



Technical Data Sheet



Structural Adhesive Technologies

EV Bond 401 is a high performance two part methacrylate adhesive engineered to bond a wide range of plastics, metals, and composite assemblies. It offers outstanding bond strength, is extremely durable, with excellent impact and weathering properties. EV Bond 401 greatly increases the reliability of finished assemblies with exceptional flexibility, it's ability to with stand extreme temperature fluctuation and thermal cycling, and resistance to a wide range of chemicals and environmental conditions.

Technology/Base:	Modified Acrylic	
Type of Product:	Structural Adhesive	
Components:	Two Component	
Curing:	Room Temperature Cure	
Appearance / Color:	Amber, Grey, or Black	
Consistency:	Viscous Liquid	

Metals	ended For Thermoplastics
Aluminum	Acrylic
Steel	ABS
Stainless	Polycarbonate
E-Coated Metal	Nylon/PA
	PPO
Thermosets	Vinyl
Fiberglass	PVČ
Phenolic	Styrene
Gel Coat	Peek
Epoxy	PBT Blends
RIM Urethane	PET Blends
Polyurethane	
Liquid Molding Resin	



Features and Benefits



- No Surface Preparation Required
- Excellent Adhesion Properties
- Excellent Strength to Metals, E-Coat, Thermoplastics, Thermosets, and Engineering Plastics
- High Impact Resistance
- Suitable for Easy Manual and Pneumatic Dispensing

- Excellent Thermal Performance
- 100% Reactive
- Room Temperature Cure 1:1 meter-mix product for ease of application
- Use on as received metal surfaces including aluminum, stainless and plated steels and forms tough, high strength bonds without surface preparation







Technical Data

Rheology		Condition/Method
Viscosity - Resin	60,000 cPs @ 25°C40,000 -	Brookfield RV7 20 rpm
Viscosity – Activator	60,000 cPs @ 25°C	Brookfield RV7 20 rpm
Viscosity – Mixed		'
Thixotropic Index	5	Brookfield RV7 20/2 rpm
Density		
Mixed Density	0.98 g/cc	
Mix Ratio		
Volume Mix Ratio	1:1	
Weight Mix Ratio	1:1	
Uncured Material Characteristics		
Flash Point	51°F	
Open Time	8 - 12 minutes	
Fixture Time	20 - 35 minutes	
Cure Temperature and Time	Room Temperature, 24 hr	
Cured Mechanical Properties		
Gap Fill Dimension	0.125 inch	
Hardness	75 Shore D	ASTM D2240
Tensile Strength	4350 to 5800 psi (30 to 40 MPa)	ASTM D638
Over Lap Shear Strength		
Carbon Steel	3200 to 4000 psi (22 to 27 MPa)	ASTM D1002, 25°C 50% RH
Aluminum	3700 psi	ASTM D1002, 25°C 50% RH
Cured Thermal Properties		
Thermal Service Range	-67°F to 250°F	



General Information

The product is best used at temperatures between 65°F and 80°F. Temperatures below 65°F will slow the cure speed of the material and viscosities will be higher. Temperatures above 80°F will cause the material to cure faster and viscosities will be lower. For consistent dispensing maintain temperature in the above mentioned range. For optimum bond strength and to insure maximum performance in the finished assembly mate parts together within the specified work time of the adhesive. Make sure the bond joint has uniform coverage and that a sufficient amount of adhesive is in the bond area. It is important to have the adhesive applied, parts aligned and positioned, within the established work times for the product. To ensure maximum performance in the finished assembly parts should remain undisturbed until the fixture time is reached.



Handling and Clean-Up

Clean up is best before the adhesive has cured. Cleaners containing NMP (N-methyl pyrolidone) or Citrus terpene provide the best results. On cured adhesive repeatuse may be required.



Storage and Shelf Life

Product should be stored in a cool dry place out of direct sunlight. The shelf life of EV Bond 401 is one year from date of manufacture. Shelf life is based on the products being stored properly at temperatures between 55°F and 75°F. Exposure to temperatures above 75°F will reduce the shelf life. This product should NEVER BE FROZEN..



Typical Packaging

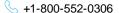
EV Bond 401 is conveniently packaged in 50 ml, 400 ml, pail, and drum kits. Special packaging is available upon request.



Safety and Disposal

For safe handling information on this product, consult the Safety Data Sheet (SDS)

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