

BÜFA®-BOND 001

BÜFA®-Bond 001 Adhesive

Prod. No. 6600001

Product description

BÜFA®-Bond 001 is a 2-component bonding paste filled in a cylindrical, 380 ml plastic cartridge. The resin/peroxide mixing ratio is 10 to 1. BÜFA®-Bond 001 is a fibre reinforced bonding paste based on special, unsaturated polyester resin in paste form. The paste contains styrene and a peroxide indicator that changes the colour from mint green to white.

Applications

BÜFA®-Bond 001 can be used for bonding cured GRP laminates with GRP laminates, iron and ferrous steel, e.g. ST 37. The suitability of BÜFA®-Bond 001 on other substrates must be tested in advance. In any case, the substrate must be prepared. The surface of the substrate must be generally free of grease, oil and dust. When bonding metal, OLDOPAL Metal Adhesion Promoter 742-0079 must be used for priming after the substrate has been prepared and cleaned. BÜFA®-Bond 001 can also be used as an alternative to UP bonding paste for structural bonding as well as for quick fixation. Levelling (nips/gaps should not exceed 8 mm) and application on thin laminates (print effect in the laminate through a high peak exotherm) should be carried out carefully.

Specifications / technical data

Property	Test method	Value	Unit
Density at 20 °C		approx. 1,25	g/ml
Viscosity at 20 °C Brookfield RV/DV-II Spl 7 rpm 5	ISO 2555	500 000 - 700 000	mPas
Styrene content		28 - 31	%
Flash point	DIN 53 213	+ 32	°C

Curing

Reactivity values:

BÜFA method in accordance with DIN 16 945 6.2.2.1

(Bonding paste with hardener – 100 g bonding paste metered from the cartridge into a cup)

20 - 30 °C	8 - 14 min
20 °C - Tmax	11 - 18 min
Tmax	140 - 160 °C

Gel time at 20 °C in a 100 g cup

Gel time: 8 - 14 min

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Further orientational data on curing:

Bonding of GRP laminate, glue line 4.5 mm thick

(Bonding past with hardener – metered from the cartridge)

20 - 30 °C	8 - 14 min
20 °C - Tmax	11 - 18 min
Tmax	65 - 75 °C

Gel time at 20 °C in the 4.5 mm thick glue line

Gel time: 8 - 14 min

Fixation of adherends

- Working time:	7 - 9 min
- Fixation time:	20 - 25 min

Attention! The information given above exclusively to the use of the static mixer named and the temperatures given. Lower or higher working temperatures may yield different results.

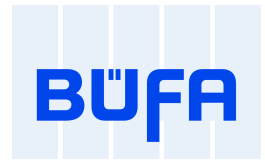
Directions for use

BÜFA®-Bond 001 is a polyester adhesive that can be metered with the aid of a 2-component cartridge. The 380 ml cartridges come with a static mixer and an opener for the cartridges. Metering is carried out with a hand metering gun or a pneumatic metering gun through the attached static mixer which ensures that the peroxide is homogenously mixed with the bonding paste. Please note that the correct mixing ratio is not guaranteed at the beginning of the metering process (approx. 15 - 20 ml).

Note:

Because of the fibre reinforcement, viscosity may increase over time. A layer maximum 8 mm thick should be used for bonding because the bonding paste is highly reactive and thicker layers could lead in the curing process to a high maximum temperature.

Note: The Information given above is based on our current state of knowledge and experience. In view of the many factors that may influence working conditions and the application of our products, the user is not relieved from carrying out his own tests and experiments. No legally binding warranty of certain properties or suitability for a particular purpose can be derived from this information. It is the responsibility of the receiver or user of our products to observe proprietary rights as well as existing laws and regulations. The latest version of the corresponding EU Safety Data Sheet must also be observed.



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Hohe Looge 2-8
26180 Rastede
GERMANY
Phone +49 4402 975-0
Fax +49 4402 975-300
compositesystems@buefa.de
www.buefa.de
www.buefacompositesystems.com

A member of the BÜFA-Group