

BÜFA® -Bonding Paste 0139

Art.-No. 7400139

Status: 2/29/2024

BÜFA®-Bonding Paste 0139 is a fibre-reinforced bonding paste with a filling paste consistency. When cured, the product is characterised by its viscoplastic bonded joints.

Profile

Product type	Bonding Paste
Product family	METALLHOLZ
Pre-accelerated product	Yes
Fibre Reinforced	Yes
Colour	beige
Machine dosable	Manual processing

Application Range

BÜFA®-Bonding Paste 0139 is particularly 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.

Specification / Technical Data

Density approx.	1.33 g/mL
Flashpoint approx.	34°C
Styrene content approx.	28.2 %
Viscosity (BM V02) Viscosity at 20°C with spindle 7 and 5 rpm	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

Reactivity	BM R02
Sample size	100g sample
Peroxide addition	2.0 vol% Butanox M-50
Geltime (Reactivity 20-30°C)	17 - 24 min
T-Max (Reactivity Tmax at 20°C)	95 - 125 °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.

BÜFA®-Bonding Paste 0139 enables curing with commercially available catalysts based on benzoyl peroxide or methyl ethyl ketone peroxide.

In order to achieve the maximum mechanical properties, the product must be tempered.

Processing

BÜFA®-Bonding Paste 0139 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.

Maritime approval: DNV

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.