



P24 POLIBONDER SOFT



GENERAL PURPOSE BONDER

Description

Bonder based on unsaturated polyester resins.

Main Features

- Excellent spatula application.
- Shrinkage near to zero.

Recommended uses

P24 is a bonder formulate for gluing FRP parts and other core materials, where use of medium-light products is advisable. P24 can be used for :

- Gluing core materials (for the construction of structural sandwiches).



Hardeners

P24 is a two-component bonder which must be accurately mixed with a specific liquid hardener C08 (Cyclohexanone peroxide).

Catalysis ratio

P24 should be mixed with a percentage of hardener that takes into account the room temperature, never less than 5°C, in which the process is carried out.

Catalysis and Temperature	C08 Liquid Hardener
between 5 and 10° C	3.0%
between 10 and 20 °C	2.0%
over 20 °C	1.0%

Properties

When the product is applied, it will assume mechanical properties that depend on the temperature at which the process has been carried out. The characteristics measured at 20°C are reported in the following table.

Bonder P24 with 2% Liquid hardener C08		
Properties	u.m.	Value
Colour	-	viracolor
Gel time at 20°C	min	40 ± 10
Specific weight	kg/L	1.40 ± 0.05
Linear Shrinkage ¹	%	0.35
Shore hardness D	D	70
Tg (after 2 h at 80°C) ²	°C	78
HDT (after 2 h at 80°C) ³	°C	73

Packaging

P24 Bonder is supplied in :

- pails containing 25 kg net.

Storage

Store the product in the original sealed packaging at a temperature of less than 20°C, well away from heat sources and sunlight. In these conditions, the product will remain stable for 1 year from the date of production.

¹ After 2 h at 80°C; ASTM D2566

² DSC test at 20°C/min in N₂, ISO 11357

³ DMA test ASTM D648-01