Technical Data Sheet

TEROSON® EP 8380 BK

September 2025

Product description

TEROSON® EP 8380 BK provides the following product characteristics:

Technology	Epoxy
Chemical type	Epoxy
Appearance (resin)	Black paste
Appearance (hardener)	Pale yellow paste
Appearance (mixed)	Black
Appearance (mixed) cured	Black
Components	Two components – requires mixing
Viscosity	Heavy-bodied
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	10 to 35°C (50 to 95°F)
In service temperature	-40 to 90°C (-40 to 194°F)
Specific Benefits	• Easily tooled and keeps shape • Very good sag resistance • Very good paint compatibility

TEROSON® EP 8380 BK is a fast curing, two-component, heavy-bodied epoxy adhesive sealant. Once mixed, the two component epoxy cures to form a flexible thermoset that is effective for replicating OEM-applied seams in the vehicle repair market. Before curing, the material can be easily tooled and holds brush strokes very well with minimal rolling and transparency. Work time and cure rate depend on temperature. By increasing the temperature, the reaction time can be reduced. Low temperature retards the process. Typical applications include replicating OEM hem flange seam seals around vehicle doors, hoods and trunks of vehicles being refurbished. Factory-applied seam sealant throughout the engine compartment, trunk, passenger cabin and wheel housing/underbody, etc. can be replicated when restoring vehicles to pre-crash condition.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Resin

Specific gravity @ 73°F (23°C)	1.37
Viscosity, mPa·s (cP): Anton Paar, MCR301, CP25-2, 25°C	75,000

Hardener

Specific gravity @ 73°F (23°C)	1.21
Viscosity, mPa·s (cP): Anton Paar, MCR301, CP25-2, 25°C	45,000

TYPICAL CURING PERFORMANCE

Working time

STM 823. Time after dispense that the material can be tooled to shape.

@ 73°F (23°C), minutes	12
@ 50°F (10°C), minutes	25
@ 86°F (30°C), minutes	6

Open time

STM-819. Open time is defined as maximum time that a static mixing nozzle being used may sit idle after which the static mix nozzle must be changed to facilitate further dispensing.

Open time, @ 73°F (23°C), minutes	8
Open time, @ 50°F (10°C), minutes	25
Open time, @ 86°F (30°C), minutes	6

TYPICAL PERFORMANCE OF CURED MATERIAL

Physical properties

Cured for 72 hr @ 73°F (23°C)		
Hardness, ISO 868, ShoreA		79
Tensile strength, at break, DIN 53504	(psi)	422
Elongation, at break, DIN 53504, %		50

Adhesive properties

Cured for 3 days @ 73°F(23°C)		
Lap shear strength, ASTM D1002:		
Aluminum, anodized	(psi)	894

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

Pretreatment:

1. Bonding surfaces must be free of oil, grease, dust, or any other contaminant. Clean bonding surfaces with IPA and lint-free cloth.

Application:

1. Load cartridge into 200mL applicator.
2. Unscrew retainer nut to remove nose plug with clip and discard.
3. Before attaching the static mixer to the cartridge, squeeze out a small amount of material until both adhesive components run equally. This is necessary to achieve a good mix of the two components.
4. Screw on provided static mixer.
5. To ready for dispense, dispense epoxy through the static mixer and purge at least a 2-inch bead of mixed epoxy onto a scrap towel. Note: If using the Door Edge nozzle, insert the filled static mixer into the prepared Door Edge nozzle with axial orientation enabling a comfortable dispense.
6. Apply TEROSON® EP 8380 BK heavy-bodied seam sealer and tool the material to desired profile. All bare metal areas should be covered with 2K epoxy primer before sealing.
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8. It may be necessary to change the static mixer if no material has been passed through for some time. Refer to Open Time at temperature information above, static mixer changes will be required sooner in warmer temperatures.
9. After use, leave the static mixing nozzle in place to seal the cartridge.

Curing:

1. Cure speeds may vary based on adhesive and substrate temperatures.
2. During the initial curing phase, the TEROSON® EP 8380 BK heavy-bodied seam sealer may easily be tooled within the Work Time.
3. Once the TEROSON® EP 8380 BK heavy-bodied seam sealer firms up it can no longer be easily tooled. Refer to indications of Work Time at temperature above for guidance.

Cleaning:

1. It is important to clean up excess adhesive from the work area and application equipment before it hardens.
2. Remove excess adhesive immediately with spatula or cloth and IPA. Cured adhesive can only be removed mechanically.

Painting:

1. Always follow paint manufacturer guidelines.
2. TEROSON® EP 8380 BK heavy-bodied seam sealer can be painted after application.
3. If painting more than three days after application, scuff the surface before painting to promote adhesion.

Storage

Store product in the unopened container in a dry location. Storage information may be indicated on the product container labeling.
Optimal Storage: 15°C to 35°C (59°F to 77°F).
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 beencontaminated or stored under conditions other than thosepreviously indicated. If additional information is required, please contact your local Henkel representative.

Product Specification

The technical data contained herein are intended as reference only and are not considered specifications for the product.
Product specifications are located on the Certificate of Analysis or please contact Henkel representative.

Approval and certificate

Please contact Henkel representative for related approval or certificate of this product.

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

(°C x 1.8) + 32 = °F
kV/mm x 25.4 = V/mil
mm / 25.4 = inches
µm / 25.4 = mil
N x 0.225 = lb
N/mm x 5.71 = lb/in
N/mm² x 145 = psi
MPa x 145 = psi
N·m x 8.851 = lb·in
N·m x 0.738 = lb·ft
N·mm x 0.142 = oz·in
mPa·s = cP

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Reference 1

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