TECHNICAL DATA SHEET

G6 – BONDING PASTE FOR ASSEMBLY

Bonding paste based on unsaturated polyester resins reinforced with special mineral microfibers. It has good mechanical, thermal and chemical resistance and excellent adhesion to the substrate.
In the composite sector, it represents a practical and economical solution for the assembly of the model skeleton, the joining of the side parts, the gluing of the inserts, the fixing of furniture and systems.
It can be used with paste or liquid hardener.

SUPPORTS

Recommended: polyester and vinylester fiberglass, wood.

GENERAL INSTRUCTIONS FOR USE

Apply on well cleaned sanded surfaces;
Make sure the substrate is free of dust, fibres, dirt and surface condensation.
Carefully mix the bonding paste with 1,0 - 3,0% of hardener in paste (benzoyl peroxide) or with 1,0 - 2,0% of liquid hardener (methylethyl ketone peroxide), bearing in mind that the amount of hardener required depends on the temperature of use and the processing times required.
The recommended temperature range is between 12 and 30°C.
It must be applied manually with a spatula after careful mixing of the hardener.
In its original packaging, the product can be used for **12 months** if stored indoor away from direct sunlight, at temperatures not exceeding 20°C.

TYPICAL SPECIFICATIONS OF THE LIQUID PRODUCT

Tests made at 23°C	Value	Unit	Method
Color	Grey	-	IMIA-01
Density	1,70 ± 0,05	Kg/l	IMIA-02
Solid content	85 ± 2	%	IMIA-03
Reactivity (100g product + 1,50g BPO)	5 ± 1	min	IMIA-15
Reactivity (100g product + 1,50g CT21/ MEKP 50%)	30 ± 5	min	IMIA-15

TYPICAL CHARACTERISTICS OF THE CURED PRODUCT (*)

Tests made at 23°C	Value	Unit	Method
Superficial hardness	80 ± 5	Shore D	IMIA-29
Flexural Modulus **Tensile Modulus**	3782 8815	MPa	ISO 178 ISO 527
Thermo-mechanical resistance: **HDT** **Tg**	 54 ± 5 64 ± 5	 °C °C	 IMIA-50 ASTM D3418
(*) Curing cycle: 24 hours at 23°C and 3 hours at 80°C			

The information and data contained in this technical sheet are based on the measurements and experience gained; in good faith, they are made available to the customer who is responsible for the application verification and the definition of suitability for the intended use.
INTEC assumes no responsibility for the results obtained in the specific application made by the user.

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