

GRAVICOL 2039 TC

BONDING PASTE
WITHOUT GLASS FIBER



Technical data sheet

Date sheet n° : 1011
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DESCRIPTION

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

PROPERTIES / ADVANTAGES

Semi flexible bonding paste for dynamic 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 that helps to avoid distortion of assembled parts .

USE AREAS

Product suitable for many types of bonding of composite parts for thin joints.
Product designed for thin joint the assembly of composites with suitable polyurethane foam, Balsa wood, etc. ...
The product suits for all the operations of gap filling, surface filling and sealing.
The product can be used as a laminating aid.

APPEARANCE

TC : Contain a catalyst indicator.

APPLICATION

Surface to be bonded should be free from dust and contaminants which can adversely affect the bond adhesion and strength.
Preparation of surface is recommended with light abrasion / sanding and 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% 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. 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 parts.

STORAGE / CONSERVATION

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		CURING	
. Density.....	1,28 - 1,34	. Catalyst : MEKP	
. Viscosity (dPa.s)..... [23°C - Spindle V73 - 0,5 rpm]	30 000 - 40 000	. Gel time (mn) (250g - 23°C - 1% MEKP) :.....	14 - 22
		. Peak time (mn) (250g - 23°C - 1% MEKP) :.....	50 - 80
		. Peak exotherm (°C) (250g - 23°C - 1% MEKP) :.....	100 - 130

MECHANICAL PROPERTIES AFTER CURING

Assembly	Aid to lamination	Gap filling
■	■	■
- Bond failure in the laminate (h) (20°C) :.....		6
- Compressive strength (MPa) - NFP 15-451 :.....		55
- Flexural strength (MPa) - NFP 15-451 :.....		35

For all additional information, refer to the Safety Data Sheet n° FP 12431 available at our website address www.polynt.com.

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