



D Aircraft Products, Inc. 1191 Hawk Circle, Anaheim, CA 92807

# DAPCO<sup>®</sup> 3003 EPOXY ADHESIVE AND REPAIR COMPOUND

## GENERAL DESCRIPTION

DAPCO™ 3003 is a two-component, high strength, structural epoxy adhesive which cures at normal room temperature. This product features:

- Thixotropic flow properties permit use on vertical or overhead areas
- Bonds a variety of substrates, including metal, wood, concrete and plastic
- High resistance to cold and hot water, acids, alkalis, solvents, oils, grease, etc.

## APPLICATIONS

DAPCO™ 3003 is most commonly used as an insert potting compound as well as a general purpose adhesive. The product can be applied by extrusion, trowel, etc.

## TYPICAL PROPERTIES

	<u>PART A</u>	<u>PART B</u>	<u>MIXED</u>
Color	Semi-translucent	Grey	Grey
Solids, %	100	95	98
Appearance	Paste	Paste	Paste
Density, pounds/gallon		12.5	10.5
Specific Gravity			1.43

## PROCESSING

Mix Ratio: The recommended mix ratio for DAPCO™ 3003 is:

	<u>Weight</u>	<u>Volume</u>
Part A	100	1.0
Part B	138.6	1.0

DAPCO™ 3003 is a heavy paste and must be mixed thoroughly prior to use. **DO NOT MIX MORE THAN 1 PINT AT A TIME!**

Working Life: The pot life of DAPCO™ 3003 after mixing is 1 to 1-1/2 hours.

Curing: DAPCO™ 3003 achieves optimum cured properties when cured at room temperature (77°F) overnight.

Accelerated cure is 2 hours at 77°F followed by elevated temperature cure at 180°F for 2 hours.

## SURFACE PREPARATION

The substrates must be free from contaminants, i.e., dirt, oil, grease, etc. Clean the surface by wiping with a suitable solvent/cleaning agent and dry thoroughly. Mechanical roughening of the surfaces will often improve performance.

## **TYPICAL CURED PROPERTIES**

When cured in accordance with the recommended schedule, the following typical properties are developed:

Hardness, Shore "D"	85-90
Tensile Strength, (psi)	3000
Tensile Elongation, %	3
Shear Adhesion to:	
Aluminum (2024 T3)	1700 psi
Carbon Steel	2400 psi
Stainless (321)	1600 psi
Plywood/plywood	2000 psi
substrate failure	
Rigid PVC/PVC	1800 psi
substrate failure	
Concrete/Concrete	1200 psi
substrate failure	

## **STORAGE AND HANDLING**

Store in a cool, dry place.

Keep containers tightly sealed. Settling may occur within the "B" component during storage, mix thoroughly before use.

Shelf life: 12 months from date of shipment

## **SAFETY**

Exercise good housekeeping practices. Material Safety Data Sheets available upon request.