



ISO-9001-2008 Certified

TECHNICAL BULLETIN

EB-350-3T

ONE COMPONENT, MACHINABLE, LOW EXPANSION ADHESIVE

EB-350-3T is a single-part heat cured toughened epoxy adhesive. The epoxy combines the structural strength of conventional epoxies with unparalleled peel, impact, and cleavage resistance.

It has excellent adhesion to most metal surfaces, with metal fatigue or failure resulting before the adhesive fails. The epoxy also has good adhesion to a variety of other surfaces, including most thermoset plastics and composite materials. The high bond strength of the epoxy allows it to be used in many applications in place of mechanical fastening, soldering, brazing, or welding.

EB-350-3T can be blended with glass spacer beads (according to specification) which allows for a uniform bond line and no squeeze out during clamping. This allows for even curing and consistent bond strength. The cured adhesive with glass beads will not change any cured or handling characteristics.

FEATURES & BENEFITS:

- Outstanding Adhesive Strength
- Excellent Resistance to Vibration and Impacts
- Good Performance at High Temperature
- Durable Bond in Harsh Environments
- Adhesion to a Wide Variety of Substrates
- Resistant to Most Chemicals

TYPICAL HANDLING PROPERTIES:

Viscosity, cps @ 25°C	>800,000
Pot life at 80°C, minutes	20
Shelf life at 25°C, months	4
Recommended Cure	1 hr/100°C+1 hr/150°C
Alternate Cure	2 hr/125°C
	Or 30 min/150°C
	Or 20 min/175°C

TYPICAL CURED PROPERTIES:

(Tested @ 25°C unless otherwise indicated)

Color	Black
Specific Gravity	1.5
Hardness, Shore D	91
Water Absorption (24 hrs at 25°C), %	0.09
Lap Shear Strength to Aluminum, psi	
At 25°C	2900
At 100°C	1800
Thermal Conductivity, W/mK	0.6
Flexural Strength, psi	12,400
Flexural Modulus, psi	1x10 ⁶
Service Temperature range, °C	-55 to 220
Glass Transition Temperature, °C	120
Coefficient of Linear Thermal Expansion, 10 ⁻⁶ /°C	
Below Tg	34
Above Tg	119
Dielectric Constant at 1 kHz	4.5
Dissipation Factor at 1 kHz	0.01
Volume Resistivity, ohm-cm	1x10 ¹⁵

INSTRUCTIONS FOR USE:

1. Use dispensing equipment for best results.
2. For small applications, apply the product using a syringe or clean spatula.
3. Avoid air entrapment to obtain optimum cured properties.
4. Proceed with the bonding application and cure as recommended.
5. Typical cured properties were determined using recommended cure schedule. Some difference in properties may occur with the alternate or other cure schedules.

AVAILABILITY:

Packaged in Pint, Quart and Gallon size
 30cc syringe & 8 OZ Semco Cartridge

SHELF LIFE (STORAGE TEMPERATURE):

Average 25°C	4 months
below 10°C	6 months

FOR INDUSTRIAL USE ONLY:

Practices of good housekeeping, safety and cleanliness should be followed before, during and after use.

WARNING!

Adequate ventilation of work place and ovens is essential. Refer to Material Safety Data Sheet (MSDS) for additional health and safety information.

DISCLAIMER: All data given here is offered as a guide to the use of these materials and not as a guarantee of their performance. The user should evaluate their suitability for own purposes. Properties are typical and should not be used in preparing specifications. Statements are not to be construed as recommendations to infringe any patent.