

# Technical Datasheet



## ENGUARD™ BP 725 AC Marine Bonding Paste

ENGUARD BP 725 AC is a pre-accelerated white bonding paste based on unsaturated polyester resin, with good mechanical properties. ENGUARD BP 725 AC has good flexibility. It has a low thixotropy level and long geltime with controlled shrinkage property.

### Typical properties of bonding paste

Property at 23 °C	Value	Unit	Method
Density	1,3	kg/dm <sup>3</sup>	ISO 2811
Viscosity, Brookfield RV7, 10 rpm	300 000	mPas	
Geltime, 2% MEKP-50	35	min	D 006
Hardening time	5	hours	QC 36
Complete hardening	72	hours	
Shrinkage, linear	1,6	%	ASTMD2566-7

### Typical properties of cured bonding paste

Property	Value	Unit	Method
Tensile strength	16	MPa	ASTM C297
Shear strength	17	MPa	R028
Compression strength (with 5 mm joint)	100	MPa	R029
Hardness	33	Barcol	ASTM D2583

### Application and use

ENGUARD BP 725 AC bonding paste is designed for use in the marine industry. ENGUARD BP 725 AC is used for adhesion of polyester laminates and/or adhesion of polyester laminates to balsa, PVC or PU foam in sandwich structures.

Recommended thickness of bonding paste is 0,3-3 mm and bonding paste must not start gelling before parts are attached together. Mechanical forces on bonded parts must not be used within three days from application.

### Certificates and approvals

The manufacturing, quality control and distribution of products, by Ashland Performance Materials, are complying with one or more of the following programs or standards: Responsible Care, ISO 9001, ISO 14001 and OHSAS 18001 by .

### Handling and storage

It is highly recommended that all materials and tools are stored at stable temperature under 25 C preferably indoors and away from direct sunlight. Surfaces to be bonded must be cleaned eg. with acetone or by grinding. A high quality methyl ethyl ketone peroxide (MEKP) should be used between 1-2%. The bonding paste with catalyst must be stirred well before taken in use.



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### ENGUARD™ BP 725 AC Marine Bonding Paste

Shelf life of ENGUARD BP 725 AC is 5 months.

Prolonged storage or storage outside of recommended conditions can influence liquid bonding paste properties like viscosity and gel time and it is recommended to test these properties before starting application.

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