

TECHNICAL DATA SHEET

BV10R – LIGHT VINYLESTER BONDING PASTE RAPID Type Approval Certificate N° DIP146622CS

Adhesive bonding paste based on unsaturated vinylester resins, microspheres and light reinforcing fillers, characterized by high mechanical and thermal properties, and low shrinkage.

Specifically formulated for the use of large vacuum bags and for bonding sheets and inserts in Balsa, PVC, PET, PIR and polyurethane foam, is easily spatulable and deaerated without dripping from vertical surfaces.

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

Properly prepared and cleaned polyester and vinylester fiberglass laminates.

GENERAL INSTRUCTIONS FOR USE

Product particularly suitable for applications in the winter months.

Can be applied directly on freshly laminated surfaces free of dust, fibers, dirt and condensation.

Completely hardened surfaces must instead be sanded and cleaned thoroughly.

- Mix the product directly in its packaging and mix it 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 (See page 10 of the guideline: “**Bonding Pastes for Core Materials**”).
- The recommended temperature range is between 14 and 18°C.
- It can be applied manually with a spatula, for quantities over 5kg, mixing with a whisk 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 **6 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	1,03 ± 0,05	Kg/l	IMIA-02
Solid Content	72 ± 2	%	IMIA-03
Viscosity (Brookfield, Tb, 5rpm)	150000 - 250000	cP	IMIA-10
Reactivity (100g product + 1,50g CT21/MEKP 50%)	40 ± 10	min	IMIA-15
Reactivity (100g product + 1,50g CT21/MEKP 50%) temp. 16°C	120 ± 10	min	IMIA-15

TYPICAL CHARACTERISTICS OF THE CURED PRODUCT (*)

Tests made at 23°C	Value	Unit	Method
Linear shrinkage	0,3 ± 0,05	%	IMIA-25
Superficial hardness	70 ± 5	Shore D	IMIA-29
Flexural Modulus	3279	MPa	ISO 178
Tensile Modulus	4392	MPa	ISO 527
Thermo-mechanical resistance:			
HDT	90 ± 5	°C	IMIA-50
Tg	95 ± 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.

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INTEC s.r.l. a Socio Unico

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