

Date sheet n°

BONDING PASTE

1030

GRAVICOL 2503R

WITHOUT GLASS FIBER**I. DESCRIPTION**

An accelerated bonding paste based on unsaturated polyester resin. Cures at room temperature (15 - 25°C) with Methyl Ethyl Ketone Peroxide.

II. PROPERTIES / ADVANTAGES

Rigid bonding paste, formulated without glass fibers.
Present a short gel time.
Presents a very low level of shrinkage to ensure that no surface distortion is caused.

III. USE AREAS

| <i>salling</i> | <i>Help for the stratification</i> | <i>Casting</i> |
|-------------------------------------|------------------------------------|-------------------------------------|
| <input checked="" type="checkbox"/> | <input type="checkbox"/> | <input checked="" type="checkbox"/> |

For bonding unsaturated polyester GRP (Glass Reinforced Polyester) composites.
The product can be used as a gap filler, fixing and sealant.

IV. PRESENTATION

STD : Quality with normal reactivity
WHITE : White version of bonding paste.

V. PACKAGING

Packaging : 25 Kg
Packaging : 250 Kg

VI. STORAGE / CONSERVATION

Keep the product at ambient temperature between 15°C and 25°C .
Shelf life : 6 months .

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VII. CHARACTERISTICS*** LIQUID**

| | |
|--------------------------------|-------------------|
| . Look :..... | Thixotropic paste |
| . Flash point NFT 30050 :..... | 31°C |
| . Density :..... | 1,46 - 1,54 |
| . Viscosity (mPa.s) :..... | N.A |

*** CURING**

| | | |
|---|-------------|-----------|
| . Catalyst : | MEKP | |
| . Gel time (mn) (250g - 23°C - 1% MEKP) :..... | | 13 - 21 |
| . Peak time (mn) (250g - 23°C - 1% MEKP) :..... | | 40 - 70 |
| . Peak exotherm (°C) (250g - 23°C - 1% MEKP) :..... | | 100 - 120 |
| - Bond filure in the laminate :..... | | 6h |

*** MECHANICAL PROPERTIES AFTER CURING**

| | |
|--|-------|
| - Compressive strength - NFP 15-451..... | 75MPa |
| - Flexural strength - NFP 15-451..... | 25MPa |

VIII. APPLICATION

The surfaces of the part to be bounded should be free of dust contaminants to ensure the best level adherence. If necessary, the surface of the parts should be abraded and solvent wiped.

The bonding paste is ready to use. Under normal application conditions (15 – 25°C), add the necessary quantity of catalyst : the paste should be catalysed between 1 min. and 2 % max. Mix until completely homogeneous (and disappearing of catalyst indicator in TC version).

For all additional information, refer to the Safety Data Sheet n°1030 available at our website address www.crayvalley.com.