



# EV Bond 343



## Technical Data Sheet



### Polyurethane Adhesive

EV Bond 343 is a medium-hardness, semi-flexible two-component polyurethane adhesive designed for bonding applications requiring resilient bonds, non-sag application and enhanced adhesion to flexible substrates.

EV Bond 343 is suitable for bonding metals, ceramics, natural rubber, thermosetting polymers and select types of unprepared thermoplastic substrates such as ABS, Polycarbonate and Nylon.

It is recommended that this product be tested before use on any polymer not specifically noted above. Other types of Thermoplastic substrates may be suitably bonded with EV Bond 343 after physical or chemical pretreatment.

<b>Technology/Base:</b>	Polyurethane
<b>Type of Product:</b>	Structural Adhesive
<b>Components:</b>	Two Component
<b>Curing:</b>	Room Temperature
<b>Appearance / Color:</b>	Amber/Black
<b>Consistency:</b>	Paste

### Mixing and Cure Schedule

To obtain the best cured properties, accurate proportioning and thorough mixing are essential.

The production of the desired polyurethane requires accurate measurement of the two components and adequate mixing.

Ratio	Part A	Part B
By weight	100	125
By volume	100	100

The cure schedule is dependent upon the temperature. The recommended cure schedule will vary with the desired properties.

The recommended schedule to achieve the typical properties is shown below:

18 hours @ 25 °C (77 °F) -or- 2 hours @ 80 °C (176 °F)



### Features and Benefits



- High Bond Strength
- Flexible
- Bonds Plastic & Metals
- Excellent for Battery Pack Assembly
- Fast Processing
- Ease of Use
- Reliability



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Typical Uncured Properties			
Property	Part A	Part B	Mixed
Color	Amber	Black	Black
Viscosity @ 25 °C, cps.	16,000	83,000	Thixotropic Paste
Weight per Gallon, lbs.	9.79	12.11	
Specific Gravity @ 25 °C	1.17	1.45	
Gel Time 10g (minutes)			3-5
Tack-Free Time, minutes (40 mil film)			15
Filler Type	None	Non-Abrasive	
Shelf Life (in separate sealed containers), months	6	6	

Typical Cured Properties	
Property	
Hardness (Shore D)	65
Lap Shear Strength, polycarbonate, 7-day cure, average psi	2000+ psi (substrate failure)
Lap Shear Strength, cold-rolled steel, solvent degreased 7-day cure, psi average	3,000
Lap Shear Strength, aluminum, solvent degreased, 7-day cure, psi average	2,200
Lap Shear Strength, galvanized steel, solvent degreased, 7-day cure, psi average	1,900
Cast Tensile Strength, 7-day cure, psi average	3,709
Cast Tensile Elongation, 7-day cure, % average	160



### 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 gal Pails  
55 gal Drums



### 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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