

GRAVICOL 2428 TC

BONDING PASTE
FIBER



Technical data sheet

Date sheet n° : 1102
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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 rigid bonding paste for static bonding applications.
Bonding paste with fibres for thick joints.
Very smooth consistency, and easy to apply with a spatula or comb applicator.
Due to its no shrinkage characteristics, dimensional stability of part is maintain after curing of paste.
Not flows in thick bond applications.

USE AREAS

Product suitable for many types of bonding of composite parts for thick joints.
Due to the consistency, the product is typically used for repairs of composites.

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 typically are greater than 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 - 1,35	. Catalyst : MEKP	
. Viscosity (dPa.s)..... [23°C - Spindle V73 - 0,5 rpm]	40 000 - 60 000	. Gel time (mn) (250g - 23°C - 1% MEKP) :.....	15 - 23
		. Peak time (mn) (250g - 23°C - 1% MEKP) :.....	45 - 75
		. Peak exotherm (°C) (250g - 23°C - 1% MEKP) :.....	100 - 120

MECHANICAL PROPERTIES AFTER CURING

Assembly	Aid to lamination	Gap filling
<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
- Bond failure in the laminate (h) (20°C) :.....		4
- Compressive strength (MPa) - NFP 15-451 :.....		57,5
- Flexural strength (MPa) - NFP 15-451 :.....		29

For all additional information, refer to the Safety Data Sheet n° FP 12447 available at our website address www.polynt.com.

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