

BÜFA® -Bonding Paste 0181

Art.-No. 7400181

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BÜFA®-Bonding Paste 0181 is based on a blend of tetrahydrophthalic and isophthalic unsaturated polyester resins dissolved in styrene. The product is fibre-reinforced and is filled with a lightweight mineral. It is characterised by its very good mechanical properties, in particular, with regard to impact resistance and elongation at break.

Profile

Product type	Bonding Paste
Product family	OPTIMAL
Pre-accelerated product	Yes
Fibre Reinforced	Yes
Peroxide indicator	Yes
Colour	brown, cloudy

Application Range

BÜFA®-Bonding Paste 0181 is particularly well suited as a "liquid laminate" between the gelcoat and glass matt and, for moulded parts with sharp edges and complex geometry, it serves to smooth the contours. This is intended to ensure that, when constructing the laminate, the glass fibres fit well in all places. This prevents the need to arrange the fibres and, therefore, the risk of formation of cavities between the gelcoat and the laminate.

Specification / Technical Data

Density approx.	1.26 g/mL
Flashpoint approx.	32°C
Styrene content approx.	25.5 %
Viscosity (BM V02) Viskosität bei 20°C mit Spindel 7 und 5 U/min	120,000 - 160,000 mPas

The BÜFA testing standards define the testing scenario after the values are determined in our facilities. They relate to generally accepted standards and are available under request.

Curing

Reactivity	BM R02
Sample size	100g sample
Peroxide addition	2.0 Vol% Curox M-303
Geltime (Reactivity 20-30°C)	25 - 35 min
T-Max (Reactivity Tmax at 20°C)	110 - 130 °C

ATTENTION! The above information refers exclusively to the use of the peroxides mentioned here in the indicated dosage. If other products are used or if the dosage differs, the results may vary.

We recommend post-curing (tempering) the component for several hours at 80°C, as this is the only way to achieve the optimum mold material properties.

Processing

BÜFA®-Bonding Paste 0181 can only be processed by hand due to the nature of the product.

The suitability of this bonding paste for use in bonding the substrate in question should be checked in advance.

After adding the curing agent and stirring thoroughly, the mixture should be transferred to a second container. This ensures the homogenous mixture of the peroxide.

The adhesive resin layer should not be less than 1.5 mm thick.

The maximum adhesive layer thickness should not exceed 7 mm.

The recommended bonding paste layer thicknesses should be taken into account in order to be able to ensure good curing at low layer thicknesses on the one hand and also to ensure that the maximum temperature is not too high if the layers are too thick. Layer thicknesses which deviate from this recommendation should each be checked separately.

The product should be processed in layer thicknesses below 7 mm, otherwise shrinkage marks will occur. In order to be able to laminate the subsequent glass mat into the adhesive resin that has not yet gelled, the adhesive can also be mixed with 1.5 - 2.0 % Butanox LPT.

Other information

As a result of the wide range of factors which may influence the operating conditions and the application of the product, the user must still carry out their own tests and trials.

Acetone or the BÜFA®-GRP Multi Cleaner can be used for degreasing, cleaning the tools and removing uncured filler residues.

Due to fiber reinforcement, viscosity may increase over time.

Storage and handling

The inspection and assurance of the product quality (goods which meet the specifications) take place within the framework of quality control immediately after the product has been manufactured.

The product must be kept closed, cool, dry and protected from sunlight.

In unopened and undamaged original containers, at storage temperatures of up to 20 °C the product can be used for at least 3 months.

The setting and curing times as well as the viscosities may vary with longer storage periods.

Technical Data Sheet //

The above details have been compiled to the best of our knowledge and are based on our current knowledge and experience. These details only constitute product descriptions. Under no circumstances do they constitute guarantees relating to quality or durability. The processor is obliged to carry out their own tests and investigations in order to take responsibility for any processing and application of our products in the processor's application area. The latest version of the corresponding EU safety data sheet must also be observed.