

# BÜFA® -Bonding Paste 0182

Art.-No. 7400182

Status: 9/7/2022

BÜFA®-Bonding Paste 0182 is based on unsaturated tetrahydrophthalic - polyester resin dissolved in styrene. The product is fibre-reinforced and is characterised by its very good mechanical properties, in particular, with regard to impact resistance and elongation at break, as well as thermal stability.

## Profile

<b>Product type</b>	Bonding Paste
<b>Product family</b>	Optimal laminate constructions
<b>Resin base</b>	Tetrahydrophthalic acid (THP)
<b>Pre-accelerated product</b>	Yes
<b>Fibre Reinforced</b>	Yes
<b>Peroxide indicator</b>	Yes
<b>Colour</b>	purple

## Application Range

BÜFA®-Bonding Paste 0182 is mainly used as a "liquid laminate" between gelcoat and glass mat. 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 formation of cavities between the gelcoat and the laminate.

## Specification / Technical Data

<b>Density approx.</b>	1,2 g/mL
<b>Flashpoint approx.</b>	40,5°C
<b>Styrene content approx.</b>	26,60 %
<b>Viscosity (BM V02) Viscosity at 20 °C with spindle 7 and 5 rpm</b>	480,000 - 620,000 mPas

The BÜFA test procedures describe the test scenario according to which the characteristic values are determined in our company. They refer to generally applicable standards and can be requested if necessary.

## Curing

<b>Reactivity</b>	BM R02
<b>Sample size</b>	100g sample
<b>Peroxide addition</b>	Curox M-303 2.0 vol.%
<b>Geltime (Reactivity 20-30°C)</b>	12 - 18 min
<b>Curing time (Reactivity 20°C-Tmax)</b>	23 - min
<b>T-Max (Peak temperature at 20°C)</b>	150 - 180 °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.

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

## Processing

BÜFA®-Bonding Paste 0182 can be processed both by hand and with suitable dosing systems.

The suitability of this bonding paste for bonding with 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 product should be applied in layer thicknesses below 5 mm, otherwise shrinkage marks will occur. In order to laminate the subsequent glass mat into the not yet gelled adhesive resin, the adhesive can also be processed with 1.5 - 2.0 % Butanox LPT-IB 94. This process optimises the transition structure and interlaminar adhesion.

## Other information

Due to the large number of factors that can 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 in order to degrease and clean the tools, as well as to remove residues of filler which have not cured.

The viscosity may increase over time as a result of the fibre reinforcement.

## Storage and handling

The product must be stored closed, in a cool, dry place and protected from sunlight.

In unopened, original containers, the product can be processed for at least 3 months if properly stored at up to 20 °C.

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

The setting and curing times as well as the viscosities may change as a result of lengthy 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.