

Technical Data Sheet

DD Klebeharz-DF1

PRODUCT DESCRIPTION

DD Adhesive Resin DF1 is a fiber-reinforced 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;
- Reinforced with fiberglass;
- Minimal shrinkage;
- Suitable for bonding the fiberglass side of polyester laminates

SHADE

Colorless

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

Density:	approx. 1.2 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 ground, clean and grease-free
H.D.T. (DIN 53458):	70 °C
Storage potential:	not mixed, in closed original containers with cool, but frost-free, dry storage for at least 6 months
Flash Point:	Base 31 °C (DIN53213) Temperer 52 °C (MEKP-Temperer DD-MP1)

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 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.

Induction time not applicable

Pot life: 45 minutes at 25°C
90 minutes at 20°C
120 minutes at 15°C

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Application with:

	Spatula
Dilution Type	not applicable
% dilution	not applicable
Spray opening	not applicable
Cleaning	Acetone or ethyl acetate

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	oC	ISO 75-2
• Flexural strength	16	MPa	ISO 178
• Modulus of elasticity	1528	MPa	ISO 178

Hardener:

As a hardener for DD Adhesive Resin DF1 we recommend MEKP Hardener DD-MP1. When mixing the binder with the hardener, an exothermic reaction leads to strong heating. Never mix more than you can apply within the pot life.

SAFETY INFORMATION

For more detailed information, see the product safety information sheet.

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