

TECHNICAL DATA SHEET

B10 – LIGHT POLYESTER BONDING PASTE

Lightweight adhesive bonding paste based on unsaturated polyester resins, microspheres and light reinforcing fillers. Specifically formulated for the composite sector for bonding core materials and inserts in Balsa, PVC, PET, PIR and polyurethane foam.

It is easy to apply, spread with spatula, easily deaerate and stick to the surface thanks to the excellent tixotropy.

Under pressure or vacuum it flows easily saturating every crack and cavity of the foam thus ensuring high mechanical, thermal and chemical properties to the sandwich laminate.

The low specific weight of its formulation is combined with limited shrinkage during hardening and excellent adhesion performance even on high density foams.

The product contains a "color-changing" pigment (*Viracolor*) in order to verify the homogeneous dispersion of the peroxide.

SUPPORTS

Recommended: properly prepared and cleaned polyester and vinylester fiberglass laminates.

GENERAL INSTRUCTIONS FOR USE

The product can be applied directly to freshly laminated surfaces free of dust, fibers, dirt and condensation.

Completely hardened surfaces must instead be sanded and cleaned thoroughly.

The suitability for use on surfaces obtained from paraffin resins must be checked.

Mix the product directly in its package with 1,0 – 2,0% of liquid hardener (methylethyl ketone peroxide), bearing in mind that the amount of hardener required depends on the temperature of use and the processing times required.

The recommended temperature range is between 16 and 28°C.

It can be applied manually with a spatula or by machine.

For quantities over 5kg, mixing with a stirrer is recommended, while for 200l drums, the use of a pressing plate extruder/mixer guarantees the best mixing efficiency.

The product has also been formulated to be sprayable, where the large surfaces of components or the rapid cycles of mass production require it.

For further details and recommended application procedures, refer directly to the guideline "**Bonding Pastes for Core Materials**", available at INTEC's Technical Customer Service.

In its original packaging, the product can be used for **12 months** if stored indoor away from direct sunlight, at temperatures not exceeding 20°C. Some drift may occur in gel time.

TYPICAL SPECIFICATIONS OF THE LIQUID PRODUCT

Tests made at 23°C	Value	Unit	Method
Color	Light Blue - Viracolor	-	IMIA-01
Density	1 ± 0,1	Kg/l	IMIA-02
Solid content	71 ± 2	%	IMIA-03
Viscosity (Brookfield, Tc ,5 rpm)	150000 - 250000	cP	IMIA-10
Reactivity (100g product + 1,50g CT21/MEKP 50%)	40 ± 10	min	IMIA-15

TYPICAL CHARACTERISTICS OF THE CURED PRODUCT (*)

Tests made at 23°C	Value	Unit	Method
Linear shrinkage	0,80 ± 0,05	%	IMIA-25
Superficial hardness	70 ± 5	Shore D	IMIA-29
Flexural Modulus	3250	MPa	ISO 178
Tensile Modulus	4059	MPa	ISO 527
Thermo-mechanical resistance:			
HDT	70 ± 5	°C	IMIA-50
Tg	72 ± 5	°C	ASTM D3418
(*) Curing cycle: 24 hours at 23°C and 3 hours at 80°C			

The information and data contained in this technical sheet are based on the measurements and experience gained; in good faith, they are made available to the customer who is responsible for the application verification and the definition of suitability for the intended use.

INTEC assumes no responsibility for the results obtained in the specific application made by the user.

Last update: January 2025

Revision: 3



INTEC s.r.l. a Socio Unico

Società soggetta a direzione e coordinamento di Briolf Group S.L.

Via Edison, 4 - 42049 Calerno - Sant'Ilario d'Enza (RE) - Italy

E-mail: info@intecforcomposites.com - Tel.: +39 0522 909727