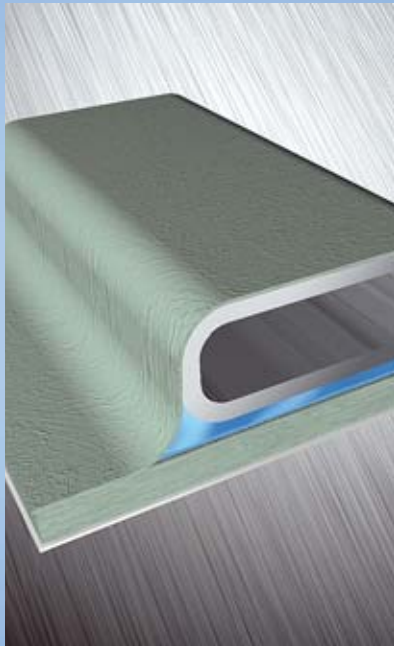
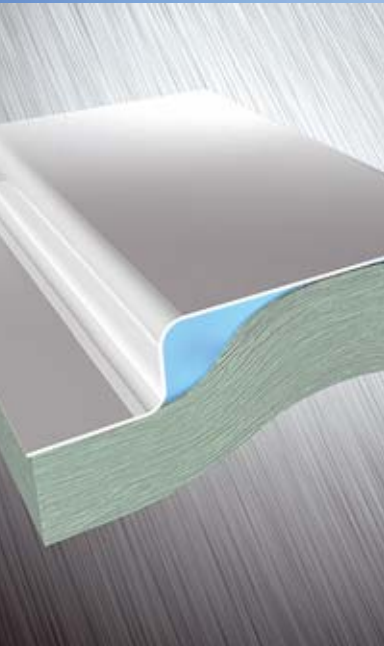


# BÜFA®-Bonding Pastes

Quality... that stands for the extensive BÜFA-Assortment of bonding pastes. Filled or unfilled, fibre reinforced or without reinforcement, with low density for bonding sandwich constructions, low-shrink formulation, flexible or even pigmented bonding pastes and numerous other variations are available to our customers.



## Innovative specialities for the composite industry



**Gelcoats**  
High gloss surface

**Bonding pastes**  
Powerful connections

**Fire retardant systems**  
Optimal safety

**Pigment pastes**  
Unlimited colours

**Special products**  
Process solutions



### Optimal laminate construction

- 740-0181**
- THP base
  - fibre reinforced
  - low viscosity, low shrink
  - liquid, mat levelling compound
  - crack bridging
  - very good heat resistance
  - no printing on the surface
  - low exothermic character

- 740-0182**
- THP base
  - fibre reinforced
  - high viscosity, low shrink
  - liquid, mat levelling compound
  - crack bridging

#### Applications:

- marine
- rail vehicles
- automotive

### Bonding of metal and wood

- 740-0139-family\*\*\*\***
- THP base
  - fibre reinforced
  - tough-elastic
  - very high elongation at break
  - good impact and fatigue resistance
  - good bonding under peel stress

#### Applications:

- rail vehicles
- automotive

### Special Products

- 740-0240**
- OP base
  - fibre reinforced
  - elasticised
  - flame retarding
  - halogen-free
  - good working properties
  - also available in an unreinforced version

- 740-0410**
- IP-NPG base
  - slightly elasticised
  - very good resistance to chemicals and hydrolysis
  - good adhesion to PVC

#### Applications:

- marine
- swimming pool
- rail vehicles

Edition: March 2010

### Our recommendations for you:

#### Working parameters

- use at least 1.5 % MEKP
- working temperature between 18-24 °C
- the surface should be clean and free of grease and dust
- low resin surface in bonding area
- sand the substrate before bonding
- prime wood and metals

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A company of BÜFA and DSM Composite Resins

#### Your advantages

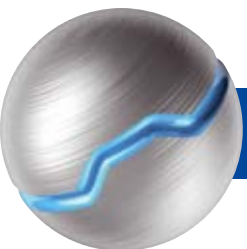
- high-strength bonding of different materials
- high fatigue strength, impact resistance and elongation at break
- promotes processing (levelling, round edges)
- optimal surface quality through low-shrink systems
- reduction of weight, vibrations and noise

The information given above is based on our current state of knowledge and experience. In view of the many factors that may influence working conditions and the application of our products, the user is not relieved from carrying out his own tests and experiments. Not legally binding warranty of certain properties or suitability for a particular purpose can be derived from this information. It is the responsibility of the receiver or user of the products to observe proprietary rights as well as existing laws and regulations. The latest version of the corresponding EU safety data sheet must also be observed.

You'll find technical data sheets and further information at [www.buefagelcoatplus.com](http://www.buefagelcoatplus.com).

## BÜFA®-Bonding Pastes

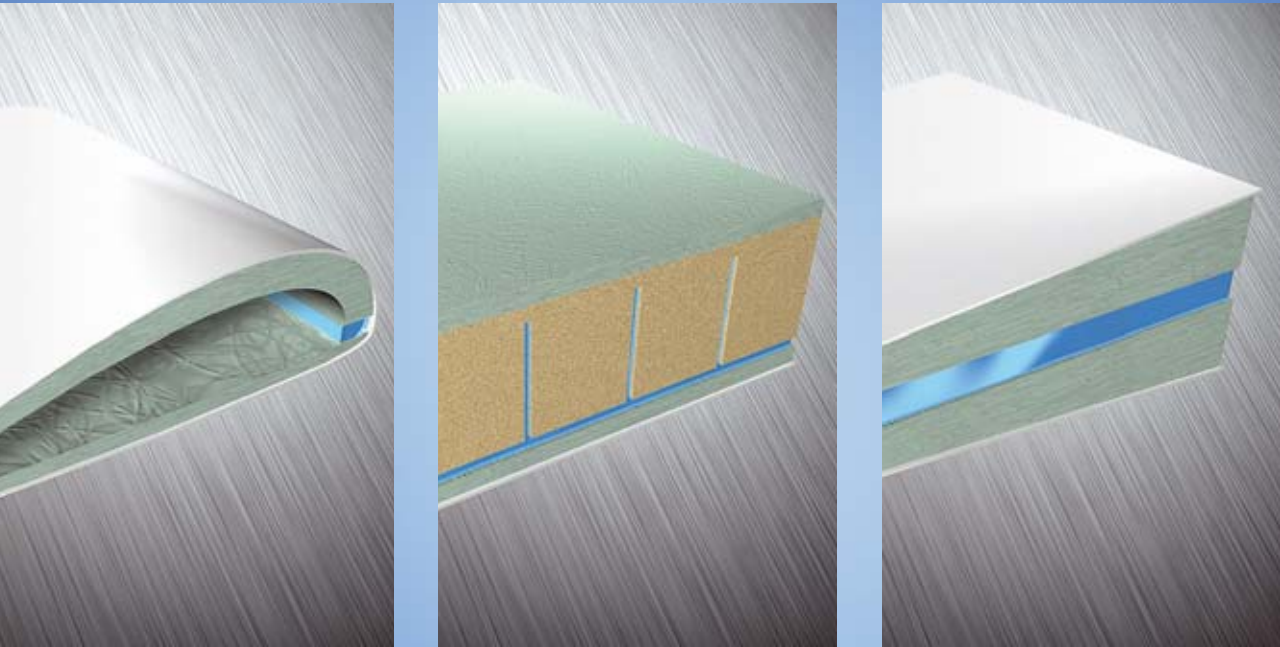
Powerful connections



**Bonding pastes**

BÜFA®-Bonding Pastes

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High-strength bonding

- 740-0110 - family\*\*
- VE base
  - very high fatigue strength
  - Elasticity
  - high static strength
  - excellent resistance to chemicals and hydrolysis
  - cures with MEKP without developing gas
  - machine application
  - GL certificate

- 740-0123
- IP base
  - high fatigue strength
  - good resistance to hydroloysis
  - contains a peroxide indicator
  - machine application

- Applications:
- wind energy
  - marine

Sandwich construction

- 740-0072
- OP base
  - low density
  - good thixotropy
  - excellent flow
  - very good adhesion to core materials

- 740-0590
- IP base
  - fibre reinforced
  - low density
  - very good mechanical properties
  - very high thixotropy
  - also for structural joinings

- Applications:
- marine
  - rail vehicles
  - automotive

Structural joining

- 740-0250 - family\*\*\*
- OP base
  - many variations (geltimes, viscosity, fibre reinforcement
  - fatigue resistant
  - semi-flexible
  - high thixotropy but low viscosity
  - good adhesion to different surfaces
  - contains a peroxide indicator

- 740-0588 - family\*
- THP base
  - fibre reinforced
  - high impact resistance
  - good heat resistance
  - machine application

- Applications:
- marine
  - rail vehicles
  - automotive

Our recommended standard solutions for bonding:

									Marine							Rail vehicles		Automotive			Other		
Adhesive	Description	Resin base	Reinforcement	Peroxide indicator	Colour	Viscosity (mPas)	Gel time (min)	Curing time (min)	Repair	Deck+hull	Interior walls	Sandwich construction	Inliner + hull	Deck+insider roofing	Levelling	Sandwich construction	Structural bonding	Sandwich construction	Structural bonding	Levelling	Mould construction	Rotor blades	Swimming pools
740-0001	Repair filler formulated for brushing	THP			white	2.250.000	15	32	✓												✓		
740-0002	Repair filler formulated for spraying	THP			grey	23.000	8	16	✓												✓		
740-0068	Very fast repair filler, available with hardener tube	THP			grey	-	6	9	✓												✓		
740-0072	Sandwich adhesive with very low density	OP			blue	220.000	30	60				✓				✓		✓					
740-0110**	Bonding paste with excellent mechanical and chemical properties	VE			natural	1.100.000	60	85	✓	✓	✓		✓	✓			✓		✓		✓	✓	
740-0123	Very good structural bonding paste with a wide range of use	IP		✓	natural	500.000	23	35		✓	✓		✓	✓					✓				
740-0139****	Bonding paste for bonding metal and wood, elastic	THP	✓		yellow	580.000	21	33			✓						✓		✓				
740-0141****	Bonding paste for bonding metal and wood, elastic	THP	✓		white	500.000	20	34			✓						✓		✓				
740-0181	Liquid laminate with low exothermic character, low viscosity	THP	✓		green	140.000	27	40							✓					✓			
740-0182	Liquid laminate with higher exothermic character, high viscosity	THP	✓		violet	550.000	18	27							✓					✓			
740-0185*	Bonding paste with very good mechanical properties, good thixotropy	THP	✓		green	600.000	25	35			✓		✓	✓									
740-0240	Bonding paste with a fire protection effect, halogen-free	OP	✓		white	500.000	22	29								✓	✓						
740-0241	Bonding paste with a fire protection effect, halogen-free	OP			grey-white	325.000	16	26								✓	✓						
740-0250***	Bonding paste for versatile applications	OP		✓	grey	850.000	17	36			✓			✓					✓				
740-0251***	Bonding paste for versatile applications	OP	✓	✓	grey	850.000	17	36			✓		✓	✓					✓				
740-0410	Chemically resistant bonding paste, good adhesion to PVC	IP/NPG			natural	500.000	24	42															✓
740-0588*	Bonding paste with very good mechanical properties, good thixotropy	THP	✓		natural	600.000	10	18			✓						✓		✓				
740-0590	Sandwich adhesive with low density	IP	✓		opaque	680.000	7	15				✓				✓		✓					
740-0591	Strong bonding paste with a wide range of applications	IP	✓		natural	600.000	13	22		✓									✓				
740-4410***	Bonding paste for versatile applications, very short gel times	OP		✓	white	625.000	10	21			✓			✓					✓				
740-4425***	Bonding paste for versatile applications, medium gel times	OP		✓	white	625.000	25	43			✓			✓					✓				
740-4426***	Bonding paste for versatile applications, low viscosity	OP		✓	white	225.000	25	43			✓		(✓)	✓					✓				
740-4470***	Bonding paste for versatile applications, very long gel times	OP		✓	white	625.000	70	105			✓			✓					✓				

The recommendations presented above are a few of the possibilities for using bonding pastes. For more detailed information, please get in touch with our Technical Service Department. We'll be glad to help.  
Abbreviations for base resins: VE – vinyl ester, OP – orthophthalic acid, IP – isophthalic acid, THP – tetrahydrophthalic acid, NPG – neopentyl glycol  
(✓)=Please get in touch with our Technical Service Department.