



# EV Bond 383



## Technical Data Sheet



### Epoxy

#### Adhesive System

EV Bond 383 is thixotropic, toughened, two-component, ambient-curing epoxy adhesive. High impact resistance, moderate cure-speeds and good peel resistance characteristics make this system suitable for assembly or sealing of reinforced composite structures, metal bonding or other applications where a toughened epoxy adhesive is required. This system contains dyes which fluoresce brightly with exposure to UV inspection lamps (black light.)

<b>Technology/Base:</b>	Epoxy
<b>Type of Product:</b>	Structural Adhesive
<b>Components:</b>	Two Component
<b>Curing:</b>	Room Temperature
<b>Appearance / Color:</b>	Orange/Amber
<b>Consistency:</b>	Thixotropic

<b>Tensile Strength at 25°C, average psi:</b>	4492
<b>Tensile elongation at 25°C (at break), average %:</b>	14.3
<b>Glass Transition Temperature, °C by TMA:</b>	53
<b>Coefficient of Thermal Expansion, ppm/°C, 30°C-40°C:</b>	111.8



### Features and Benefits



- Outstanding Bond Strength on AL, steel, as well as other composites
- Great elongation
- Wide open time
- High heat resistance



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### Typical Uncured Properties

Property	Part A 383	Part B 383	Mixed
Color	Amber	Orange	Green
Viscosity at 25°C, cps.	34,000	23,000	27,000
Weight per Gallon, lbs.	9.10	8.42	8.85
Specific Gravity at 25°C	1.177	1.01	1.09
Gel time, minutes 200g at 25°C			54
Tack-Free time, 40mil layer at 25°C			180
Shelf Life (in separate sealed containers), months	12	12	

### Mixing and Curing Schedule

Ratio	Part A	Part B
By Weight	100	86
By Volume	1	1

The recommended cure schedule to achieve the typical properties is 5 days at 25°C/77°F. Properties will be slightly altered if exposed to elevated temperature post-cure.

### Cured Physical Properties (5 day cure at 25°C)

Tensile Lap Shear at 25°C, 5 day cure at 25°C, 5mil bondline thickness, sandblasted cold rolled steel, psi	3203
Tensile Lap Shear at 25°C, 5 day cure at 25°C, 5mil bondline thickness, scoured aluminum, psi	2413
Tensile Lap Shear at 25°C, 5 day cure at 25°C, 5mil bondline thickness, solvent wiped aluminum, psi	2173



#### Handling and Clean-Up

A wide variety of cleaning solutions are available for cured and uncured epoxies and polyurethanes. For more information on proper recommendations and procedures, contact the Technical Department.



#### Typical Packaging

200 mL Cartridge  
5 gallon Pail  
55 gallon Drum



#### Storage and Shelf Life

These materials should be stored in a dry environment within a temperature range of 16 °C to 27 °C (60 °F to 80 °F). Extremes of temperature beyond this range may result in crystallization or polymerization of the materials. Introduction of a nitrogen blanket into the containers before closing will improve the storage life of the products.

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#### Safety and Disposal

These materials are intended for industrial use only, and the practices of good housekeeping, safety and cleanliness should be followed before, during and after use.

Although the system contains low volatility materials, care should be taken in handling. Use adequate ventilation in the work area. These materials may cause dermatitis in susceptible individuals. Keep off skin and out of eyes. In case of accidental skin contact, wash thoroughly with soap and water. In case of eye contact, flush eyes thoroughly with water and consult a physician immediately.

Refer to Material Safety Data Sheet for additional information.

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