

bonding pastes

italbeit has formulated a range of polyester adhesives and putties based on highly selected raw materials. They are normally used in the PRFV industry for all those applications where a consistent bonding between fibreglass parts, structural parts and core materials is needed together with a low shrinkage.

The formulation is based on different polyester resins in styrene, chosen depending on the requirements of their application: water resistance, chemical resistance, better adhesion to the reinforcement fibres and fillers of the system, better adhesion to the surface they are applied on.

They are supplied already pre-accelerated, and they only have to be catalysed using standard peroxides available on the market. Gel time is normally tailored on the customers' needs or on the climate conditions (winter and summer).

Most of them are formulated with a viracolor additive that allows the visual check of the presence of the peroxide and its proper and even dispersion into the bonder/putty.

application characteristics

All **italbeit's** bonding pastes are characterized by an excellent application ease, either when applied by knife, or when applied using specific machines with catalizer and pumping system.

Before starting the application, we suggest to sand the fibreglass parts when needed in order to obtain an even and smooth surface. It is also advisable to check the finishing of the PRFV parts and, by using a cloth wetted with styrene, to remove all potential dust and other polluting agents which might compromise the structural strength of the bonding.

italbeit's bonding pastes must be catalysed following the instructions given in the attached table and using a percentage of peroxide between 1% and 2%. Before stressing bonded parts let them rest for at least 24 hours at room temperature (15/25°C).

We do not recommend to bond together surfaces finished with woven rovings or tissues which, as widely known, negatively affect the bonding characteristics.

packaging

Kg. 18 - 25 - 200

liner on request

storage stability

3 months from despatch date, if stored in the original closed packages, between 16°C and 22°C, kept away from naked flames, heat sources, direct sunlight.

warning

- flammable products: keep away from heat sources, naked flames and sparkles.
- do not smoke, drink or eat while using it.
- avoid electrostatic charges.
- consult Safety Data Sheet.

chemical and physical characteristics

code	resin	appearance	gel time	peroxide	flex strength MP-a	fibre	note
3S736	N	clear thixo	5' - 10'	BPO	-	no	Polyester moulds maintenance and repair. Marbles bonding.
3S2049W	O	white thixo	8' - 15'	MEKP	-	no	Body filler. Also available clear (3S2049U)
3AC4	O	blu	10' - 20'	MEKP - BPO	4-9	yes	Body filler with fibreglass. Can be catalysed with both systems. Also available without fibres (3A4). Viracolor.
3AC	O	blu	20' - 40'	MEKP	5-1	yes	Structural adhesive with viracolor. Refrigerator truck industry.
3AV	O	blu	20' - 40'	MEKP	5-5	yes	Semi-structural adhesive and body filler. Also available with viracolor.
3AR	N	grey	20' - 60'	MEKP	6.8	yes	Highly resilience, rough finishing. Specifically formulated for structural bonding in the marine industry.
3ACVE	V	pink thixo	60' - 90'	CHP	4-5	yes	Chemical resistant reinforced with C glass. Ideal for bonding and/or repairing PRFV parts in contact with chemicals.
3ACB9	N	blu Thixo	15' - 40'	MEKP	5-7	yes	Specifically formulated for the marine industry as a back up behind the gel coat film. High resistance to water. Viracolor
3A1140	N	blu	20' - 60'	MEKP	-	no	Ultra light bonder for core material. Specific for PVC and similar. Very low specific weight. Viracolor.
3A0731NFV	O	blu thixo	20' - 40'	MEKP	5-4	yes	Adhesive and body filler for the truck industry with low specific weight. Viracolor.

Flexural strength according to ASTM D-3165

Gel Time according to Italtel method Po4

Resin: N = neopentilic - O = ortho - V = vinyl ester

note

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