

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 ³	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.

Remark: Temperature of workshop, raw materials and tools should be 18-25°C and relative humidity below 70%. 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 use.

Certificates and approvals

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



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Handling and storage Shelf life of bonding paste is 5 months from the day of manufacture and it is highly recommended that all material is stored at stable temperature under 25 °C preferably indoors and away from direct sunlight.

Notice All information presented herein is believed to be accurate and reliable, and is solely for the user's consideration, investigation and verification. The information is not to be taken as an express or implied representation or warranty for which Ashland assumes legal responsibility. Any warranties, including warranties of merchantability or non-infringement of intellectual property rights of third parties, are herewith expressly excluded.

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Ashland requests that the user reads, understands and complies with the information contained herein and the current Material Safety Data Sheet.

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