

2011: Bonds Stronger and Keeps its Cool

Better resin availability and lower exotherm means a superior bond with less shrinkage and cracking



All medium weight marine bonding compounds are *not* created equal. That is because many of today's professional bonding products are "resin-starved", due to excessive quantities of general filler packing used to regulate viscosity. This may ultimately jeopardize the overall strength and long term durability of the bond, which could inevitably threaten the quality of your project.

How We Created the Medium Weight Compound

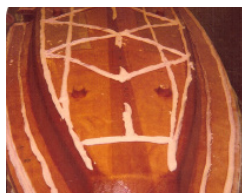
Our early experience in the boat building industry taught us that to get the perfect bond—especially between fiberglass parts—you sometimes had to create the perfect compound...yourself. From this spirit of innovation, Arjay products like **Medium Weight Compound** were perfected over the years to perform the best:

Performance Benefits

- Maximum premium resin availability for adhesion
- Low exotherm means less shrinkage & finish work
- Clings to almost any surface, even vertical ones
- Easily pumped through major dispensing equipment
- Provides excellent bond for most general applications



"Stays put"2 on just about any surface



Preparing to mate a 38' headliner to deck



Medium weight used in Filling Strakes

ProTips & Other Resources at ArjayTech.com

- 2011 TDS (PDF) Available for download any time on our website

TECHNICAL DATA SHEET

2011 MEDIUM WEIGHT
POLYESTER BONDING COMPOUND

RECOMMENDED FOR

General Bonding	General Filling
Liner to Deck	Filling Strakes

WORKING & TIMES (In Minutes)

Gel Time	Interval	Total	Peak Exo
45	41	86	180° F

TYPICAL PHYSICAL PROPERTIES @75°F (24°C)

Color	White
Odor	Styrene
Texture	Smooth
Weight	8.6 lbs/gallon
Stability	5 months, uncured

VISCOSITY

RPM	μ Min	μ Max
2	900,000	1,300,000
20	90,000	180,000

TYPICAL CURED PROPERTIES @75°F (24°C)

Test	Average	Deviation
Tensile Elongation, %	2.28	1.14
Tensile Strength, PSI	1,490	23.5
Compressive Strength, PSI	3,330	12.4
Lap Shear, PSI	1,140	50
Heat Deflection, °F	130	2.5
Linear Shrinkage, %	< 1	
Shore D Hardness	74-80	

PACKAGING & AVAILABILITY

Pails
5 Gal./19 L



ITEM# 2011

Drums
55 Gal./ 189 L



ITEM# 2012

Storage & Handling

STORAGE

To ensure maximum stability and maintain optimum properties, bonding compounds should be stored in the original closed container at temperatures below 24 C/75 F and away from heat ignition sources and sunlight. The product must be warmed up to 18 C/ 65 F prior to use so that timely curing and optimum processing can be maintained.

All storage space and containers should conform to local fire and building codes. The bonding compounds should be stored separately and away from oxidizing materials, peroxides and metal salts. Keep containers closed when not in use. Employ best practices of using first-in, first-out stock rotation.

SHELF LIFE

Shelf life is 3 months from date of shipment. Minimum shelf life performance implies the life of the product in the original, unopened container. For additional information on storage and handling, please contact your sales representative or authorized distributor.

STANDARD PACKAGING

Standard product packages include 55-gallon metal drums and 5 gallon plastic pails.

SAFETY

Read and understand the material safety data sheet before working with the product. Obtain a copy of the material safety data sheet on this product from the Arjay website, or contact your sales representative or authorized distributors.

The bonding compounds contain volatile components that are highly flammable and should be handled with care and used in well ventilated area. The product must be stored in a cool place away from source of heat, open flames or sparks. Keep containers closed when not in use. Prevent contact with skin and eyes. In case of skin contact, wash with soap and water. In case of eye contact flush with water for 15 minutes and seek immediate medical care.

DISPENSING EQUIPMENT

The pumpable versions of the bonding compounds are supplied in drums, to be dispensed with internal metered mix equipment. Most commonly used dispensing equipment is supplied by Magnum Venus Products (www.mvpind.com). GS Manufacturing (www.gsmfg.com) and Glass-Craft (www.glascraft.com) also offer similar dispensing systems.

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California Proposition 65 Warning: This product contains the following chemicals known to the State of California to cause cancer: Styrene Oxide, Aniline. Styrene, in the presence of air and high temperature or the prolonged exposure to a styrene/air mixture to sunlight can react to form styrene oxide.