

## BÜFA®-Bonding Paste 0600

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BÜFA®-Bonding Paste 0600 is based on an orthophthalic unsaturated polyester resin and is a fibre-reinforced standard bonding paste with a filling paste consistency. The product is characterised by its very good thixotropic behaviour on vertical surfaces.

### Profile

<b>Product type</b>	Bonding Paste
<b>Product family</b>	STDVERKLEBUNG
<b>Pre-accelerated product</b>	Yes
<b>Fibre Reinforced</b>	Yes
<b>Peroxide indicator</b>	Yes
<b>Colour</b>	blue
<b>Machine dosable</b>	Manual processing
<b>Recommendations for use</b>	Standard bonding

### Application Range

BÜFA®-Bonding Paste 0600 is suitable as a fibre-reinforced standard bonding paste for bonding cured GRP UP laminates as long as there are no increased requirements for the heat-deflection temperature. It is not suitable for high-strength and structural bonds or applications.

## Specification / Technical Data

<b>Density approx.</b>	1,4 g/mL
<b>Flashpoint approx.</b>	32°C
<b>Styrene content approx.</b>	16.6 %
<b>Viscosity (BM V02) Viskosität bei 20°C mit Spindel 7 und 5 U/min</b>	500,000 - 700,000 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

<b>Sample size</b>	100g sample
<b>Peroxide addition</b>	Curox M-303 2.0 vol%
<b>Orientating reactivity data</b>	BM R02 100 g sample 2.0 vol% Curox M-303  Reactivity 20-30°C: 30-45 min Reactivity Tmax at 20°C: 100-130°C.

Note: These data serve as orientation for the use of other, suitable peroxides. In any case, the use of the peroxides under the present conditions must be checked for suitability.

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 0600 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.

The surfaces to be filled / fused must be free from dust, oil, grease and any other residues, which may negatively affect adhesion.

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 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.

## 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.

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.