

BÜFA®-KLEBEHARZ 0110

Unreinforced VE Bonding Paste

Prod. No. 740-0110

Product description BÜFA® Bonding Paste 0110 is a pre-accelerated bonding paste on an elasticised vinyl ester base. Because of the properties of the base resin, the bonding paste has good heat resistance and excellent strength. BÜFA® Bonding Paste 0110 is also very stable on vertical surfaces and can be worked by hand as well as with suitable metering equipment.

Applications BÜFA® Bonding Paste 0110 is used for bonding laminates subjected to high dynamic loads.

Specifications / technical data	Property	Test method	Value	Unit
	Density at 20 °C	DIN 53 217/2	approx. 1,2	g/ml
	Viscosity at 23 °C Brookfield RV/DV-II Spl 96 rpm 3	TM 2913 EN	1500000 - 2100000	mPas
	Styrene content		41 - 44	%
	Flash points	DIN 53 213	+ 32	°C
	Solid content	EN ISO 1172	8 - 10	%
	Fibre reinforced		no	
	Peroxide indicator		yes	

Curing

Reactivity of the intermediate:
BÜFA method in accordance with test method 2625
 (100 g intermediate + 3 g Butanox M-50)

25 - 35 °C	24 - 26 min
25 °C - Tmax	37 - 45 min
Tmax	120 - 140 °C

Gel time of the bonding paste at 23 °C in a 200 g cup with 4 ml Butanox M-50: 55 - 65 min

Attention!

The information given above refers exclusively to the use of the catalyst named and the quantity specified. The use of different products or differing quantities may yield different results.

BÜFA®-KLEBEHARZ 0110

Unreinforced VE Bonding Paste

Prod. No. 740-0110

Mechanical Properties**Tested according to DIN EN 1465**

Property* adherend	Steel adherend	GRP
Shear strength	14.50 MPa	9.50 MPa
Elongation at break	3.7 %	3.3 %
Shear module	620 MPa	310 MPa
Failure	cohesion	laminate

* Measured in a standard laboratory atmosphere. Remember that the preparation, pre-treatment and subsequent treatment of the substrates and the bonding seam play a decisive role on mechanical properties.

Directions for use

Temperature development, 1 cm thick layer*: 36 - 40 °C
Temperature development, 2.5 cm thick layer*: 97 - 101 °C

Linear shrinkage in accordance with EN 12617-1*: 0.28 %

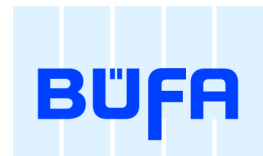
* Cured with 2 % Butanox 50 in a standard laboratory atmosphere.

If the bonding paste is mixed with the hardener by hand, the mixture should be poured into a second container after it has been intensively stirred to ensure homogenous distribution of the peroxide. If circumstances permit, we recommend post-curing the moulded part for 6 hours at approx. 80 °C to achieve optimal properties of the cured resin.

Storage/Handling

This product must be stored cool in closed containers, protected from sunlight. Shelf-life is at least 5 months in unopened, original containers stored up to a temperature of 20 °C. Gel and curing times may change with increasing duration of storage.

Note: The Information given above is based on our current state of knowledge and experience. In view of the many factors that may influence working conditions and the application of our products, the user is not relieved from carrying out his own tests and experiments. No legally binding warranty of certain properties or suitability for a particular purpose can be derived from this information. It is the responsibility of the receiver or user of our products to observe proprietary rights as well as existing laws and regulations. The latest version of the corresponding EU Safety Data Sheet must also be observed.



Gelcoat Plus

BÜFA®-KLEBEHARZ 0110

Unreinforced VE Bonding Paste

Prod. No. 740-0110

BÜFA Gelcoat Plus GmbH & Co. KG
Hohe Looge 2-8
26180 Rastede
GERMANY
Phone +49 4402 975-0
Fax +49 4402 975-300
gelcoatplus@buefa.de
www.buefa.de
www.buefagelcoatplus.com

A company of BÜFA and DSM Composite Resins