

## TEROSON EP 8380 BK

August 2025

### PRODUCT DESCRIPTION

Terason EP 8380 BK provides the following product characteristics:

Technology	Epoxy
Chemical Type	Epoxy
Appearance (Resin)	Beige Paste
Appearance (Hardener)	Pale yellow paste
Appearance (Mixed)	Beige
Components	Two Components – requires mixing
Mix ratio, (by volume) Resin:Hardener	1:1
Mix Ratio, (by weight) Resin:Hardener	114:100
Cure	Room temperature cure after mixing
Application	Seam sealer
Application temperature	15 to 35°C
In service temperature	-40 to 90°C
Specific Benefits	<ul style="list-style-type: none"> <li>Very good sag resistance</li> <li>Good paint compatibility</li> <li>Good adhesion to raw steel/aluminum sheets.</li> </ul>

Terason EP 8380 BK is a fast cure two component, medium viscosity epoxy adhesive sealant. Once mixed, the two component epoxy cures to form a black flexible bond line that is effective for seam sealing in the vehicle repair market. Before curing, the material can be easily tooled holding brush strokes very well with minimal rolling and transparency. The fully cured epoxy is resistant to a wide range of chemicals and solvents, and acts as an excellent electrical insulator. Skin formation and curing times depend on humidity and temperature. In addition, the curing time also depends on the layer thickness. By increasing the temperature and humidity, the reaction time can be reduced. Low temperature retards the process.

Typical applications include the repair sealing of seams originally applied in the engine compartment, luggage boot, passenger cabin, wheel housing/underbody and a surface coating for repair purposes or completing PVC underbody coating and/or stone chip protection in the automobiles.

### TYPICAL PROPERTIES OF UNCURED MATERIAL

#### Resin

Specific Gravity @ 23°C	1.37
Viscosity, Anton Parr @ 25 °C mPa·s (cP)	
Spindle CP25-2 10 S <sup>-1</sup>	75000

#### Hardener

Specific Gravity @ 23°C	1.20
Viscosity Anton Parr @ 25 °C, mPa·s (cP):	
Spindle-CP25-2 10 S <sup>-1</sup>	68000

#### Mixed

Specific Gravity @ 23°C	1.32
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#### Extrusion Rate

23°C, HD14 Pneumatic, 50psi, g/min	42
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#### Sag Resistance

23°C, STM732, inches	0.05
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### TYPICAL CURING PERFORMANCE

Curing @ 23°C, 50%RH	
Work Time, STM823, minutes	12
Mix Nozzle Open Time, STM819, minutes	8
Hardness Development, STM707, Shore A @ time	
20 min	42
30 min	47
1 hr	55
4 hr	62
24 hr	74

### TYPICAL PERFORMANCE OF CURED MATERIAL

Cured for 72 hours @23°C,50% RH

Tensile properties, STM708, psi, El%:		
RT	420	50%
66°C, 500hr	1750	47%
93°C, 500hr	2000	54%
120°C, 500hr	2200	62%

#### Lap Shear strength STM700:

Aluminum (Acid Etched & Abraded)	N/mm <sup>2</sup>	6
	(psi)	(870)

### GENERAL INFORMATION

**This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials.**

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

### Directions for use

#### Important

For application of primers, fillers, primer fillers, paints or other coatings, technical guidelines from manufacturers have to be considered and followed.

#### Pretreatment

- The adhesion of TEROSON EP 8380 BK is improved if the surfaces are roughened with an abrasive non-woven.
- The substrates must be clean, dry and grease free.

#### Application

1. For the application of Teroson EP 8380 BK from cartridges, applicator guns, pneumatic (preferred) and manual dispensers can be used to form a material bead ("sealant bead")
2. Virtually all types of structures specified by the manufacturer can be reproduced rapidly and without problems by means of appropriate adjustments of the pistols.

### Cleaning

1. For cleaning application equipment contaminated with uncured products the use of IPA is recommended to be used safely.
2. Cured material can only be removed mechanically.

### Primer

1. When primers are used (2-component epoxy resin primers are particularly suitable due to their good corrosion protection and adhesion), these should be completely dry/have fully cured according to manufacturers' instructions, before sealing or coating.
2. Considering the great variety of systems available, sufficient trials should always be carried out.

### Painting

1. After skin formation Teroson EP 8380 BK can be painted with usual commercial available car paints.
2. Early overpainting does not inhibit curing but slows down the curing process.
3. Overpainting should be carried out within 3 days max. From the 4th day onwards, scuffing the seam sealer before painting facilitates optimal adhesion.
4. Considering great variety of systems available, sufficient trials should always be carried out.

### Storage

Store product in the unopened container in a dry location. Storage information may also be indicated on the product container labelling.

**Optimal Storage: 10 °C to 25 °C. Storage below 10 °C or greater than 28 °C can adversely affect product properties.** Material removed from containers may be contaminated during use. Do not return product to the original container. Henkel cannot assume responsibility for product which has been contaminated or stored under conditions other than those previously indicated. If additional information is required, please contact your local Henkel Representative.

### Data Ranges

The data contained herein may be reported as a typical value. Values are based on actual test data and are verified on a periodic basis.

Temperature/Humidity Ranges: 23 °C / 50% RH = 23±2 °C / 50±5% RH

### Conversions

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$   
 $\text{kV/mm} \times 25.4 = \text{V/mil}$   
 $\text{mm} / 25.4 = \text{inches}$   
 $\mu\text{m} / 25.4 = \text{mil}$   
 $\text{N} \times 0.225 = \text{lb}$   
 $\text{N/mm} \times 5.71 = \text{lb/in}$   
 $\text{N/mm}^2 \times 145 = \text{psi}$   
 $\text{MPa} \times 145 = \text{psi}$   
 $\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$   
 $\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$   
 $\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$   
 $\text{mPa}\cdot\text{s} = \text{cP}$

### Note

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