



**HBF EY3804**

EY3804 is a low viscosity, two-component epoxy system that offers low temperature cure, high temperature strength, and excellent resistance to hot water immersion. These properties make EY3804 an excellent choice for field repair of composite components. EY3804 may be considered as a permanent repair for service temperatures to 200°F. It has also qualified to specification BMS 8-301J, Class 2

<b>Technology / Base</b>	Epoxy
<b>Type of Product</b>	Structural Adhesive
<b>Components</b>	Two Component
<b>Curing</b>	Room Temperature (secondary thermal cure)
<b>Appearance / Color</b>	Grey
<b>Consistency</b>	Liquid

**Features and Benefits**

- Excellent Bonding to Metals, Composites, Coatings, and Most Plastics
- Excellent Chemical Resistance
- Suitable for MMD Dispensing Equipment
- Excellent Thermal Performance
- 100% Reactive
- Room Temperature Cure

**General Instructions**

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 gives the best results. Bring both components to room temperature prior to mixing. Just prior to using, blend the two components, Part A and Part B, in the ratio above. Mechanical mixing is preferable, but should be carried out at slow speeds (<300 rpm), taking as little air as possible into the adhesive batch. Spread a thin layer of the mixed adhesive on one or both of the parts to be bonded. Once the adhesive is applied, no open time is necessary. The surfaces can be assembled immediately. Parts should be assembled while the adhesive is still wet to the touch before it sets. The individual parts, the ambient temperature and the adhesive itself will dictate the open time permitted.

**Specifications and Approvals**

BMS 8-301 REV H CLASS 2

**Handling and Clean-Up**

See SDS for handling and clean-up information.

**Storage**

Product should be stored in a cool dry place out of direct sunlight. The shelf life is from date of manufacture. Shelf life is based on the products being stored properly at temperatures between 12°C and 25°C. Exposure to temperatures above 25°C will reduce the shelf life. This product should not be frozen.

**Use Note**

**Authorized Distributor**





Technical Data

Rheology	Value	Condition/Method
Viscosity - Part A	6000 cPs	at 25°C
Viscosity - Part B	1650 cPs	at 25°C
Viscosity - Mixed	3900 cPs	at 25°C
<b>Density</b>		
Specific Gravity		
<b>Uncured Material Characteristics</b>		
Volume Mix Ratio		
Weight Mix Ratio	100 to 66	
Pot Life		166 gram
Gel Time	40 to 44 min	at 25°C 166 gram
Handling Time		
Full Cure @ 23°C	10 to 14 days	
Full Cure @ 66°C	3 hours	
Shelf Life	Part B: 12 months unopened Part A: 3 months	
<b>Cured Mechanical Properties</b>		
Hardness	82 Shore D	ASTM D2240
Tensile Strength		
Elongation at Break	4.0%	
Overlap Shear Strength		
Aluminum, Acid Etched	26.9 MPa	ASTM D1002, 25°C 50% RH
Operating Temperature	-40°C to 95°C (-40°F to 200°F)	

**Safety and Disposal**

See SDS for safety and disposal information.

H.B. Fuller Company  
 1200 Willow Lake Boulevard  
 St. Paul, MN 55164  
 +1.651.236.5900 tel

[www.hbfuller.com](http://www.hbfuller.com)

[www.hbfullerengineering.com](http://www.hbfullerengineering.com)

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