

P 470 / DUROBOND 470

CORE BONDING PASTE

PER470 is a low density bonding paste for adhering foam core materials to various skins. Durobond 470 is a tough filled paste based on an unsaturated polyester resin, dissolved in styrene.

The most important features are :

- Good gap filling properties
- Medium cure gel time
- Ideal for Vacuum Bagging PVC & Balsa
- Good adhesive strength
- Geltime can be varied to suit application
- Coloured white for easy identification

Typical gel times of Methyl Ethyl Ketone Peroxide (MEKP) at 25 deg C are :

- 1% MEKP 25 minutes
- 2% MEKP 20 minutes

Durobond 470 can be applied by a notched trowel or squeegee. Adhesion can be improved by vacuum assistment. Apply on both sides. It is better to hot coat the core with a polyester resin first.

Coverage is dependant upon surface of foam and skin. In order to calculate the coverage use a factor of 750 gm to 1.2 kg per m². This will give a thickness of approx. 1-2 mm.

Note : Agitate before use.

TECHNCAL DATA

Appearance	White Paste
Tensile Strength	12.7 MPa
Tensile Modulus	900 MPa
Barcol Hardness	15 - 20
HDT	45 deg C
Flash Point	31 deg C
Shrinkage	2%

Storage

Six months from date of manufacture if kept in closed opaque containers at 20 - 25 Deg C.