

Medium Weight Bonding Compound

A premium resin-based compound engineered for superior bonding performance and ease of application in composite part assembly.



ARJAY formulates its Medium Weight Bonding Compound with premium resins and engineered fillers designed to provide exceptional performance when dispensed through drum pumping equipment. When bonding hulls, decks and liners no significant loss in volume is expected with pressures typically encountered in modern dispensing units - helping ensure economic benefits. Arjay's industry recognized product quality guarantees consistent performance.

Performance Benefits

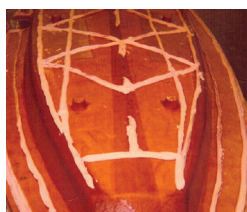
- Machine dispensable
- Exceptional crush resistance
- Formulated with premium resins and fillers
- Low shrinkage and exotherm
- Low styrene content

Uses

- Hull and Deck
- General fiberglass bonding
- Cavity filling
- Hull Liners



"Stays put" 2 on just about any surface



Preparing to mate a 38' headliner to deck



Medium weight used in Filling Strakes

TECHNICAL DATA SHEET

3502HS

PRODUCT SPECIFICATIONS

Color	Neutral
Odor	Styrene
Texture	Smooth
Weight	8.5 - 9.5 lbs/gallon
Uncured Shelf Life	6 months

GEL PROPERTIES

Gel Time	Interval	Fixture Time	Peak Exo
45 - 75 min	20 - 50 min	50 - 100 min	150 - 240° F

Sample mass: 150 g w/ 2.0% DDM-9 @ 77 °F

VISCOSITY RANGES

RPM	μ Min CPS	μ Max CPS
2 @ 77 °F	1,750,000	2,500,000

Measured on Brookfield DVI HB #6

TYPICAL CURED PROPERTIES OF 3502

Test	ASTM Reference #	Typical Values
Tensile Elongation	D 638 - 82	3%
Tensile Strength	D 638 - 82	1920 PSI 13.2 MPA
Tensile Modulus	D 638 - 82	290000 PSI 1999.5 MPA
Flexural Strength	D 790	3500 PSI 24.1 MPA
Flexural Modulus	D 790	260000 PSI 1792.6 MPA
Compressive Strength	D 695 - 80	3150 PSI 21.7 MPA
Lap Shear	D 3163 - 84	1285 PSI 8.9 MPA
Heat Deflection	D 648 - 72	150 °F
Linear Shrinkage	D 2566 - 86	< 1 %
Shore D Hardness	D 2240 - 86	65

PACKAGING & AVAILABILITY

Pails
5 Gal./19 L



Drums
55 Gal./ 189 L

