

PHD Adhesive Resin-DP

Technical Data Sheet

Adhesive Resin DP

PRODUCT DESCRIPTION

Adhesive resin DP is an adhesive paste based on a pre-accelerated unsaturated isophthalic acid polyester resin.

CHARACTERISTICS AND INTENDED USE

- Highly thixotropic;
- Fast curing and long pot life;
- Excellent filling power;
- Excellent elasticity;
- Suitable for bonding e.g. balsa wood, PU foam or PVC foam on the glass fibre side of polyester laminates;
- Suitable for bonding polyester laminates: both glass fibre side to glass fibre side and gelcoat side to gel coat side;
- Suitable for machine processing.

SHADE

Colorless

BASIC DATA (AT 20 °C AND 50% REL. L.F.)

Density	approx. 1.3 g/cm ³ , depending on colour
Solids	approx. 100% (Volumen)
Recommended layer thickness	depending on the application
Fully cured after	3 hours
Can be repainted according to	min. 24 hours, see additional information max. Unlimited, if sanded, clean and grease-free
H.D.T. (DIN 53458)	70°C
Shelf life	not mixed, in closed original containers at cool, but frost-free, dry storage for at least 6 months
Flash point	Base 31°C (DIN53213) Härter 52°C (MEKP)

YIELD

Depending on the application approx. 0.8 – 3.3 m²/kg

Practical yield depends on various factors, such as the shape of the object, the condition and profile of the surface, the method of application, weather conditions and expert application.

SUITABLE SUBSTRATES, PRE-TREATMENT AND TEMPERATURE

Surfaces to be bonded

Dry and free of grease, impurities, dirt and loose particles, free from paraffinic resins or coatings, sanded with sandpaper P120, see additional information.

During application and curing, the temperature must be at least 15°C. The

The temperature of the substrate must be at least 3°C above the dew point.

PROCESSING INSTRUCTIONS

Stir the individual components well before use. Add the hardener to the base and stir in carefully.

Mixing ratio 100.0 Base: 2.0 to 3.0 hardener (weight parts)

Do not mix more than can be applied within the pot life.

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Induction time	not applicable
Pot life	45 minutes at 25°C 90 minutes at 20°C 120 minutes at 15°C

Application with	Spatula
Dilution Type	not applicable
% dilution	not applicable
Spray opening	not applicable
Cleaning	Ethyl acetate or acetone

ADDITIONAL INFORMATION

Application

The adhesive surfaces must be dust-free and must not be treated with a paraffinic resin or a (synthetic) coating.

Clean old laminates with acetone and then sand with sandpaper P120. Clean paraffin-containing surfaces with acetone and sand with sandpaper P60 – P80.

Pre-treatment by grinding increases the adhesion strength.

Mechanical properties

Feature	Value	Unit	Test Method
• Tensile strength	10	MPa	ISO 527-3
• Elongation at break	21	%	ISO 527-3
• HDT	38	°C	ISO 75-2
• Flexural strength	16	MPa	ISO 178
• Modulus of elasticity	1528	MPa	ISO 178

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