADEQUATE TESTS: The information contained in this bulletin we believe is correct to the best of our knowledge and tests. The recommendations and suggestions herein are made without guarantee or representation as to results. We recommend that adequate tests be made in your laboratory or plant to determine if this product meets all of your requirements.