

## DESCRIPTION

Ijmobond T is a bonding paste based on a pre-accelerated isophthalic unsaturated polyester resin.

## PRINCIPAL CHARACTERISTICS

- Very thixotropic;
- Rapid curing;
- Very low shrinkage;
- Semi-flexible;
- Adhesive suitable for bonding balsa wood, polyurethane foam or PVC foam to glass fibre reinforced polyester laminates;
- Adhesive suitable for bonding glass fibre reinforced polyester laminates, glass fibre side to glass fibre side or gelcoat side to gelcoat side;
- Suitable for application by heavy duty spray equipment.

## COLOURS AND GLOSS

Transparent

## BASIS PROPERTIES (AT 20 °C AND 50% R.H.)

Density	: approx. 1,3 g/cm <sup>3</sup>
Solid content	: approx. 100 % (volume)
Recommended d.f.t.	: depending on application
Full cure after	: 3 hours
Recoating interval	: min. 24 hours max. no limit, provided free from any contamination
H.D.T. (DIN53458)	: approx. 70 °C
Shelf life	: separate components, stored cool and dry in original packaging, at least 6 months
Flashpoint (DIN53213)	: base component 34 °C hardener component 52 °C (MEK peroxide)

## SPREADING RATE

Depending on application : approx 0,8 – 3,3 m<sup>2</sup>/kg (1,0 – 4,0 m<sup>2</sup>/l)  
The practical spreading rate depends on a number of variables, such as: shape and size of object to be painted, the condition and profile of the substrate, the method of application, environmental conditions and skill of labour.

## SUBSTRATE CONDITION AND TEMPERATURE

All surfaces : in good condition, clean and dry, free from any contamination, loose particles and other foreign matter, grit sanded with P120, see additional information.

During application and curing a minimum temperature of 15 °C is allowed. The temperature of the substrate should be minimum 3 °C above dew point.

## INSTRUCTIONS FOR USE

Before use mix base and hardener thoroughly.

Mixing ratio : 100 base : 2 hardener (parts by weight)  
Do not prepare more material than can be applied within the potlife of the mixture.

Induction time : None  
Pot life : 30 minutes at 25 °C  
45 minutes at 20 °C  
60 minutes at 15 °C

Application with :

	Spatula, putty knife	Airless spray
Type of thinner	n.a.	
% of thinner	n.a.	
Nozzle orifice	n.a.	
Nozzle pressure	n.a.	
Cleaning with	Double Coat Degreaser, Ethyl acetate or Acetone	

Please consult our technical department for information on application by airless spray of IJmobond T.

**ADDITIONAL INFORMATION**

- Application of IJmobond T
  - The surfaces should be free from any contamination and should not be coated with paraffin containing resins or topcoats. All organic coating such as epoxy, polyurethane or alkyd paints should be removed completely.
  - Aged or weathered laminates should preferably be cleaned with Double Coat Degreaser and grit sanded with P120. Paraffin containing surfaces should be cleaned with acetone or Double Coat Degreaser and grit sanded with P60-80.
  - A pre-treatment by sanding will improve adhesive strength.

• Mechanical properties

Property	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

- Hardener
 

The hardener for IJmobond T contains peroxides. After mixing the base component with the hardener the temperature of the mixture will increase rapidly due to an exothermic reaction. Do not prepare more material than can be applied within the pot life of the mixture.

**SAFETY INFORMATION**

This product contains solvents. Take all necessary safety measurements when using this product and arrange proper ventilation and safety equipment for all personnel. For details on safety and health see our material safety data sheet.

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203-99999

*Disclaimer*

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