

P 480 GENERAL PURPOSE BONDING PASTE

PER -480 is a medium density bonding paste for adhering foam core materials to various skins. Durobond 480 is a tough filled paste based on an unsaturated polyester resin, dissolved in styrene. Ideal for bonding PU foam structures to GRP skins such as refrigerated truck panels.

The most important features are :

- Good gap filling properties
- Slow gel time
- Ideal for Vacuum Bagging
- 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 35 minutes
- 2% MEKP 45 minutes

Durobond 480 can be applied by a notched trowel or squeegee or roller. Adhesion can be improved by vacuum assistance. (See article) 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. 1mm.

Note : Agitate before use.

TECHNICAL DATA

Appearance	White Paste
Tensile Strength	12.7 MPa
Tensile Modulus	900 MPa
Barcol Hardness	30
HDT	55 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.