

Technical Datasheet



ENGUARD™ BP 75 ARF Multi Purpose Bonding Paste with Fibres

ENGUARD BP 75 ARF is a pre-accelerated bonding paste based on unsaturated polyester resin, with good mechanical properties. ENGUARD BP 75 ARF contains glass fibres. It has a high thixotropy level which helps to avoid sagging. ENGUARD BP 75 ARF has a short gel time and mixing and application is easy due to catalyst indicator.

Typical properties of bonding paste

Property at 23 °C	Value	Unit	Method
Density	1,2	kg/dm ³	ISO 2811
Geltime, 2% MEKP-50	10	min	D 006
Hardening time, 2% MEKP-50	3	hours	QC 36
Complete hardening	72	hours	
Shrinkage, linear	2	%	ASTMD2566-7

Typical properties of cured bonding paste

Property	Value	Unit	Method
Tensile strength	26	MPa	ASTM C297
Shear strength	19	MPa	R 028
Compression strength (5 mm joint)	125	MPa	R 029
Hardness	30	Barcol	ASTM D2583

Application and use

ENGUARD BP 75 ARF bonding paste is suitable for use in the marine, building/sanitary, tanks/silos and transport/panel industry. ENGUARD BP 75 ARF is used for adhesion of polyester laminates and/or adhesion of polyester laminates to balsa, PVC or PU foam in sandwich structures.

The thixotropic behaviour of the bonding paste improves levelling and reinforcement wet-out properties. In other words, ENGUARD TH 75 ARF bonding paste is easy to apply.

Recommended thickness of bonding paste is 3-5 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.

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



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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.

Shelf life of ENGUARD BP 75 ARF 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.

Notice

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