Technical data sheet

GRAVICOL 2040 TC

BONDING PASTE - WITHOUT GLASS FIBER

Date sheet n° : *1015*

Updated : *01.12.16*

Assembly	*Aid to lamination*	*Gap filling*

DESCRIPTION

Pre-accelerated bonding paste based on unsaturated polyester resin. Cures at room temperature (15 - 25°C).
Cured using MEKP peroxide.

APPEARANCE

TC : Contains catalyst indicator

USE AREAS

Product is suitable for many types of thin joint bonding of composite parts.

APPLICATION

Surface to be bonded should be free from dust and contaminants which can adversely affect the bond adhesion strength.
Preparation of surface is recommended using light abrasion / sanding followed by cleaning with appropriate solvent.
The bonding paste is ready to use and reaction is initiated using the correct dosage of correct peroxide. Typical dosage is 1% to 2% w/w under normal workshop application conditions (15-25°C).
Mix thoroughly to ensure homogeneous catalyst dispersion (this is assisted by use of catalyst indicators which change colour in TC version).
Apply a uniform bead of bonding paste onto one of the surfaces and press parts together evenly to obtain the desired thickness of bond. Typically the thickness of the joint should be between 0,7mm and 5mm.
We recommend allowing sufficient time for cohesive bond to form between laminates before handling bonded parts (cf : MECHANICAL PROPERTIES AFTER CURING).

PROPERTIES / ADVANTAGES

Semi rigid bonding paste for static bonding applications.
Bonding paste without fibres for thin joints.
Very smooth consistency, and easy to apply with a spatula or comb applicator.
Bonding paste with very low shrinkage helping to avoid distortion of assembled parts .

STORAGE / SHELF LIFE

Shelf-life : 6 Months .
When the product is sealed in its original packing, stored indoors away from direct sunlight and direct heat sources and ideally at ambient temperature between 15°C and 25°C .

TYPICAL CHARACTERISTICS : LIQUID

Properties	*Test method*	*Conditions*	*Unit*	*Typical values*
Density	MT-C B 001 O	23°C	g/cm3	1,37 - 1,41
Viscosity	MT-C B 023 V	23°C - Spindle V73 - 0,5 rpm	mPa.s	2 000 000 - 4 000 000
Gel time	MT-C B 072 R	Catalyst : MEKP (250g - 23°C - 1% MEKP)	min	60 - 90
Peak time	MT-C B 072 R		min	90 - 130
Peak exotherm	MT-C B 072 R		°C	100 - 130

TYPICAL CHARACTERISTICS : MECHANICAL PROPERTIES AFTER CURING

Properties	*Test method*	*Conditions*	*Unit*	*Typical values*
Compressive strength	NFP 15-451		MPa	70
Flexural strength	NFP 15-451		MPa	29
Bond failure in the laminate	MT-C B 901 Q	20°C	h	4

For all additional information, refer to the Safety Data Sheet n° FP 12434 available on our website.

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