



## BÜFA® Bonding Paste 0591

UP/ISO Bonding Paste, fibre reinforced

Prod. No. 740-0591

**Product description** BÜFA® Bonding Paste 0591 is a fibre reinforced bonding paste in a surface-filling consistency. It is pre-accelerated and based on unsaturated isophthalic acid polyester resin dissolved in styrene.

**Applications** BÜFA® Bonding Paste 0591 is used as a fibre reinforced, standard bonding paste for bonding cured GR-UP laminates as long as they are not subjected to extreme loads. The paste is worked by hand.

Specifications / technical data	Property	Test method	Value	Unit
	Density at 20 °C	DIN 53 217/2	approx. 1.25	g/ml
	Viscosity at 20 °C Brookfield RV/DV-II spl 7 rpm 5	ISO 2555	500,000 - 700,000	mPas
	Styrene content		30 - 33	%
	Flash point	DIN 53 213	+ 32	°C

**Curing** **Reactivity:**  
**BÜFA methode in accordance with DIN 16 945 6.2.2.1**  
(100 g Bonding Paste + 2 ml Butanox M-50)

20 - 30 °C	10 - 16 min
20 °C - Tmax	18 - 26 min
Tmax	140 - 170 °C

**Gel time at 20 °C in a 100 g cup with 2 ml Butanox M-50:** 10 - 16 min

**Attention!**

The information given above refers exclusively to the use of the catalysts named and the quantities specified. The use of different products or differing quantities may yield different results.

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<b>Properties of the cured base resin</b>	<b>Properties*</b>	<b>Test method</b>	<b>Value</b>
	<b>Tensile strength</b>	ISO 527-2	90 MPa
	<b>Tensile E modulus</b>	ISO 527-2	3,700 MPa
	<b>Elongation at break</b>	ISO 527-2	4.6 %
	<b>Heat distortion temperature (HDT)</b>	ISO 75-A	93 °C

\* Measured in a standard laboratory atmosphere on cast test specimens made of pure resin that were cured for 24 hours at room temperature and conditioned a further 24 hours at + 80 °C.

## Directions for use

When the bonding paste is mixed with the hardener by hand, the mixture should be poured into a second container after it has been intensively stirred. This ensures homogenous distribution of the peroxide.

## Note:

Viscosity may increase over time due to the fibre reinforcement.

## Storage/Handling

This product must be stored cool in closed containers, protected from sunlight. Shelf-life is at least 3 months in unopened, original containers stored up to a temperature of 20 °C. Gel and curing times may change with increasing duration of storage.

Note: 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. No 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 our 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.

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