

GRAVICOL 3110 IHB TC

BONDING PASTE - FIBER

Date sheet n° : 3111
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Assembly	Aid to lamination	Gap filling

DESCRIPTION

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

APPEARANCE

IHB : Quality with slow reactivity
TC : Contains catalyst indicator

USE AREAS

Product suitable for many types of thick joint bonding of composite parts. Product designed for thin joints bonding in the assembly of composites with suitable polyurethane foam, Balsa wood, etc. ...

APPLICATION

Surface to be bonded should be free from dust and contaminants which can adversely affect the bond adhesion strength. 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 is greater than 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 with fibres for thick 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 . Not suitable for use in thick bond applications.

STORAGE / SHELF LIFE

Shelf-life : 4 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	1,23 - 1,26
Viscosity	MT-C B 023 V	23°C - Spindle V73 - 0,5 rpm	mPa.s	55 000 - 65 000
Gel time	MT-C B 074 R	Catalyst : MEKP (250g - 23°C - 1,5% MEKP)	min	55 - 65
Peak time	MT-C B 074 R		min	70 - 60
Peak exotherm	MT-C B 074 R		°C	95 - 135

TYPICAL CHARACTERISTICS : MECHANICAL PROPERTIES AFTER CURING

Properties	Test method	Conditions	Unit	Typical values
Compressive strength	NFP 15-451		MPa	96
Flexural strength	NFP 15-451		MPa	20
Bond failure in the laminate	MT-C B 901 Q	20°C	h	5

For all additional information, refer to the Safety Data Sheet n° FP16566 available on our website.

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