COMPOSITE

professional Composite line

slem

PRODUCTS FOR
COMPOSITE INDUSTRY

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PRODUCTS FOR
COMPOSITE INDUSTRY

Composite

Where ideas take shape… Marine, Renewable energies, aeronautical, aerospace, transport and advanced mobility, the Composite Slem line represents a valid solution in the production phase of the fiberglass manufacturing and other composite materials.

Dove le idee prendono forma… Nautica, Energie Rinnovabili, Aeronautica, Aerospaziale, Trasporti e Mobilità Avanzate, la linea Composite Slem rappresenta una valida soluzione nelle fasi di produzione dei manufatti in vetroresina e altri materiali compositi.

composite slem

Industry Tech

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Car refinishing

The company's core business, with over 50 dedicated products, the Slem Car Refinishing line is able to meet any requirement in the body repair sector.

Core business dell'azienda, con oltre 50 prodotti dedicati, la linea Slem Car Refinishing rispondere a qualsiasi esigenza nel settore della riparazione della carrozzeria.

car refinishing slem

Wood

The Slem Wood line is composed of a range of putties which is widely used both in the construction and modelling industries.

La linea Slem Wood è composta da una gamma di stucchi che trova ampio impiego sia nell'edilizia che nella modelleria.

wood slem

Stones

In Slem Stones line you can find a wide range of putties for the filling and gluing of marble, stones, granite and related products.

Nella linea Slem Stones potete trovare un'ampia gamma di mastici per la stuccatura e l'incollaggio del marmo, pietre, graniti e affini.

stones slem

Bricolage

Slem Bricolage: various useful chemical products for wood / car / boat / stones D.I.Y.

Slem Bricolage: diversi prodotti chimici utili per il bricolage legno/auto/nautica/stones

bricolage slem

no Chemical

COMPANY PROFILE

The company **INTEC** S.r.l., Industria Tecno Chimica (Technical-Chemical Industry), was founded in 1971 in Calerno - Sant'Ilario d'Enza in the province of Reggio Emilia-ITALY.

From the very beginning the company specialized in the production and marketing of chemical products based on polyester resins. The know-how developed by the company in over forty years of business enabled us to create an extremely diverse range of products with brand "SLEM".

The lines that are currently in production are:

- "SlemCar-Refinishing" in the Bodywork and Transport fields.
- "SlemComposite" for various industry fields (marine, renewable energy, pipes, aeronautical, aerospace, trains, transports, advanced mobility, ect.)
- "SlemStones" in the field of marble, granites and natural stones
- "SlemWood" in the sector of wood
- "SlemBricolage" in the car/wood/stones D.I.Y.

All the Slem lines represent in the reference fields a valid solution in each productive phase and include a wide variety of products such as fillers, primers, transparent varnishes, putties, bonders, polishes, model pastes and additions.

The Slem lines with their versatility and dynamism allow the clientele to identify the best Slem product in order to carry out their work in the best possible way. An intense collaboration between the Sales Network, always aware of the continuous productive changes and the Research and Development laboratory enable the creation, year after year of new products which are able to meet the new productive demands of the various markets. Quality and technology are the elements that characterize the professional development of INTEC srl.

A continuous and constant business evolution, both at a structural and organizational level, is directing the company towards a widening of its national and international market. INTEC's aims at a company, sales and productive level are numerous... yet all joined together by a must: Professionalism.

*L'azienda **INTEC** S.r.l., Industria Tecno Chimica, nasce nel 1971 a Calerno - Sant'Ilario d'Enza in provincia di Reggio Emilia - ITALIA.*

L'azienda si specializza fin da subito nella produzione e commercializzazione di prodotti chimici a base di resine poliestere. Il know-how sviluppato dall'azienda in oltre quarant'anni di attività ha permesso la realizzazione di una gamma di prodotti estremamente variegata a marchio "Slem".

Le linee attualmente in produzione sono:

- *"SlemCar-Refinishing" nel settore della Carrozzeria*
- *"SlemComposite" per vari settori Industriali (nautica, energie rinnovabili, tubazioni, cisterne, aeronautico, aerospaziale, ferroviario, trasporti, mobilità avanzata, ecc.)*
- *SlemStones" nel settore del Marmo, del Granito e delle Pietre Naturali*
- *"SlemWood" nel settore del Legno*
- *"SlemBricolage" nel settore del bricolage auto/legno/stones*

Tutte le linee Slem rappresentano, nei settori di riferimento, una valida soluzione in ogni fase produttiva e comprendono una estesa varietà di prodotti quali stucchi, fondi, vernici trasparenti, mastici, bonders, lucidanti, paste per modellerie e prodotti complementari.

Le linee Slem, con la loro versatilità e dinamicità, permettono alla clientela di individuare il miglior prodotto Slem per completare al meglio il proprio lavoro. Una intensa collaborazione tra la Rete Commerciale, attenta ai continui cambiamenti produttivi, e il laboratorio di Ricerca e Sviluppo, permette di realizzare, anno dopo anno, nuovi prodotti capaci di soddisfare le nuove esigenze produttive dei vari mercati. Qualità e tecnologia sono gli elementi che caratterizzano lo sviluppo professionale della INTEC srl.

*Una continua e costante evoluzione aziendale, sia a livello strutturale che organizzativo, sta proiettando l'azienda verso un ampliamento del mercato nazionale e internazionale. Gli obbiettivi della INTEC a livello aziendale, commerciale e produttivo sono molteplici... ma uniti da un unico must: **Professionalità**.*

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PRODUCTS FOR COMPOSITE INDUSTRY

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CHEMICAL PRODUCTS FOR COMPOSITE INDUSTRY

PRODUCT CATEGORY / *CATEGORIA*	PRODUCT CODE / *CODICE*	PRODUCT / *PRODOTTO*
PUTTIES-BODY FILLERS / *STUCCHI*	SK1	PUTTY GREY / *STUCCO SK1*
	SK3	STRATOS PUTTY / *STUCCO STRATOS*
	SK2F	EXPORT PUTTY FLEXIBLE / *STUCCO EXPORT FLESSIBILE*
	SK8	FLEXIBLE PUTTY FOR FILLING WHITE / *STUCCO FLEX PER RIEMPIMENTO BIANCO*
	SK21 / SK21B	PUTTY EXTRA LIGHT / *STUCCO EXTRA LIGHT*
	SK22	UNIVERSAL LIGHT PUTTY WHITE / *STUCCO UNIVERSALE BIANCO*
	SK23	UNIVERSAL PLUS PUTTY / *STUCCO UNIVERSAL PLUS*
	SK24C	BEIGE COMPACT PUTTY / *STUCCO COMPACT SOFT BEIGE*
	SK40	FIBERGLASS PUTTY / *STUCCO VETRORESINA*
	SK41	PUTTY FOR ASSEMBLING / *STUCCO PER ASSEMBLAGGIO*
	SK50	PUTTY FOR CARBON / *STUCCO PER CARBONIO*
	SG90	GEL PUTTY FOR FINISHING / *STUCCO GEL PER FINITURA*
	SG91	GEL PUTTY FOR ASSEMBLING / *STUCCO GEL PER RIEMPIMENTO*
	SV70	VINYLESTER PUTTY FOR FINISHING / *STUCCO VINILESTERE PER FINITURA*
	SV71	VINYLESTER PUTTY FOR FILLING / *STUCCO VINILESTERE PER RIEMPIMENTO*
	SV72	VINYLESTER PUTTY LIGHT FOR FINISHING / *STUCCO VINILESTERE LIGHT PER FINITURA*
BONDING PASTES / *MASTICI*	B14 / B14R	BONDING PASTE PLUS (RAPID VERSION B14/R)/ *MASTICE PLUS CON MICROFIBRA*
	B15 / B15R	BONDING PASTE PLUS WITH FIBRES (RAPID VERSION B15/R)/ *MASTICE PLUS CON FIBRA*
	G1	BONDING PASTE FOR ASSEMBLING / *MASTICE PER ASSEMBLAGGIO*
	G2 / G2B	BONDING PASTE FOR ASSEMBLING / *MASTICE PER ASSEMBLAGGIO*
	G2RL	BONDING PASTE FOR ASSEMBLING RAPID/ SLOW/ *MASTICE PER ASSEMBLAGGIO RAPIDO LENTO*
	G3 / G3C	BONDING PASTE FOR FILLING WITH MICRO FIBRES / *MASTICE PER RESINATURA CON MICRO FIBRE*
	G3L	BONDING PASTE LIGHT FOR FILLING WITH MICRO FIBRES / *MASTICE LIGHT CON MICRO FIBRE*
	G4 / G4C	BONDING PASTE FOR FILLING WITH FIBRES / *MASTICE PER RESINATURA CON FIBRE*
	G4L	BONDING PASTE LIGHT FOR FILLING WITH FIBRES / *MASTICE LIGHT CON FIBRE*
	G6	BONDING PASTE FOR ASSEMBLING / *MASTICE PER ASSEMBLAGGIO*
	G7	INDUSTRIAL BONDING PASTE WITH MICRO FIBRES / *MASTICE INDUSTRIALE CON FIBRA*
	G8	INDUSTRIAL BONDING PASTE WITH FIBRES / *MASTICE INDUSTRIALE CON MICROFIBRA*
	GV20	VINILESTER BONDING PASTE FOR FILLING / *MASTICE VINILESTERE PER RESINATURA*
	GV21	VINILESTER BONDING PASTE WITH MICROFIBERS / *MASTICE VINILESTERE CON MICROFIBRE*
BONDING PASTES FOR CORE MATERIALS / *BONDER PER INCOLLAGGIO MATERIALI D'ANIMA*	BO7	BONDER EXTRA LIGHT / *BONDER EXTRA LIGHT*
	B10 / B10R	BONDER LIGHT / *BONDER LIGHT* - BONDER LIGHT RAPID / *BONDER LIGHT RAPIDO*
	BV10	VINYLESTER BONDER LIGHT / *VINYLBONDER LIGHT*
TOOLING PASTES & PUTTIES FOR THE TOOLING PASTES REFINISHING / *PASTE FRESABILI PER MODELLERIE E STUCCHI PER LA LORO FINITURA* * SEE / *VEDERE PAG. 46*	PF07E	EXTRUDABLE POLYESTER TOOLING PASTE LIGHT / *PASTA POLIESTERE ESTRUDIBILE LIGHT*
	PF10E	EXTRUDABLE POLYESTER TOOLING PASTE / *PASTA POLIESTERE ESTRUDIBILE*
	PF10	SPRAYABLE POLYESTER TOOLING PASTE / *PASTA POLIESTERE A SPRUZZO*
	PF07LS	LOW STYRENE EXTRUDABLE TOOLING PASTE LIGHT / *PASTA ESTRUDIBILE LOW STYRENE*
	PF07GT	GREEN TECH EXTRUDABLE TOOLING PASTE LIGHT / *PASTA ESTRUDIBILE GREEN TECHNOLOGY LIGHT*
	PF10GT	GREEN TECH EXTRUDABLE TOOLING PASTE / *PASTA ESTRUDIBILE GREEN TECH*
	PV10E	EXTRUDABLE VINYLESTER TOOLING PASTE / *PASTA VINILESTERE ESTRUDIBILE*
	PV10HT	EXTRUDABLE VINYLESTER TOOLING PASTE HIGH TEMPERATURE / PASTA VINILESTERE ESTRUDIBILE HIG
	SF07	BODY FILLER LIGHT FOR POLYESTER TOOLING PASTES FINISHING / *STUCCO LIGHT PER FINITURA PASTE PO*
	SF10	BODY FILLER FOR POLYESTER TOOLING PASTES FINISHING / *STUCCO PER FINITURA PASTE POLIESTERE*
PRIMERS / *FONDI*	SK4 / SK4B	FILLER SPRAY GRAY/ *FONDO SPRAY GRIGIO/ BIANCO*
	FP10 / FP11	POLYESTER POLISHING FINISHING FILLER WHITE-GREY/ *FONDO FINISHING BIANCO-GRIGIO LUCIDABILE*
	FV20 / FV21 / FV22	VINYLESTER POLISHING FINISHING FILLER WHITE-BLACK-GREY / *FONDO FINISHING BIANCO-NERO- GRIGIO VINIL*
	FV22	VINYLESTER POLISHING FINISHING FILLER GREY / *FONDO FINISHING VINILESTERE LUCIDABILE GRIGIO*
HIGH GLOSS PAINT/ *VERNICI TRASPARENTI*	VHG100 / VHG100B / VHG100G	HIGH GLOSS CLEAR COAT (COLORLES/BLACK/GREY) / *VERNICE TRASPARENTE HIGH GLOSS (TRASPARE*
TOOLING GELCOATS / *GELCOATS PER STAMPI*	GI	TOOLING GELCOAT ISOPHTHALIC / *GELCOATS PER STAMPI ISOFTALMICO*
	GV	TOOLING GELCOAT VINYLESTER / *GELCOATS PER STAMPI VINILESTERE*
BARRIERCOAT	BC90V	VINYLESTER BARRIERCOAT / *BARRIERCOAT VINYLESTERE*
TOOLING RESINS / *RESINE*	R999	RESIN FOR POLYSTIRENE LAMINATION / *RESINA PER LAMINAZIONE POSTIROLO*
	RV2015	SKIN COAT RESIN VINYLESTER / *RESINA VINILESTERE PER SKINCOAT*
	RS2005	PREFILLED TOOLING RESIN EASYMOULD / *RESINA CARICATA PER STAMPI EASYMOULD*
	RS2030	PREFILLED TOOLING RESIN HIGH QUALITY MOULD / *RESINA CARICATA PER STAMPI ALTA QUALITA'*
	RS6060LP	PREFILLED LP TOOLING RESIN POLYESTER / *RESINA CARICATA POLIESTERE LP PER STAMPI*
	RV8080LP	PREFILLED LP TOOLING RESIN VINYLESTER / *RESINA VINILESTERE CARICATA LP PER STAMPI*
POLISHING PRODUCTS / *LUCIDANTI*	L70	ABRASIVE PASTE / *PASTA ABRASIVA MORDENTE*
	L71	ABRASIVE PASTE EXTRA MORDANT / *PASTA ABRASIVA EXTRA MORDENTE*
	L80	UNIVERSAL POLISH / *POLISH UNIVERSALE*

	PLUG / *MODELLO*	MOULD / *STAMPO*	LAMINATION / *LAMINAZIONE*	ASSEMBLING / *ASSEMBLAGGIO*	BODY FINISHING / *FINITURA CARROZZERIA*
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GH TEMPERATURE	OK	OK			
OLYESTERE	OK				
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LESTERE LUCIDABILE	OK				OK
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PRODUCTS FOR COMPOSITE INDUSTRY

COMPOSITE PROCESSING STEPS / *TABELLA FASI DI LAVORAZIONE SETTORI COMPOSITO*	
PLUG / *MODELLO*	Assembling of plug frame / *Assemblaggio ossatura del modello*
	Foam support lamination / *Laminazione del supporto in espanso*
	Knife shaping of the plug / *Sagomatura a spatola del modello*
	Shaping with extrusion or spray systems / *Sagomatura con estrusione o spruzzo*
	Spray finishing of the plug surface / *Finitura a spruzzo del modello*
MOULD-LAMINATION / *STAMPO-LAMINAZIONE*	Skincoat lamination / *Laminazione dello skincoat*
	Layering plan lamination / *Laminazione del piano di stratifica*
	Filling of the strips / *Riempimento di pattini*
	Small angles and chines smoothing / *Raggiatura angoli e spigoli*
	Bonding of PVC, PU, balsa cores / *Incollaggio anime in PVC, balsa e poliuretano*
LAMINATION-ASSEMBLING / *LAMINAZIONE-ASSEMBLAGGIO*	Skincoat lamination / *Laminazione dello skincoat*
	Positioning of bulkheads / *Posizionamento paratie*
	Gluing of inserts / *Incollaggio inserti*
	Bonding of floors and cielings / *Incollaggio fondi e cielini*
	Bonding of the manufactured / *Accoppiamento manufatto*
FITTING-OUT / *ALLESTIMENTO*	Bonding of inner liners / *Incollaggio pareti esterne*
	Positioning of furnishings / *Fissaggio arredamento*
	Positioning of electric and plumbing systems / *Fissaggio impiantistica*
BODY-FINISHING / *FINITURA-CARROZZERIA*	Levelling of counterparts and sides / *Livellamento murate, pareti e cielini*
	Levelling of the surfaces / *Livellamento e rasatura superfici*
	Finishing of bonded joints / *Finitura giunzioni*
	Repairing of scratches and small cracks / *Eliminazione imperfezioni e graffi*
	Polishing of gelcoated surfaces / *Lucidatura del manufatto finito e gelcoat*

photo by **Bill Ingalls**

Putties-Body Fillers

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PRODUCTS FOR
COMPOSITE INDUSTRY

SK1
GREY POLYESTER PUTTY

Finishing putty based on polyester resins for general use. Formulated to ensure high spreadability, excellent flow and de-aeration for a complete absence of porosity, good adhesion to the support and long-term resistance to storage.

SUPPORTS

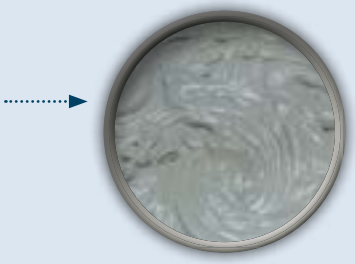
Laminates in polyester and vinyl ester fibreglass; raw sheet metal, degreased and sanded

GENERAL USE INDICATIONS

Apply on clean, sanded surfaces; make sure that the support is free of dust, fibres, dirt and surface condensation.
On the sheet metals, remove any residual oxide, degrease with antisilicone thinner.
Thoroughly mix the putty with 1.0 - 3.0% of catalyst-paste hardener (benzoyl peroxide), keeping in mind that the quantity of catalyst needed depends on the required operation Temperature and the processing times. The recommended operating temperature interval is between 12 and 30 °C.
It is applied manually with a spatula in one or more coats until reaching the required thickness.
Generally recommended dry sanding cycle, grit: P80-P120-P220.
In its original packaging the product is stable for 12 months when stored in a dry place at temperatures not exceeding 20°C.

TYPICAL SPECIFICATIONS OF THE LIQUID PRODUCT

	Value	Method
Colour	Gray	IMIA-01
Density, @ 23°C, g/litro	1820 ± 50	IMIA-02
Solid content, % by weight	87 ± 2	IMIA-03
Reactivity @ 23°C – Gel time, minutes 100 g. putty + 1,50 g. BPO 50% in paste	5 ± 1	IMIA-15
Min. sanding time at 23°, minutes	25	IMIA-55



TYPICAL CHARACTERISTICS OF THE HARDENED PRODUCT (*)

	Value	Method
Surface hardness Shore D	83	IMIA-29
Thermo-mechanical properties HDT, ° C	67	IMIA-50

(*) on specimens hardened for 24 hours at 23°C and post-hardened for 3 hours at 80°C

The information and data contained in this technical data sheet are based on the acquired measurements and experience; in good faith, they are put at the customer's disposal who is responsible for verifying the application and for the definition of suitability thereof for the intended use. INTEC assumes no responsibility for the results obtained in the specific application made by the user.

SK2F

EXPORT PUTTY / FLEXIBLE EXPORT PUTTY

Spatulable flexible polyester putty (SK2F), characterized by a high filling capacity and can be easily sanded. It is a putty that is suitable for general use: also used in the composite industry for spatula shaping of models, the levelling of walls and the finishing of joints. Optimal stretching and de-aeration for a complete absence of porosity. Together with its perfect adhesion on any metal support there is also zero shrinkage, maintaining flexibility over time and a high thermal resistance.

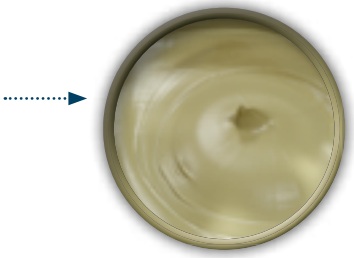
SUPPORTS

Laminates in polyester and vinyl ester fibreglass; raw sheet metal, degreased and sanded

GENERAL USE INDICATIONS

Apply on clean, sanded surfaces; make sure that the support is free of dust, fibres, dirt and surface condensation.
On the sheet metals, remove any residual oxide, degrease with antisilicone thinner.
Thoroughly mix the putty with 1.0 - 3.0% of catalyst-paste hardener (benzoyl peroxide), keeping in mind that the quantity of catalyst needed depends on the required operation Temperature and the processing times. The recommended operating temperature interval is between 12 and 30 °C.
It is applied manually with a spatula in one or more coats until reaching the required thickness.
Generally recommended dry sanding cycle, grit: P80-P120-P220.
In its original packaging the product is stable for 12 months when stored in a dry place at temperatures not exceeding 20°C.

TYPICAL SPECIFICATIONS OF THE LIQUID PRODUCT		
	Value SK2F	Method
Colour	Yellow	IMIA-01
Density, @ 23°C, g/litro	1830 ± 50	IMIA-02
Solid content, % by weight	85 ± 2	IMIA-03
Reactivity @ 23°C		
– Gel time, minutes	5 ± 1	IMIA-15
100 g. putty + 1,50 g. BPO 50% in paste		
Min. sanding time at 23°, minutes	25	IMIA-55



TYPICAL CHARACTERISTICS OF THE HARDENED PRODUCT (*)		
	Value SK2F	Method
Surface hardness Shore D	81	IMIA-29
Thermo-mechanical properties HDT, ° C	63	IMIA-50
(*) on specimens hardened for 24 hours at 23°C and post-hardened for 3 hours at 80°C		

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SK3
STRATOS PUTTY

Spatulable polyester putty, characterized by a high filling capacity and can be easily sanded. It is a putty that is suitable for general use: also used in the nautical industry for spatula shaping of models, the levelling of walls and the finishing of joints. Optimal stretching and de-aeration for a complete absence of porosity. Together with its perfect adhesion on any metal support there is also zero shrinkage, maintaining flexibility over time and a high thermal resistance.

SUPPORTS
Laminates in polyester and vinyl ester fibreglass; raw sheet metal, degreased and sanded.

GENERAL USE INDICATIONS
Apply on clean, sanded surfaces; make sure that the support is free of dust, fibres, dirt and surface condensation.
On the sheet metals, remove any residual oxide, degrease with antisilicone thinner.
Thoroughly mix the putty with 1.0 – 3.0% of catalyst-paste hardener (benzoyl peroxide), keeping in mind that the quantity of catalyst needed depends on the required operation Temperature and the processing times. The recommended operating temperature interval is between 12 and 30 °C.
It is applied manually with a spatula in one or more coats until reaching the required thickness.
Generally recommended dry sanding cycle, grit: P80-P120-P220.
In its original packaging the product is stable for 12 months when stored in a dry place at temperatures not exceeding 20°C.

TYPICAL SPECIFICATIONS OF THE LIQUID PRODUCT		
Colour	Yellow	IMIA-01
Density, @ 23°C, g/litro	1800 ± 50	IMIA-02
Solid content, % by weight	87 ± 2	IMIA-03
Reactivity @ 23°C – Gel time, minutes 100 g. putty + 1,50 g. BPO 50% in paste	5 ± 1	IMIA-15
Min. sanding time at 23°, minutes	25	IMIA-55

TYPICAL CHARACTERISTICS OF THE HARDENED PRODUCT (*)		
	Value SK2	Method
Surface hardness Shore D	81	IMIA-29
Thermo-mechanical properties HDT, ° C	65 ± 5	IMIA-50
(*) on specimens hardened for 24 hours at 23°C and post-hardened for 3 hours at 80°C		

The information and data contained in this technical data sheet are based on the acquired measurements and experience; in good faith, they are put at the customer's disposal who is responsible for verifying the application and for the definition of suitability thereof for the intended use. INTEC assumes no responsibility for the results obtained in the specific application made by the user.

SK8

FLEX PUTTY FOR MODELS

Spatula polyester putty characterized by easy application and flexibility. It has excellent sanding properties and impact resistance. It leaves no holes. In the nautical industry it is particularly suitable for shaping models.

SUPPORTS

Laminates polyester and vinylester fibreglass, wood, degreased and sanded bare metal.

GENERAL USE INDICATIONS

Apply on clean, sanded surfaces; make sure that the support is free of dust, fibres, dirt and surface condensation. On the sheets, remove any residual oxide, degrease with antisilicone solvent.

Thoroughly mix the mastic with 1,0 - 2,0% of catalyst liquid (methyl ethyl ketone peroxide), keeping in mind that the required catalyst quantity depends on the required operating temperature and the processing times. The recommended temperature range is between 12 and 30°C.

It is applied manually by spatula with one or more coats until reaching the required thickness.

Typically recommended cycle of dry sanding, grit: P80-P120-P220-P400. Can be sanded 20 minutes after being applied at 23°C.

In its original packaging the product is stable for 12 months in storage at temperatures not exceeding 20°C.

TYPICAL SPECIFICATIONS OF THE LIQUID PRODUCT	Value	Method
Colour	White	IMIA-01
Density, @ 23°C, g/litro	1750 ± 50	IMIA-02
Solid content, % by weight	81 ± 2	IMIA-03
Reactivity @ 23°C – Gel time, minutes 100 g. putty + 1,50 g. MEKP 50%	30 ± 5	IMIA-15
Min. sanding time at 23°, minutes	180	IMIA-55

TYPICAL CHARACTERISTICS OF THE HARDENED PRODUCT (*)	Value	Method
Surface hardness Shore D	60	IMIA-29
Thermo-mechanical properties HDT, ° C	48 ± 5	IMIA-50
(*) on specimens hardened for 24 hours at 23°C and post-hardened for 3 hours at 80°C		

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SK21 / SK21B

EXTRALIGHT PUTTY / EXTRALIGHT PUTTY WHITE

Light spatulable polyester putty. Used in the transport and composite sectors as a modelling indicator for the filling of the model for the finishing of the pieces. Having soft spatuling characteristics and being easy to sand without kneading the abrasive paper, it is also appreciated for the finishing of the joints, the elimination of scratches and surface imperfections. It does not shrink, it leaves no surface holes and tolerates any impacts well.

SUPPORTS

Laminates in polyester and vinyl ester fibreglass; raw sheet metal, degreased and sanded

GENERAL USE INDICATIONS

Apply on clean, sanded surfaces; make sure that the support is free of dust, fibres, dirt and surface condensation.
On the sheet metals, remove any residual oxide, degrease with antisilicone thinner.
Thoroughly mix the putty with 1.0 - 3.0% of catalyst-paste hardener (benzoyl peroxide), keeping in mind that the quantity of catalyst needed depends on the required operation Temperature and the processing times. The recommended operating temperature interval is between 12 and 30 °C.
It is applied manually with a spatula in one or more coats until reaching the required thickness.
Generally recommended dry sanding cycle, grit: P80-P120-P220. Can be sanded 30 minutes after being applied at 23°C.
In its original packaging the product is stable for 12 months when stored in a dry place at temperatures not exceeding 20°C.

TYPICAL SPECIFICATIONS OF THE LIQUID PRODUCT	Value	Method
Colour	Beige (SK21) White (SK21B)	IMIA-01
Density, @ 23°C, g/litro	1200 ± 50	IMIA-02
Solid content, % by weight	79 ± 2	IMIA-03
Reactivity @ 23°C – Gel time, minutes 100 g. putty + 1,50 g. BPO 50% in paste	6 ± 1	IMIA-15
Min. sanding time at 23°, minutes	30	IMIA-55

TYPICAL CHARACTERISTICS OF THE HARDENED PRODUCT (*)	Value	Method
Surface hardness Shore D	70	IMIA-29
Thermo-mechanical properties HDT, ° C	40 ± 5	IMIA-50
(*) on specimens hardened for 24 hours at 23°C and post-hardened for 3 hours at 80°C		

SK21

SK21B

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SK22

UNIVERSAL LIGHT POLYESTER PUTTY

Polyester putty for general use with low specific weight. Used in the composite sector for the model and model repair. Also used in the finishing of joints, in the levelling of the walls and the elimination of scratches and surface imperfections. Excellent spreadability and sanding.

SUPPORTS

Laminates polyester and vinylester fibreglass, degreased and sanded bare metal.

GENERAL USE INDICATIONS

Apply on clean, sanded surfaces; make sure that the support is free of dust, fibres, dirt and surface condensation. On the sheets, remove any residual oxide, degrease with antisilicone solvent.

Thoroughly mix the mastic with 1.0 - 3.0% of catalyst-paste hardener (benzoyl peroxide), keeping in mind that the required catalyst quantity depends on the required operating temperature and the processing times. The recommended temperature range is between 12 and 30°C.

It is applied manually by spatula with one or more coats until reaching the required thickness.

Typically recommended cycle of dry sanding, grit: P80-P120-P220.

In its original packaging the product is stable for 12 months in storage at temperatures not exceeding 20°C.

TYPICAL SPECIFICATIONS OF THE LIQUID PRODUCT		
	Value	Method
Colour	White	IMIA-01
Density, @ 23°C, g/litro	1320 ± 50	IMIA-02
Solid content, % by weight	85,4 ± 2	IMIA-03
Reactivity @ 23°C		
– Gel time, minutes	6 ± 1	IMIA-15
100 g. putty + 1,50 g. BPO 50% in paste		
Min. sanding time at 23°, minutes	25	IMIA-55

TYPICAL CHARACTERISTICS OF THE HARDENED PRODUCT (*)		
	Value	Method
Surface hardness Shore D	74	IMIA-29
Thermo-mechanical properties HDT, ° C	46 ± 5	IMIA-50
(*) on specimens hardened for 24 hours at 23°C and post-hardened for 3 hours at 80°C		

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SK23

UNIVERSAL PLUS PUTTY

Polyester putty for general use with low specific weight, characterized by excellent spreading and sanding qualities. Excellent spreading out and de-aeration for a total absence of porosity. Used in the composite industry in the finishing of joints, in the levelling of the walls and the elimination of scratches and surface imperfections.

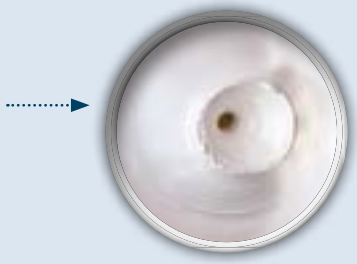
SUPPORTS

Laminates polyester and vinylester fibreglass, wood, degreased and sanded bare metal.

GENERAL USE INDICATIONS

Apply on clean, sanded surfaces; make sure that the support is free of dust, fibres, dirt and surface condensation. On the sheets, remove any residual oxide, degrease with antisilicone solvent.
Thoroughly mix the mastic with 1.0 - 3.0% of catalyst-paste hardener (benzoyl peroxide), keeping in mind that the required catalyst quantity depends on the required operating temperature and the processing times. The recommended temperature range is between 12 and 30°C.
It is applied manually by spatula with one or more coats until reaching the required thickness.
Typically recommended cycle of dry sanding, grit: P80-P120-P220.
In its original packaging the product is stable for 12 months in storage at temperatures not exceeding 20°C.

TYPICAL SPECIFICATIONS OF THE LIQUID PRODUCT	Value	Method
Colour	White	IMIA-01
Density, @ 23°C, g/litro	1250 ± 50	IMIA-02
Solid content, % by weight	82 ± 2	IMIA-03
Reactivity @ 23°C		
– Gel time, minutes	6 ± 1	IMIA-15
100 g. putty + 1,50 g. BPO 50% in paste		
Min. sanding time at 23°, minutes	20	IMIA-55



TYPICAL CHARACTERISTICS OF THE HARDENED PRODUCT (*)	Value	Method
Surface hardness Shore D	74	IMIA-29
Thermo-mechanical properties HDT, ° C	50 ± 2	IMIA-50
(*) on specimens hardened for 24 hours at 23°C and post-hardened for 3 hours at 80°C		

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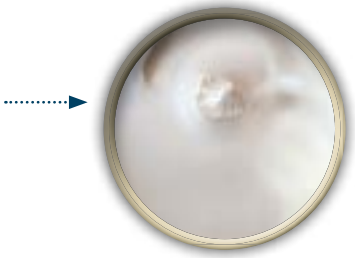
SK24
UNIVERSAL SOFT

Polyester putty based on polyester resins for general use in composite sector. Formulated to provide an exceptional spreadability, excellent spreading out, adhesion to the support and de-aeration for a total absence of porosity; long term resistance to storage.

SUPPORTS
Laminates polyester and vinylester fibreglass, degreased and sanded bare metal.

GENERAL USE INDICATIONS
Apply on clean, sanded surfaces; make sure that the support is free of dust, fibres, dirt and surface condensation. On the sheets, remove any residual oxide, degrease with antisilicone solvent.
Thoroughly mix the mastic with 1.0 - 3.0% of catalyst-paste hardener (benzoyl peroxide), keeping in mind that the required catalyst quantity depends on the required operating temperature and the processing times. The recommended temperature range is between 12 and 30°C.
It is applied manually by spatula with one or more coats until reaching the required thickness.
Typically recommended cycle of dry sanding, grit: P80-P120-P220.
In its original packaging the product is stable for 12 months in storage at temperatures not exceeding 20°C.

TYPICAL SPECIFICATIONS OF THE LIQUID PRODUCT		
	Value	Method
Colour	Beige	IMIA-01
Density, @ 23°C, g/litro	1800 ± 50	IMIA-02
Solid content, % by weight	87 ± 2	IMIA-03
Reactivity @ 23°C		
– Gel time, minutes	5 ± 1	IMIA-15
100 g. putty + 1,50 g. BPO 50% in paste		
Min. sanding time at 23°, minutes	20	IMIA-55



TYPICAL CHARACTERISTICS OF THE HARDENED PRODUCT (*)		
	Value	Method
Surface hardness		
Shore D	80	IMIA-29
Thermo-mechanical properties		
HDT, ° C	65 ± 5	IMIA-50
(*) on specimens hardened for 24 hours at 23°C and post-hardened for 3 hours at 80°C		

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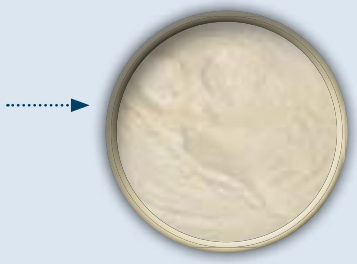
SK40
FIBREGLASS PUTTY

Polyester putty with glass fibre for filling and reinforced smoothing operations, also with high thicknesses. Highly thixotropic and easy to spread out when repairing and filling damaged surfaces, it is particularly appreciated for the fastening of roof frames and ribs and for the assembly of semi-finished products and fibreglass products in the composite field.

SUPPORTS
Laminates in polyester and vinyl ester fibreglass.

GENERAL USE INDICATIONS
Apply on clean, sanded surfaces; make sure that the support is free of dust, fibres, dirt and surface condensation.
Thoroughly mix the putty with 1.0 - 3.0% of catalyst-paste hardener (benzoyl peroxide), keeping in mind that the quantity of catalyst needed depends on the required operation Temperature and the processing times. The recommended operating temperature interval is between 12 and 30 °C.
It is applied manually with a spatula in one or more coats until reaching the required thickness.
In its original packaging the product is stable for 12 months when stored in a dry place at temperatures not exceeding 20°C.

TYPICAL SPECIFICATIONS OF THE LIQUID PRODUCT		
	Value	Method
Colour	Yellow	IMIA-01
Weight density, @ 23°C, g/litro	1360 ± 50	IMIA-02
Solid content, % by weight	83 ± 2	IMIA-03
Reactivity @ 23°C		
– Gel time, minutes	6 ± 1	IMIA-15
100 g. putty + 1,50 g. BPO 50% in paste		
Min. sanding time at 23°, minutes	25	IMIA-55



TYPICAL CHARACTERISTICS OF THE HARDENED PRODUCT (*)		
	Value	Method
Surface hardness		IMIA-29
Shore D	75	IMIA-28
Elastic form		
Flexural modulus, MPa	3010	ISO 178
Tensile modulus, MPa	5150	ISO 527
Thermo-mechanical properties		
HDT, ° C	51 ± 5	IMIA-50
TG,° C	74 ± 5	ASTM D3418

(*) on specimens hardened for 24 hours at 23°C and post-hardened for 3 hours at 80°C

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SK41

PUTTY FOR ASSEMBLY OPERATIONS

Polyester putty with glass fibre for filling and reinforced smoothing operations. Highly thixotropic and easy to spread out when repairing and filling damaged surfaces, it is particularly appreciated for the assembly of semi-finished products and fibreglass products in the composite field.

SUPPORTS

Laminates in polyester and vinyl ester fibreglass.

GENERAL USE INDICATIONS

Apply on clean, sanded surfaces; make sure that the support is free of dust, fibres, dirt and surface condensation.
Thoroughly mix the putty with 1.0 - 3.0% of catalyst-paste hardener (benzoyl peroxide), keeping in mind that the quantity of catalyst needed depends on the required operation Temperature and the processing times. The recommended operating temperature interval is between 12 and 30 °C.
It is applied manually with a spatula in one or more coats until reaching the required thickness.
In its original packaging the product is stable for 12 months when stored in a dry place at temperatures not exceeding 20°C.

TYPICAL SPECIFICATIONS OF THE LIQUID PRODUCT		
	Value	Method
Colour	Grey	IMIA-01
Weight density, @ 23°C, g/litro	1550 ± 50	IMIA-02
Solid content, % by weight	81 ± 2	IMIA-03
Reactivity @ 23°C		
– Gel time, minutes	6 ± 1	IMIA-15
100 g. putty + 1,50 g. BPO 50% in paste		
Min. sanding time at 23°, minutes	25	IMIA-55

TYPICAL CHARACTERISTICS OF THE HARDENED PRODUCT (*)		
	Value	Method
Surface hardness		
Shore D	90	IMIA-29
Barcol	40	IMIA-29
Elastic form		
Flexural modulus, MPa	6989	ISO 178
Tensile modulus, MPa	8030	ISO 527
Thermo-mechanical properties		
HDT, ° C	60 ± 5	IMIA-50
TG,° C	83 ± 5	ASTM D3418

(*) on specimens hardened for 24 hours at 23°C and post-hardened for 3 hours at 80°C

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SK50
TRANSPARENT PUTTY

Transparent putty based on special polyester resins. Easy to spread apply even on vertical surfaces. Particularly suitable for practically invisible neutral grouting, without causing halos. Recommended for grouting materials on demand (e.g. carbon). The transparency of the grouting persists up to a maximum thickness of 2 mm.

SUPPORTS
Fibreglass polyester and vinyl ester laminates; carbon

GENERAL USE INDICATIONS
Apply on clean, sanded surfaces; make sure that the support is free of dust, fibres, dirt and surface condensation.
Thoroughly mix the putty with 1.0 - 2.0% of liquid catalyst (methyl ethyl ketone peroxide), keeping in mind that the quantity of catalyst needed depends on the required operation Temperature and the processing times. The recommended operating temperature interval is between 12 and 30 °C.
It is applied manually with a spatula.
Once applied the product, you can smooth and polish the surface after 6 - 8 hours.
In its original packaging the product is stable for 12 months when stored in a dry place at temperatures not exceeding 20°C.

TYPICAL SPECIFICATIONS OF THE LIQUID PRODUCT		
	Value	Method
Colour	Colourless	IMIA-01
Weight density, @ 23°C, g/litre	1100 ± 50	IMIA-02
Solid content, % by weight	65 ± 2	IMIA-03
Reactivity @ 23°C		
– Gel time, min.	30 ± 5	IMIA-15
100 g. putty + 1,50 g. MEKP 50%		

TYPICAL CHARACTERISTICS OF THE HARDENED PRODUCT (*)		
	Value	Method
Surface hardness, shore-D	75	IMIA-29
Thermo-mechanical resistance HDT, ° C	55 ± 2	IMIA-50
(*) on specimens hardened for 24 hours at 23°C and post-hardened for 3 hours at 80°C		

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SG90

GEL PUTTY FOR FINISHING

White gel-based putty made from isophthalic resins specifically formulated for the nautical industry for the finishing and manual levelling of large surfaces. Excellent workability and sanding are flanked by a low shrinkage and an intense white colour that facilitates overpainting with gelcoat greatly increasing the yield of application. Recommended in a thin layer in the body cycles, directly above the support or putty filler (putty filler SG91).

SUPPORTS

laminates in Fibreglass, Polyester and Vinyl ester filler putties and mastics.

GENERAL USE INDICATIONS

Apply on clean, sanded surfaces; make sure that the support is free of dust, fibres, dirt and surface condensation.
Thoroughly mix the putty with 1.0 - 3.0% of catalyst-paste hardener (benzoyl peroxide), keeping in mind that the quantity of catalyst needed depends on the required operation Temperature and the processing times. The recommended operating temperature interval is between 12 and 30 °C.
It is applied manually with a spatula. Maximum thickness applicable for each layer 3 mm.
For further and more specific application details on the finishing putty cycles, refer to the "Finishing Processes Manual", available at the INTEC After-Sales Technical Service Centre.
In its original packaging the product is stable for 6 months when stored in a dry place at temperatures not exceeding 20°C.

TYPICAL SPECIFICATIONS OF THE LIQUID PRODUCT		
	Value	Method
Colour	White	IMIA-01
Weight density, @ 23°C, g/litro	1300 ± 50	IMIA-02
Solid content, % by weight	80 ± 2	IMIA-03
Reactivity @ 23°C		
– Gel time, minutes	6 ± 1	IMIA-15
100 g. putty + 1,50 g. BPO 50% in paste		
Min. sanding time at 23°, minutes	20	IMIA-55

TYPICAL CHARACTERISTICS OF THE HARDENED PRODUCT (*)		
	Value	Method
Surface hardness Shore D	80	IMIA-29
Thermo-mechanical properties		
HDT, ° C	57 ± 2	IMIA-50
TG,° C	65 ± 2	ASTM D3418
(*) on specimens hardened for 24 hours at 23°C and post-hardened for 3 hours at 80°C		

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SG91

GEL PUTTY FOR FILLING

Light white putty-gel specifically formulated for the nautical and composite industry for filling bubbles, flaws and joint lines, the smoothing and manual starting of large surfaces. Together with the excellent workability and sanding, there is a contained shrinkage and an intense white colour that makes recoating easy with gelcoat, greatly increasing the application yield. To meet the more demanding finishing specifications it is advisable to precede the gelcoat with the finishing putty (finishing putty SG90).

SUPPORTS

Fibreglass laminates, Polyester and Vinyl Ester mastics.

GENERAL USE INDICATIONS

Apply on clean, sanded surfaces; make sure that the support is free of dust, fibres, dirt and surface condensation.
Thoroughly mix the putty with 1.0 - 2.0% of liquid catalyst (methyl ethyl ketone peroxide), keeping in mind that the quantity of catalyst needed depends on the required operation Temperature and the processing times. The recommended operating temperature interval is between 12 and 30 °C.
It is applied manually with a spatula. Maximum thickness applicable for each layer 6-8 mm.
For further and more specific application details on the finishing putty cycles, refer to the "Finishing Processes Manual", available at the INTEC After-Sales Technical Service Centre.
In its original packaging the product is stable for 6 months when stored in a dry place at temperatures not exceeding 20°C.

TYPICAL SPECIFICATIONS OF THE LIQUID PRODUCT		
	Value	Method
Colour	White	IMIA-01
Weight density, @ 23°C, g/litro	1300 ± 50	IMIA-02
Solid content, % by weight	80 ± 2	IMIA-03
Reactivity @ 23°C		
– Gel time, minutes	25 ± 5	IMIA-15
100 g. putty + 1,50 g. MEKP 50%		
Min. sanding time at 23°, minutes	120	IMIA-55

TYPICAL CHARACTERISTICS OF THE HARDENED PRODUCT (*)		
	Value	Method
Surface hardness Shore D	80	IMIA-29
Thermo-mechanical properties		
HDT, ° C	57 ± 2	IMIA-50
TG,° C	65 ± 2	ASTM D3418
(*) on specimens hardened for 24 hours at 23°C and post-hardened for 3 hours at 80°C		

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SV70

VINYLESTER PUTTY FOR FINISHING

White vinyl ester putty based on extra-fine minerals fillers that give the product excellent spreadability and sanding. Specifically formulated for excellent finishing of surfaces directly exposed to the external environment, with higher resistance, thermal, mechanical and antiosmosis performances. Prior to sanding it can be recoated. Recommended in a thin layer in the body cycles where it is necessary to satisfy the most demanding finishing specifications, directly on the support or over the filler putty for outdoors exterior filler (filler putty SV71).

SUPPORTS

Laminates in Fibreglass, Polyester and Vinyl ester filler putties and mastics.

GENERAL USE INDICATIONS

Apply on clean, sanded surfaces; make sure that the support is free of dust, fibres, dirt and surface condensation.
Thoroughly mix the putty with 1.0 - 3.0% of catalyst-paste hardener (benzoyl peroxide), keeping in mind that the quantity of catalyst needed depends on the required operation Temperature and the processing times. The recommended operating temperature interval is between 12 and 30 °C.
It is applied manually with a spatula. Maximum thickness applicable for each layer 3 mm.
For further and more specific application details on the finishing putty cycles, refer to the "Finishing Processes Manual", available at the INTEC After-Sales Technical Service Centre.
In its original packaging the product is stable for 6 months when stored in a dry place at temperatures not exceeding 20°C.

TYPICAL SPECIFICATIONS OF THE LIQUID PRODUCT		
	Value	Method
Colour	White	IMIA-01
Weight density, @ 23°C, g/litro	1600 ± 50	IMIA-02
Solid content, % by weight	81 ± 2	IMIA-03
Reactivity @ 23°C		
– Gel time, minutes	7 ± 1	IMIA-15
100 g. putty + 1,50 g. BPO 50% in paste		
Min. sanding time at 23°, minutes	25	IMIA-55

TYPICAL CHARACTERISTICS OF THE HARDENED PRODUCT (*)		
	Value	Method
Linear shrinkage, %	0,65	IMIA-03
Surface hardness		
Shore D	85	IMIA-29
Barcol	33	IMIA-28
Elastic form		
Flexural modulus, MPa	7550	ISO 178
Tensile modulus, MPa	9260	ISO 527
Thermo-mechanical properties		
HDT, ° C	85 ± 5	IMIA-50
TG,° C	93 ± 5	ASTM D3418
Water absorption %	0,30	IMIA-46

(*) on specimens hardened for 24 hours at 23°C and post-hardened for 3 hours at 80°C

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SV71

VINYLESTER PUTTY FOR FILLING

White vinyl ester putty based on extra-fine minerals fillers that give the product excellent spreadability and sanding. Specifically formulated for the bubbles finishing, joining lines defects, as a manual coating and starting filler; even on high thickness higher than 3mm; SV71 shows excellent thixotropic behavior and a limited withdrawall.
It can be used on the surfaces directly exposed to the external environment, with higher resistance, thermal, mechanical and antiosmosis performances. Prior to sanding it can be recoated.

SUPPORTS

Laminates in Fibreglass, Polyester and Vinyl ester filler putties and mastics.

GENERAL USE INDICATIONS

Apply on clean, sanded surfaces; make sure that the support is free of dust, fibres, dirt and surface condensation.
Thoroughly mix the putty with 1.0 - 2.0% of liquid hardener (metiletilchetone peroxide), keeping in mind that the quantity of catalyst needed depends on the required operation Temperature and the processing times. The recommended operating temperature interval is between 12 and 30 °C.
It is applied manually with a spatula. Maximum thickness applicable for each layer 6-8 mm.
For further and more specific application details on the finishing putty cycles, refer to the "Finishing Processes Manual", available at the INTEC After-Sales Technical Service Centre.
In its original packaging the product is stable for 4 months when stored in a dry place at temperatures not exceeding 20°C.

TYPICAL SPECIFICATIONS OF THE LIQUID PRODUCT		
	Value	Method
Colour	White	IMIA-01
Weight density, @ 23°C, g/litro	1600 ± 50	IMIA-02
Solid content, % by weight	80 ± 2	IMIA-03
Reactivity @ 23°C		
– Gel time, minutes	30 ± 5	IMIA-15
100 g. putty + 1,50 g. MEKP 50%		
Min. sanding time at 23°, minutes	180	IMIA-55

TYPICAL CHARACTERISTICS OF THE HARDENED PRODUCT (*)		
	Value	Method
Linear shrinkage, %	0,60	IMIA-03
Surface hardness		
Shore D	85	IMIA-29
Barcol	33	IMIA-28
Elastic form		
Flexural modulus, MPa	5750	ISO 178
Tensile modulus, MPa	11189	ISO 527
Thermo-mechanical properties		
HDT, ° C	75 ± 5	IMIA-50
TG,° C	87 ± 5	ASTM D3418
Water absorption %	0,25	IMIA-46

(*) on specimens hardened for 24 hours at 23°C and post-hardened for 3 hours at 80°C

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SV72

VINYLESTER LIGHT FINISHING PUTTY

White vinyl ester putty based on extra-fine minerals fillersthat give the product excellent spreadability and sanding, low density and contained shrinkage with exceptional sanding characteristics. Specifically formulated for excellent finishing surfaces directly exposed to the external environment, with higher resistance, thermal, mechanical and antiosmosis performances. Prior to sanding it can be recoated with gelcoat. Recommended in a thin layer in the body cycles where it is necessary to satisfy the most demanding finishing specifications, directly on the support or over the filler putty for outdoors exterior filler (filler putty SV71). It can also be used as a coating and starting filler when the containment of the final weight of the piece are priority. Use only over the waterline is recommended

SUPPORTS

Laminates in Fibreglass, Polyester and Vinyl ester filler putties and mastics.

GENERAL USE INDICATIONS

Apply on clean, sanded surfaces; make sure that the support is free of dust, fibres, dirt and surface condensation.
Thoroughly mix the putty with 1.0 - 3.0% of catalyst-paste hardener (benzoyl peroxide), keeping in mind that the quantity of catalyst needed depends on the required operation Temperature and the processing times. The recommended operating temperature interval is between 12 and 30 °C.
It is applied manually with a spatula. Maximum thickness applicable for each layer 5-6 mm.
For further and more specific application details on the finishing putty cycles, refer to the "Finishing Processes Manual", available at the INTEC After-Sales Technical Service Centre.
In its original packaging the product is stable for 4 months when stored in a dry place at temperatures not exceeding 20°C.

TYPICAL SPECIFICATIONS OF THE LIQUID PRODUCT		
	Value	Method
Colour	White	IMIA-01
Weight density, @ 23°C, g/litro	1250 ± 50	IMIA-02
Solid content, % by weight	78 ± 2	IMIA-03
Reactivity @ 23°C		
– Gel time, minutes	6 ± 1	IMIA-15
100 g. putty + 1,50 g. BPO 50% in paste		
Min. sanding time at 23°, minutes	25	IMIA-55

TYPICAL CHARACTERISTICS OF THE HARDENED PRODUCT (*)		
	Value	Method
Surface hardness		IMIA-29
Shore D	78	IMIA-28
Elastic form		
Flexural modulus, MPa	3230	ISO 178
Tensile modulus, MPa	6860	ISO 527
Thermo-mechanical properties		
HDT, ° C	80 ± 5	IMIA-50
TG,° C	90 ± 5	ASTM D3418
Water absorption %	0,70	IMIA-46
(*) on specimens hardened for 24 hours at 23°C and post-hardened for 3 hours at 80°C		

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Bonding pastes

COMPOSITE

professional Composite line

slem

PRODUCTS FOR
COMPOSITE INDUSTRY

B14 / B14R

BONDING PASTE PLUS WITH MICROFIBRES / BONDING PASTE PLUS WITH MICROFIBRES RAPID

Adhesive bonding paste with micro-fibres based on unsaturated polyester resins, microspheres and light reinforcing charges. Used in the composite industry for bonding expanded cores in PVC, Polyurethane, Balsa and inserts of various kinds. The reinforcing fibres give this product high mechanical strength, making it suitable also for radiusing and the filling of the corners of the mouldings both immediately behind the gelcoat or the first MATs and in the positioning of bulkheads and mirrors.

SUPPORTS

Gelcoat, polyester and vinyl Fibreglass, Wood, Foams of various kinds.

GENERAL USE INDICATIONS

Apply on clean surfaces sanded; make sure that the support is free of dust, fibres, dirt and surface condensation.
Thoroughly mix the bonder with 1,0 - 2,0% of catalyst liquid (methyl ethyl ketone peroxide), keeping in mind that the required catalyst quantity depends on the required operating temperature and the processing times. The recommended temperature range is between 16 and 28°C. The product contains viracolor.
It is applied manually by spatula after a thorough mixing of the catalyst. For quantities exceeding 5 kg it is recommended mixing with a whisk; for 200 litre drums the aid of an extruder-mixer pressing plate provides the best efficiency of mixing.
In its original packaging the product is stable for 12 months in storage at temperatures not exceeding 20°C.

TYPICAL SPECIFICATIONS OF THE LIQUID PRODUCT

	Value B14	Value B14/R	Method
Colour	Light blue colour-changing	Light blue colour-changing	IMIA-01
Weight density, @ 23°C, g/litro	1400 ± 50	1400 ± 50	IMIA-02
Solid content, % by weight	70 ± 2	70 ± 2	IMIA-03
Reactivity @ 23°C			
– Gel time, minutes	45 ± 10	20 ± 5	IMIA-15
100 g. bonding paste + 1,50 g. MEKP 50%			

TYPICAL CHARACTERISTICS OF THE HARDENED PRODUCT (*)

	Value B14	Value B14/R	Method
Linear shrinkage @ 23°C, %	0,70	0,75	IMIA-25
Surface hardness			
Shore D	73	73	IMIA-29
Barcol	38	38	IMIA-28
Elastic form			
Flexural modulus, MPa	5528	5528	ISO 178
Tensile modulus, MPa	9603	9603	ISO 527
Thermo-mechanical properties			
HDT, ° C	70 ± 5	70 ± 5	IMIA-50
TG,° C	68 ± 5	68 ± 5	ASTM D3418
(*) on specimens hardened for 24 hours at 23°C and post-hardened for 3 hours at 80°C			

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B15 / B15R / B15T

BONDING PASTE PLUS WITH FIBRES / BONDING PASTE PLUS WITH FIBRES RAPID / BONDING PASTE PLUS WITH FIBRES TIXO

Adhesive bonding paste reinforced with fibres based on unsaturated polyester resins, microspheres and light reinforcing charges. Used in the composite industry for bonding expanded cores in PVC, Polyurethane, Balsa and inserts of various kinds. The reinforcing fibres give this product high mechanical strength, making it suitable also for radiusing and the filling of the corners of the mouldings both immediately behind the gelcoat or the first MATs and in the positioning of bulkheads and mirrors.
Fibers length 3-6 mm.

SUPPORTS

Polyester and vinyl Fibreglass, Wood, Foams of various kinds.

GENERAL USE INDICATIONS

Apply on clean surfaces sanded; make sure that the support is free of dust, fibres, dirt and surface condensation.
Thoroughly mix the bonder with 1,0 - 2,0% of catalyst liquid (methyl ethyl ketone peroxide), keeping in mind that the required catalyst quantity depends on the required operating temperature and the processing times. The recommended temperature range is between 16 and 28°C. The product contains viracolor.
It is applied manually by spatula after a thorough mixing of the catalyst. For quantities exceeding 5 kg it is recommended mixing with a whisk.
In its original packaging the product is stable for 6 months in storage at temperatures not exceeding 20°C.

TYPICAL SPECIFICATIONS OF THE LIQUID PRODUCT

	Value B15	Value B15/R	Value B15/T	Method
Colour	Light blue colour-changing	Light blue colour-changing	Light blue colour-changing	IMIA-01
Weight density, @ 23°C, g/litro	1400 ± 50	1400 ± 50	1400 ± 50	IMIA-02
Solid content, % by weight	76 ± 2	76 ± 2	78 ± 2	IMIA-03
Reactivity @ 23°C – Gel time, minutes 100 g. bonding paste + 1,50 g. MEKP 50%	40 ± 10	20 ± 5	40 ± 5	IMIA-15

TYPICAL CHARACTERISTICS OF THE HARDENED PRODUCT (*)

	Value B15	Value B15/R	Value B15/T	Method
Linear shrinkage @ 23°C, %	0,70	0,70	0,70	IMIA-25
Surface hardness				
Shore D	85	85	85	IMIA-29
Barcol	38	38	38	IMIA-28
Elastic form				
Flexural modulus, MPa	4798	4798	4948	ISO 178
Tensile modulus, MPa	8076	8076	8226	ISO 527
Thermo-mechanical properties				
HDT, ° C	73 ± 5	73 ± 5	73 ± 5	IMIA-50
TG,° C	63 ± 5	63 ± 5	70 ± 5	ASTM D3418

(*) on specimens hardened for 24 hours at 23°C and post-hardened for 3 hours at 80°C

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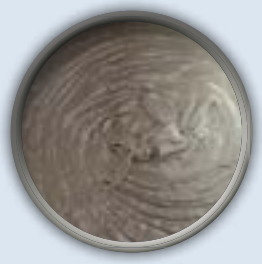
G1
BONDING PASTE FOR ASSEMBLY

Reinforced polyester bonding paste with mineral fibres. Formulated for the composite industry with good mechanical, thermal and chemical resistance and excellent anchorage to the support: it is used for the assembling, repairing and puttying of semi-finished parts and fibreglass products.
With a double catalyst system, it can be used both with paste hardener and with liquid catalyst to meet every requirement of the working cycle.

SUPPORTS
Polyester and vinyl ester Fibreglass laminates

GENERAL USE INDICATIONS
Apply on clean, sanded surfaces; make sure that the support is free of dust, fibres, dirt and surface condensation.
Thoroughly mix the bonding paste with 1.0 - 3.0% of paste hardener (benzoyl peroxide) or 1.0 - 2.0% of liquid catalyst (methyl ethyl ketone peroxide), keeping in mind that the quantity of needed depends on the required operation Temperature and the processing times. The recommended operating temperature interval is between 12 and 30 °C.
It is applied manually with a spatula.
In its original packaging the product is stable for 12 months when stored in a dry place at temperatures not exceeding 20°C.

TYPICAL SPECIFICATIONS OF THE LIQUID PRODUCT	Value	Method
Colour	Gray	IMIA-01
Weight density, @ 23°C, g/litro	1560 ± 50	IMIA-02
Solid content, % by weight	84 ± 2	IMIA-03
Reactivity @ 23°C		
– Gel time, minutes	30 ± 5	
100 g. bonding paste + 1,50 g. MEKP (50%)		IMIA-15
– Gel time, minutes	6 ± 1	
100 g. bonding paste + 1,50 g. BPO 50% in paste		



CARATTERISTICHE TIPICHE DEL PRODOTTO INDURITO con MEKP(*)	Value	Method
Surface hardness		
Shore D	80	IMIA-29
Elastic form		
Flexural modulus, MPa	3050	ISO 178
Tensile modulus, MPa	4351	ISO 527
Thermo-mechanical properties		
HDT, ° C	51 ± 5	IMIA-50

(*) on specimens hardened for 24 hours at 25°C and post-hardened for 3 hours at 80°C

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G2 / G2B

UNIVERSAL ASSEMBLING BONDING PASTE / UNIVERSAL ASSEMBLING BONDING PASTE WHITE

Bonding paste of general purpose based on unsaturated polyester resins reinforced with mineral fibers.
G2 is a bonding paste formulated for assembling glass-reinforced plastic laminates and joining or filling different materials. It can be used for positioning bulkheads and ceilings, for tacking longitudinal members to the hull.
High bonding power, good workability and thixotropy.
It is recommended when it is not required a direct outside exposure.

GENERAL USE INDICATIONS

Apply on a clean and free of dust surface.
Mix well with the specific hardener paste (benzoyl peroxide BPO). The recommended percentage of hardener is 1,0 - 3,0%, depending on the ambient temperature and the required working times. The recommended ambient temperature of working is between 12 and 30 °C.
Apply by hand with a spatula
Can be sanded 20 minutes after the application at 23°C
When stored in the original, sealed cans at a temperature of less than 20°C, the product is stable at least 12 months.

TYPICAL SPECIFICATIONS OF THE LIQUID PRODUCT	Value	Method
Colour	Gray / White	IMIA-01
Weight density, @ 23°C, g/litro	1650 ± 50	IMIA-02
Solid content, % by weight	85 ± 2	IMIA-03
Reactivity @ 23°C		
– Gel time, minutes	7 ± 2	IMIA-15
100 g. bonding paste + 1,50 g. BPO 50% in paste		

G2

G2B

TYPICAL CHARACTERISTICS OF THE HARDENED PRODUCT (*)	Value	Method
Surface hardness		
Shore D	75	IMIA-29
Elastic form		
Flexural modulus, MPa	3035	ISO 178
Tensile modulus, MPa	6010	ISO 527
Thermo-mechanical properties		
HDT, ° C	55 ± 5	IMIA-50

(*) on specimens hardened for 24 hours at 25°C and post-hardened for 3 hours at 80°C

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G2RL

UNIVERSAL ASSEMBLING BONDING PASTE

Bonding paste of general purpose based on unsaturated polyester resins reinforced with mineral fibers.
G2 is a bonding paste formulated for assembling glass-reinforced plastic laminates and joining or filling different materials. It can be used for positioning bulkheads and ceilings, for tacking longitudinal members to the hull.
High bonding power, good workability and thixotropy.
It is recommended when it is not required a direct outside exposure.

GENERAL USE INDICATIONS

Apply on a clean and free of dust surface.
Thoroughly mix the putty with 1.0 - 3.0% of catalyst paste (benzoyl peroxide) or 1.0 - 2.0% of liquid catalyst (methyl ethyl ketone peroxide), keeping in mind that the quantity of catalyst needed depends on the required operation Temperature and the processing times. The recommended operating temperature interval is between 12 and 30 °C.
Apply by hand with a spatula
Can be sanded 20 minutes after the application at 23°C
When stored in the original, sealed cans at a temperature of less than 20°C, the product is stable at least 12 months.

TYPICAL SPECIFICATIONS OF THE LIQUID PRODUCT		
	Value	Method
Colour	Gray	IMIA-01
Weight density, @ 23°C, g/litro	1650 ± 50	IMIA-02
Solid content, % by weight	85 ± 2	IMIA-03
Reactivity @ 23°C		
– Gel time, minutes	7 ± 1	
100 g. bonding paste + 1,50 g. BPO 50% in paste		IMIA-15
– Gel time, minutes	30 ± 5	
100 g. bonding paste + 1,50 g. MEKP 50% in paste		

TYPICAL CHARACTERISTICS OF THE HARDENED PRODUCT (*)		
	Value	Method
Hardness, Shore D	75	IMIA-29
Elastic form		
Flexural modulus, MPa	3035	ISO 178
Tensile modulus, MPa	6010	ISO 527
Thermo-mechanical properties HDT, ° C	55 ± 5	IMIA-50

(*) on specimens hardened for 24 hours at 23°C and post-hardened for 3 hours at 80°C

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G3 / G3C

BONDING PASTE FOR ASSEMBLING / BONDING PASTE FOR ASSEMBLING CLEAR

Bonding paste based on unsaturated polyester resins reinforced with mineral fibres. G3 is a bonding paste formulated for use on glass-reinforced plastic laminates and in various applications in the composite sector. It is excellent for filling of edges and curves, for positioning bulkheads and ceilings and for tacking longitudinal members to the hull.
Main features are high workability, optimum mechanical strength and strong bonding power.
G3 contains a colour-changing additive to check the homogeneous dispersion of the peroxide into the product during the catalysis.

SUPPORTS

Laminates polyester and vinylester fibreglass, wood.

GENERAL USE INDICATIONS

Apply on a clean and free of dust surface. Mix well with the specific liquid hardener (methyl ethyl ketone peroxide). The recommended percentage of hardener is 1,0 - 2,0%, depending on the ambient temperature and the required working times.
The recommended ambient temperature of working is between 12 and 30 °C.
Apply with a spatula or with the aid of an extrusion and mixing machine.
When stored in the original, sealed cans at a temperature less than 20°C, the product is stable at least 12 months.

TYPICAL SPECIFICATIONS OF THE LIQUID PRODUCT	Value	Method
Colour	Light blue color changing (G3 / colourless (G3C)	IMIA-01
Weight density, @ 23°C, g/litro	1300 ± 50	IMIA-02
Solid content, % by weight	74 ± 2	IMIA-03
Reactivity @ 23°C		
– Gel time, minutes	35 ± 5	IMIA-15
100 g. bonding paste + 1,50 g. MEKP 50%		
Min. sanding time at 23°, minutes	20	IMIA-55

TYPICAL CHARACTERISTICS OF THE HARDENED PRODUCT (*)	Value	Method
Linear shrinkage @ 23° C, %	0,8	IMIA-25
Surface hardness		
Shore D	86 ± 3	IMIA-29
Barcol	45 ± 3	IMIA-28
Elastic form		
Flexural modulus, MPa	86 ± 3	ISO 178
Tensile modulus, MPa	86 ± 3	ISO 527
Thermo-mechanical properties		
HDT, ° C	55 ± 5	IMIA-50
TG,° C	66 ± 5	ASTM D3418
(*) on specimens hardened for 24 hours at 25°C and post-hardened for 3 hours at 80°C		

G3

G3C

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G3L

BONDING PASTE FOR ASSEMBLING LIGHT

Bonding paste based on unsaturated polyester resins reinforced with mineral fibres. G3 is a bonding paste formulated for use on glass-reinforced plastic laminates and for various applications in the composite sector. It is excellent for filling of edges and curves, for positioning bulkheads and ceilings and for tacking longitudinal members to the hull.
It has a low density (aproximately 0,75 kg/l). Main features are high workability, optimum mechanical strength and strong bonding power. No shrinkage.
G3 contains a colour-changing additive to check the homogeneous dispersion of the peroxide into the product during the catalysis.

SUPPORTS

Laminates polyester and vinylester fibreglass, wood.

GENERAL USE INDICATIONS

Apply on a clean and free of dust surface. Mix well with the specific liquid hardener (methyl ethyl ketone peroxide). The recommended percentage of hardener is 1,0 - 2,0%, depending on the ambient temperature and the required working times.
The recommended ambient temperature of working is between 12 and 30 °C.
Apply with a spatula or with the aid of an extrusion and mixing machine.
When stored in the original, sealed cans at a temperature less than 20°C, the product is stable at least 12 months.

TYPICAL SPECIFICATIONS OF THE LIQUID PRODUCT	Value	Method
Colour	Light blue color changing	IMIA-01
Weight density, @ 23°C, g/litro	740 ± 50	IMIA-02
Solid content, % by weight	63 ± 2	IMIA-03
Reactivity @ 23°C		
– Gel time, minutes	30 ± 5	IMIA-15
100 g. bonding paste + 1,50 g. MEKP 50%		

TYPICAL CHARACTERISTICS OF THE HARDENED PRODUCT (*)	Value	Method
Surface hardness		
Shore D	65 ± 5	IMIA-29
Thermo-mechanical properties		
TG,° C	61 ± 5	ASTM D3418
(*) on specimens hardened for 24 hours at 25°C and post-hardened for 3 hours at 80°C		

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G4 / G4C

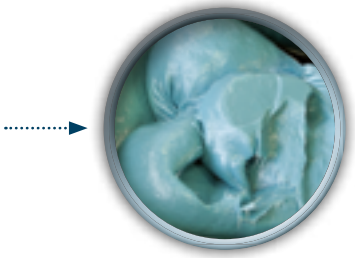
POLYFIBER BONDING PASTE / POLYFIBER BONDING PASTE CLEAR

Bonding paste based on unsaturated polyester resins reinforced with mineral fibres.
G4 is a bonding paste formulated for use on glass-reinforced plastic laminates. It is excellent for filling of edges and curves, for positioning bulkheads and ceilings and for tacking longitudinal members to the hull.
Main features are high workability, optimum mechanical strength and strong bonding power.
G4 contains a colour-changing additive to check the homogeneous dispersion of the peroxide into the product during the catalysis.
Fibers length 3-6 mm.

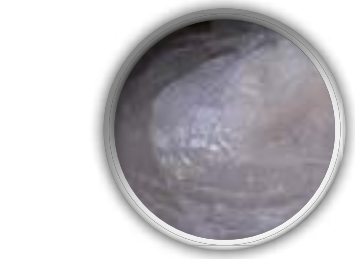
GENERAL USE INDICATIONS

Apply on a clean and free of dust surface.
Mix well with the specific liquid hardener (methyl ethyl ketone peroxide). The recommended percentage of hardener is 1,0 - 2,0%, depending on the ambient temperature and the required working times. The recommended ambient temperature of working is between 12 and 30 °C.
Apply with a spatula or with the aid of an extrusion and mixing machine.
When stored in the original, sealed cans at a temperature less than 20°C, the product is stable at least 12 months.

TYPICAL SPECIFICATIONS OF THE LIQUID PRODUCT	Value	Method
Colour	Light blue color changing (G4 / colorless (G4C)	IMIA-01
Weight density, @ 23°C, g/litro	1300 ± 50	IMIA-02
Solid content, % by weight	74 ± 2	IMIA-03
Reactivity @ 23°C		
– Gel time, minutes	35 ± 5	IMIA-15
100 g. bonding paste + 1,50 g. MEKP 50%		



G4



G4C

TYPICAL CHARACTERISTICS OF THE HARDENED PRODUCT (*)	Value	Method
Linear shrinkage @ 23°C, %	0,8	IMIA-25
Surface hardness		
Shore D	85 ± 3	IMIA-29
Barcol	45 ± 3	IMIA-28
Elastic form		
Flexural modulus, MPa	3968	ISO 178
Tensile modulus, MPa	7228	ISO 527
Thermo-mechanical properties		
HDT, ° C	58 ± 5	IMIA-50
TG,° C	73 ± 5	ASTM D3418
(*) on specimens hardened for 24 hours at 25°C and post-hardened for 3 hours at 80°C		

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G4L

POLYFIBER BONDING PASTE LIGHT

Bonding paste based on unsaturated polyester resins reinforced with mineral fibres.
G4 is a bonding paste formulated for use on glass-reinforced plastic laminates. It is excellent for filling of edges and curves, for positioning bulkheads and ceilings and for tacking longitudinal members to the hull.
Main features are high workability, optimum mechanical strength and strong bonding power.
G4 contains a colour-changing additive to check the homogeneous dispersion of the peroxide into the product during the catalysis.
Fibers length 3-6 mm.

GENERAL USE INDICATIONS

Apply on a clean and free of dust surface.
Mix well with the specific liquid hardener (methyl ethyl ketone peroxide). The recommended percentage of hardener is 1,0 - 2,0%, depending on the ambient temperature and the required working times. The recommended ambient temperature of working is between 12 and 30 °C.
Apply with a spatula or with the aid of an extrusion and mixing machine.
When stored in the original, sealed cans at a temperature less than 20°C, the product is stable at least 12 months.

TYPICAL SPECIFICATIONS OF THE LIQUID PRODUCT	Value	Method
Colour	Light blue colour-changing	IMIA-01
Weight density, @ 23°C, g/litro	740 ± 50	IMIA-02
Solid content, % by weight	63 ± 2	IMIA-03
Reactivity @ 23°C		
– Gel time, minutes	30 ± 5	IMIA-15
100 g. bonding paste + 1,50 g. MEKP 50%		

TYPICAL CHARACTERISTICS OF THE HARDENED PRODUCT (*)	Value	Method
Linear shrinkage @ 23°C, %	0,8	IMIA-25
Surface hardness		
Shore D	68 ± 3	IMIA-29
Thermo-mechanical properties		
TG,° C	64 ± 5	ASTM D3418

(*) on specimens hardened for 24 hours at 25°C and post-hardened for 3 hours at 80°C

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G6

BONDING PASTE FOR ASSEMBLY

Bonding paste based on unsaturated polyester resins reinforced with special microfiber minerals. It has good mechanical, thermal and chemical resistance and excellent anchorage to the support. In the composite industry it represents a practical and affordable solution for the assembling of the skeleton of the model, the welding of rails, the fastening of bulkheads and bonding of controstampate and ceilings. It can be used with paste hardener or liquid paste.

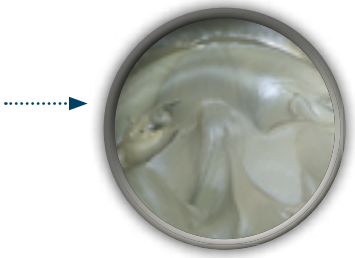
SUPPORTS

Polyester and vinyl ester Fibreglass.

GENERAL USE INDICATIONS

Apply on clean, sanded surfaces; make sure that the support is free of dust, fibres, dirt and surface condensation.
Thoroughly mix the putty with 1.0 - 3.0% of catalyst paste (benzoyl peroxide) or 1.0 - 2.0% of liquid catalyst (methyl ethyl ketone peroxide), keeping in mind that the quantity of catalyst needed depends on the required operation Temperature and the processing times. The recommended operating temperature interval is between 12 and 30 °C.
It is applied manually with a spatula after thorough mixing of the catalyst.
In its original packaging the product is stable for 12 months when stored in a dry place at temperatures not exceeding 20°C.

TYPICAL SPECIFICATIONS OF THE LIQUID PRODUCT		
	Value	Method
Colour	Gray	IMIA-01
Weight density, @ 23°C, g/litro	1700 ± 50	IMIA-02
Solid content, % by weight	85 ± 2	IMIA-03
Reactivity @ 23°C		
– Gel time, minutes	5 ± 1	
100 g. bonding paste + 1,50 g. BPO 50% in paste		IMIA-15
– Gel time, minutes	30 ± 5	
100 g. bonding paste + 1,50 g. MEKP 50%		



TYPICAL CHARACTERISTICS OF THE HARDENED PRODUCT (*)		
	Value	Method
Surface hardness		
Shore D	80	IMIA-29
Elastic form		
Flexural modulus, MPa	3782	ISO 178
Tensile modulus, MPa	8815	ISO 527
Thermo-mechanical properties		
HDT, ° C	54 ± 5	IMIA-50
TG	64 ± 5	ASTM D3418

(*) on specimens hardened for 24 hours at 25°C and post-hardened for 3 hours at 80°C

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G7

INDUSTRIAL BONDING PASTE WITH MICROFIBRES

Multipurpose bonding paste based on unsaturated polyester resins reinforced with microfibers, easily spreadable and with good mechanical, adhesion, sanding and flexibility properties. It is used for the filling, assembling, levelling of fibreglass products.

SUPPORTS

Polyester and vinyl ester Fibreglass.

GENERAL USE INDICATIONS

Apply on clean, sanded surfaces; make sure that the support is free of dust, fibres, dirt and surface condensation.
Thoroughly mix the putty 1.0 - 2.0% of liquid catalyst (methyl ethyl ketone peroxide), keeping in mind that the quantity of catalyst needed depends on the required operation Temperature and the processing times. The recommended operating temperature interval is between 12 and 30 °C.
It is applied manually with a spatula after thorough mixing of the catalyst. For quantities greater than 5 kg it is recommended mixing with a whisk.
In its original packaging the product is stable for 12 months when stored in a dry place at temperatures not exceeding 20°C.

TYPICAL SPECIFICATIONS OF THE LIQUID PRODUCT	Value	Method
Colour	Blu color changing	IMIA-01
Weight density, @ 23°C, g/litro	1700 ± 50	IMIA-02
Solid content, % by weight	83 ± 2	IMIA-03
Reactivity @ 23°C		
– Gel time, minutes	30 ± 5	IMIA-15
100 g. bonding paste + 1,50 g. MEKP 50%		

TYPICAL CHARACTERISTICS OF THE HARDENED PRODUCT (*)	Value	Method
Surface hardness Shore D	80	IMIA-29
Barcol	35	IMIA-28
Thermo-mechanical properties		
HDT, ° C	56 ± 5	IMIA-50
(*) on specimens hardened for 24 hours at 25°C and post-hardened for 3 hours at 80°C		

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G8

INDUSTRIAL BONDING PASTE WITH FIBRES

Multipurpose bonding paste based on unsaturated polyester resins reinforced with fibres, easily spreadable and with good mechanical, adhesion, sanding and flexibility properties. It is used for the filling, assembling, levelling of fibreglass products.
Fibers length 3-6 mm.

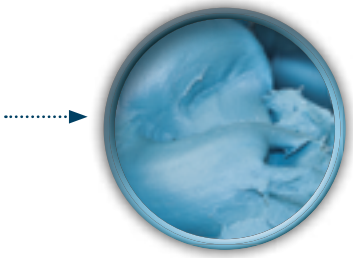
SUPPORTS

Polyester and vinyl ester Fibreglass.

GENERAL USE INDICATIONS

Apply on clean, sanded surfaces; make sure that the support is free of dust, fibres, dirt and surface condensation.
Thoroughly mix the putty 1.0 - 2.0% of liquid catalyst (methyl ethyl ketone peroxide), keeping in mind that the quantity of catalyst needed depends on the required operation Temperature and the processing times. The recommended operating temperature interval is between 12 and 30 °C.
It is applied manually with a spatula after thorough mixing of the catalyst. For quantities greater than 5 kg it is recommended mixing with a whisk.
In its original packaging the product is stable for 12 months when stored in a dry place at temperatures not exceeding 20°C.

TYPICAL SPECIFICATIONS OF THE LIQUID PRODUCT	Value	Method
Colour	Blu color changing	IMIA-01
Weight density, @ 23°C, g/litro	1700 ± 50	IMIA-02
Solid content, % by weight	84 ± 3	IMIA-03
Reactivity @ 23°C		
– Gel time, minutes	30 ± 5	IMIA-15
100 g. bonding paste + 1,50 g. MEKP 50%		



TYPICAL CHARACTERISTICS OF THE HARDENED PRODUCT (*)	Value	Method
Surface hardness		
Shore D	80 ± 3	IMIA-29
Barcol	35 ± 3	IMIA-28

(*) on specimens hardened for 24 hours at 25°C and post-hardened for 3 hours at 80°C

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GV20

VINYL ESTER BONDING PASTE WITH FIBRES

Reinforced vinyl ester structural bonding paste with glass fibres. Specifically formulated to assemble and repair printed and fibreglass products, it is also used during the laminating phases for radiusing the corners and the filling of joints due to its excellent adhesion to the support and its high mechanical and antiosmosis properties. Catalysis with viracolore.
Fibers length 3-6 mm.

SUPPORTS

Polyester and vinyl ester Fibreglass laminates

GENERAL USE INDICATIONS

Apply on clean, sanded surfaces; make sure that the support is free of dust, fibres, dirt and surface condensation.
Thoroughly mix the mastic 1.0 - 2.0% of liquid catalyst (methyl ethyl ketone peroxide), keeping in mind that the quantity needed depends on the required operation Temperature and the processing times. The recommended operating temperature interval is between 12 and 30 °C.
It is applied manually with a spatula. For quantities greater than 5 kg it is recommended mixing with a whisk; for 200 litre drums the aid of an pressing plate extruder-mixer ensures better mixing efficiency.
In its original packaging the product is stable for 6 months when stored in a dry place at temperatures not exceeding 20°.

TYPICAL SPECIFICATIONS OF THE LIQUID PRODUCT	Value	Method
Colour	Blu color changing	IMIA-01
Density, @ 23°C, g/litro	1350 ± 50	IMIA-02
Solid content, % by weight	76 ± 2	IMIA-03
Reactivity @ 23°C		
– Gel time, minutes	35 ± 5	IMIA-15
100 g. bonding paste + 1,50 g. MEKP 50%		

TYPICAL CHARACTERISTICS OF THE HARDENED PRODUCT (*)	Value	Method
Linear shrinkage, %	0,1	IMIA-25
Surface hardness		
Shore D	87	IMIA-29
Barcol	45	IMIA-28
Elastic form		
Flexural modulus, MPa	5109	ISO 178
Tensile modulus, MPa	9099	ISO 527
Thermo-mechanical properties		
HDT, ° C	85 ± 5	IMIA-50
TG,° C	90 ± 5	ASTM D3418
Water absorption % After 24 hours of immersion at 80°	0,23	IMIA-46

(*) on specimens hardened for 24 hours at 23°C and post-hardened for 3 hours at 80°C

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GV21

VINYLESTER BONDING PASTE WITH MICROFIBRES

Structural vinylester bonding paste reinforced with mineral fibres. GV21 is a putty formulated to repair or finishing molded and the fiberglass objects; it's usually used for various applications in the composite sector. It is excellent for filling of edges, curves, and joints, specially due to its excellent adhesion, mechanical and anti osmosis properties.
GV21 contains a colour-changing additive to check the homogeneous dispersion of the peroxide into the product during the catalysis.

SUPPORTS

Laminates polyester and vinylester fibreglass.

GENERAL USE INDICATIONS

Apply on clean, sanded surfaces; make sure that the support is free of dust, fibres, dirt and surface condensation.
Thoroughly mix the mastic 1.0-2.0% of liquid catalyst (methyl ethyl ketone peroxide), keeping in mind that the quantity needed depends on the required operation Temperature and the processing times. The recommended operating temperature interval is between 12 and 30° C.
It is applied manually with a spatula. For quantities greater than 5 kg it is recommended mixing with a whisk; or 200 litres drums the aid of an pressing plate extruder-mixer ensures better mixing efficiency.
In its original packaging the product is stable for 6 months when stored in a dry place at temperature not exceeding 20°.

TYPICAL SPECIFICATIONS OF THE LIQUID PRODUCT	Value	Method
Colour	Blu color changing	IMIA-01
Weight density, @ 23°C, g/litro	1350 ± 50	IMIA-02
Solid content, % by weight	75,3	IMIA-03
Reactivity @ 23°C		
– Gel time, minutes	35 ± 5	IMIA-15
100 g. bonding paste + 1,50 g. MEKP 50%		

TYPICAL CHARACTERISTICS OF THE HARDENED PRODUCT (*)	Value	Method
Linear shrinkage @ 23° C, %	0,1	IMIA-25
Surface hardness		
Shore D	85	IMIA-29
Barcol	40	IMIA-28
Elastic form		
Flexural modulus, MPa	4379	ISO 178
Tensile modulus, MPa	8130	ISO 527
Thermo-mechanical properties		
HDT, ° C	88 ± 5	IMIA-50
TG,° C	100 ± 5	ASTM D3418
Water absorption after 24hours under water at 80°C.	0,3	IMIA-46

(*) on specimens hardened for 24 hours at 23°C and post-hardened for 3 hours at 80°C

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Bonding pastes
for core materials

COMPOSITE

professional Composite line

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PRODUCTS FOR
COMPOSITE INDUSTRY

B07
BONDER EXTRA LIGHT

Bonder extra light based on unsaturated polyester resins, with ultra-light reinforcing fillers and micro-balls.
B07 is a bonder formulated for gluing core materials in PVC, PET, PIR or polyurethane of glass-reinforced plastic parts and for gluing panels of balsa and termanto. It is excellent where light weight, low shrinkage and bonding capacity are essential.
Main features are optimum application tixotrophy, excellent disaeration and strong bonding power.

GENERAL USE INDICATIONS

B07 must be mixed with the specific liquid hardener (methyl ethyl ketone peroxide). The recommended percentage of hardener is 1,0 - 2,0%, based on the ambient temperature and the required working times. The recommended ambient temperature is between 16 and 28 °C.
B07 contains a changing colour additive to check the homogeneous dispersion of the peroxide into the product. Apply B07 directly over a clean, free of dust surface laminated a short time before. If the surface is completely cured, sand and clean very well before application.
Apply with a spatula or with the aid of an extrusion and mixing machine.
When stored in the original, sealed container at a temperature less than 20°C, the product is stable at least 6 months.

TYPICAL SPECIFICATIONS OF THE LIQUID PRODUCT	Value	Method
Colour	Light blue colour-changing	IMIA-01
Weight density, @ 23°C, g/litro	700 ± 50	IMIA-02
Solid content, % by weight	66,8 ± 2	IMIA-03
Reactivity @ 23°C		
– Gel time, minutes	45 ± 10	IMIA-15
100 g. bonding paste + 1,50 g. MEKP 50%		

TYPICAL CHARACTERISTICS OF THE HARDENED PRODUCT (*)	Value	Method
Linear shrinkage @ 23°C, %	0,50	IMIA-25
Hardness, shore-D	70 ± 5	IMIA-29
Thermo-mechanical properties HDT, ° C	57 ± 5	IMIA-50
TG,° C	64 ± 5	ASTM D3418

(*) on specimens hardened for 24 hours at 23°C and post-hardened for 3 hours at 80°C

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B10
BONDER LIGHT

Bonder light based on unsaturated polyester resins, with light reinforcing fillers and micro-balls.
B10 is a bonder formulated for gluing core materials in PVC, PET, PIR or polyurethane, panels of balsa and termanto and glass-reinforced plastic parts.
It is excellent where light weight, low shrinkage and bonding capacity are essential.
Main features are optimum application thixotropy, excellent disaeration and strong bonding power.

GENERAL USE INDICATIONS

B10 must be mixed with the specific liquid hardener (methyl ethyl ketone peroxide). The recommended percentage of hardener is 1,0 - 2,0%, based on the ambient temperature and the required working times. The recommended ambient temperature of working is between 16 and 28 °C.
B10 contains a changing colour additive to check the homogeneous dispersion of the peroxide into the product.
Apply B10 directly over a clean, free of dust surface laminated a short time before. If the surface is completely cured, sand and clean very well before application.
Apply with a spatula or with the aid of an extrusion and mixing machine.
When stored in the original, sealed container at a temperature less than 20°C, the product is stable at least 6 months.

TYPICAL SPECIFICATIONS OF THE LIQUID PRODUCT	Value	Method
Colour	Light blue colour-changing	IMIA-01
Weight density, @ 23°C, g/litro	1000 ± 50	IMIA-02
Solid content, % by weight	71 ± 2	IMIA-03
Reactivity @ 23°C		
– Gel time, minutes	40 ± 10	IMIA-15
100 g. bonder + 1,50 g. MEKP 50%		

TYPICAL CHARACTERISTICS OF THE HARDENED PRODUCT (*)	Value	Method
Linear shrinkage @ 23°C, %	0,80	IMIA-25
Hardness, shore-D	70 ± 5	IMIA-29
Flexural modulus, MPa	3250	ISO 178
Tensile modulus, MPa	4059	ISO 527
Thermo-mechanical properties		
HDT, ° C	70 ± 5	IMIA-50
TG,° C	70 ± 5	ASTM D3418
(*) on specimens hardened for 24 hours at 23°C and post-hardened for 3 hours at 80°C		

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BV10 / BV10S

VINYLBONDER LIGHT / VINYLBONDER LIGHT SLOW

Adhesive bonding paste for foams based on unsaturated vinyl ester resins, microspheres and soft reinforcing fibres. Specifically formulated for the composite industry for the bonding of plates and inserts in Balsa, PVC, PET and PIR and Polyurethane foams in buildings that require maximum adhesive performance and/or the highest thermal resistances during exposure of the boat to the sun. It spatulas and disarea easily without dripping from vertical surfaces. Under pressure or vacuum it flows easily, saturating every slot and crevice of the foam thus ensuring high mechanical, thermal and chemical properties to the laminate sandwich. At the low specific weight of its formulation, retreats are added that are contained during the hardening phase.

SUPPORTS

properly prepared and cleaned laminates in Polyester and Vinyl ester Fibreglass.

GENERAL USE INDICATIONS

Directly applicable onto fresh laminate surfaces free of dust, fibres, dirt and condensation. The completely hardened surfaces have to be sanded and cleaned thoroughly. Determine the suitability for use on surfaces obtained from paraffin resins.
Mix Vinylbonder Light directly in its package and mix it with 1.0 to 2.0% of liquid catalyst (methyl ethyl ketone peroxide), bearing in mind that the amount of catalyst selected depends on the required operating Temperature and processing times. The recommended operating Temperature interval is between 16 and 28°C. The product contains viracolor in order to verify the homogeneous dispersion of the peroxide.
It is applied manually with a spatula. For quantities greater than 5 kg it is recommended mixing with a whisk, while for 200 litre drums the use of an extruder-mixer pressing plate provides the best mixing efficiency. The product was also formulated to be sprayed, where large areas of the yacht or rapid cycles of mass production so require. For more details and recommended application procedures refer directly to the "User's manual of Adhesives Bonding pastes", available at the INTEC Technical After-Sales Service Centre.
In its original packaging the product is stable for 6 months in storage at temperatures not exceeding 20°C.

TYPICAL SPECIFICATIONS OF THE LIQUID PRODUCT

	Value BV10	Value BV10S	Method
Colour	Light blue colour-changing	Light blue colour-changing	IMIA-01
Weight density, @ 23°C, g/litro	1030 ± 50	1030 ± 50	IMIA-02
Solid content, % by weight	72 ± 2	72 ± 2	IMIA-03
Reactivity @ 23°C			
– Gel time, minutes	50 ± 10	120 ± 10	IMIA-15
100 g. bonder + 1,50 g. MEKP 50%			

TYPICAL CHARACTERISTICS OF THE HARDENED PRODUCT (*)

	Value BV10	Value BV10S	Method
Linear shrinkage @ 23°C, %	0,30	0,30	IMIA-25
Surface hardness			
Shore D	70	70	IMIA-29
Elastic form			
Flexural modulus, MPa	3279	3279	ISO 178
Tensile modulus, MPa	4392	4392	ISO 527
Thermo-mechanical properties			
HDT, ° C	90 ± 5	90 ± 5	IMIA-50
TG,° C	95 ± 5	95 ± 5	ASTM D3418
(*) on specimens hardened for 24 hours at 23°C and post-hardened for 3 hours at 80°C			

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Tooling pastes

and putties for tooling pastes refinishing

COMPOSITE

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PRODUCTS FOR
COMPOSITE INDUSTRY

Tooling pastes

ITEM CODE	ITEM NAME	PACKAGING	COLOR	APPLICATION	TYPE OF HARDENER
PF07E	POLYESTER TOOLING PASTE LIGHT	LT 200 - KG 140	azure	extrusion	CT22
PF10E	POLYESTER TOOLING PASTE	LT 200 - KG 200	azure	extrusion	CT22
PV10E	VINYLESTER TOOLING PASTE	LT 200 - KG 200	azure	extrusion	CT22
PV10HT	VINYLESTER TOOLING PASTE FOR HIGH TEMPERATURE	LT 200 - KG 200	azure	extrusion	CT22
PF07LS	LOW STYRENE CONTENT TOOLING PASTE LIGHT	LT 200 - KG 140	yellow	extrusion	CT22
PF07GT	STYRENE FREE TOOLING PASTE LIGHT	LT 200 - KG 140	green	extrusion	CT22
PF10GT	STYRENE FREE TOOLING PASTE	LT 200 - KG 200	green	extrusion	CT22
PF10	POLYESTER TOOLING PASTE	LT 200 - KG 200	azure	spray	CT22

Putties for tooling pastes refinishing

ITEM CODE	ITEM NAME	PACKAGING	COLOR	APPLICATION	TYPE OF HARDENER
SF07	Body filler light for tooling pastes finishing	Lt. 4 - Kg. 2,8	Azure	spatula	CT 22
SF10	Body filler for tooling pastes finishing	Lt. 4 = Kg. 4	Azure	spatula	CT 22

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Primers

COMPOSITE

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PRODUCTS FOR
COMPOSITE INDUSTRY

SK4 / SK4B

FILLER SPRAY GREY (SK4) / WHITE (SK4B)

Polyester spray filler for the model finishing. It allows the application of high thicknesses even on one hand spray in different cross. Product with low shrinkage, easy to sand and excellent adhesion on fiberglass and wood supports; it is compatible with all paints currently available on the market.

SUPPORTS

Fiberglass sanded laminates, impregnated wood, polyester putties.

GENERAL USE INDICATIONS

Apply on clean, sanded surfaces; make sure that the supApply on clean, sanded surfaces; make sure that the support is free of dust, fibres, dirt and surface condensation. On the sheets, remove any residual oxide, degrease with antisilicone solvent.

Dilute with acetone or MEK 0-10% in volume and after Thoroughly mix the above mentioned solution with 3.0 - 4.0% of liquid catalyst CT20 (cycloexanone peroxide), keeping in mind that the required catalyst quantity depends on the required operating temperature and the processing times.

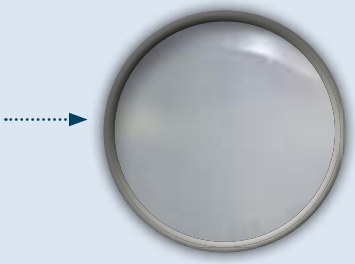
Leave bleed the product few minutes before to spray; application time of the hardened products is from 20 to 30 minutes at 23°C and depending on the used % catalyst.

Typical application with an airbrush: 300-400 microns in one hand be applied in two layers, up to a maximum thickness of 1200-1500 microns; nozzle diameter 2.5 mm; air pressure 3.5 bar. Can be sanded after 6 hours after application at 23°C. Paintable with polyester gelcoat or paint after 8 hours: with other paints after 24 hours. Typical cycle of dry sanding, grit: P220-P320-P400-P600-P800-P1200. The theoretical yield per m² for 1000 microns dry thickness is approximately 1.8 kg.

In its original packaging the product is stable for 12 months when stored in a dry place at temperatures not exceeding 20°C.

TYPICAL SPECIFICATIONS OF THE LIQUID PRODUCT

	Value	Method
Colour	Gray (SK4) / White (SK4B)	IMIA-01
Weight density, @ 23°C, g/litro	1600 ± 50	IMIA-02
Solid content, % by weight	76 ± 2	IMIA-03
Viscosity, Ford cup 8 @ 20°C, s.	5 ± 1	IMIA-12
Reactivity @ 23°C – Pot life, min. 100 g. filler + 3,50 g. CT20	25	IMIA-15



SK4

SK4B

TYPICAL CHARACTERISTICS OF THE HARDENED PRODUCT (*)

	Value	Method
Gloss index	50	IMIA-70
Thermo-mechanical resistance HDT, ° C	48 ± 5	IMIA-50
Hardness, shore-D 70 IMIA-29	65	IMIA-29

(*) on specimens hardened for 24 hours at 23°C and post-hardened for 3 hours at 80°C

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FP10 (WHITE) / FP11 (GRAY)

POLISHING FINISHING FILLER

Finishing filler based on high quality unsaturated polyester resins.
FP10 / FP11 is a filler formulated for the spray finishing of moulds, optimum for the finishing of polyester or polyurethane milled pastes.
FP10 / FP11 can be applied in thick layers in several coats, with good thixotropy and fast drying. Can be polished to reach a good grade of gloss and, when specifically required, can be overpainted.

SUPPORTS

Sanded fiberglass, wood, MDF, polyester putties, milled pastes.

GENERAL USE INDICATIONS

Apply on a clean and free of dust surface.
If necessary, dilute with acetone or MEK (max. 10%).
Add additives to the solution obtnained with 1% - 2% of liquid catalyst CT21 (MEKP peroxide, Butanox M50 or equivalent product) and mix thoroughly, keeping in mind that the quantity of catalyst needed depends on the required operation temperature and the processing times. Leave the product to de-aerate for a few minutes before applying it; the applicability time of the catalyzed product varies from 20 to 30 minutes at 23°C. according to the quantity of catalyst used. The recommended operation temperature interval is between 16 and 28°C.
Typical application with an airbrush: 300-400 microns in one hand be applied in two layers, up to a maximum thickness of 1200-1500 microns; nozzle diameter 2.5 mm; air pressure 3.5 bar.
Can be sanded after 3 hours after application at 23°C. Paintable with polyester gelcoat or paint after 4 hours; with other paints after 24 hours.
Typical cycle of dry sanding, grit: P220-P320-P400-P600-P800-P1200.
The theoretical yield per m^2 for 1000 microns dry thickness is approximately 1.8 KG.
In this original packaging the product is stable for 12 months when stored in a dry place at temperatures not exceeding 20°C.

TYPICAL SPECIFICATIONS OF THE LIQUID PRODUCT

	Value	Method
Colour	White (FP10 / Gray (FP11)	IMIA-01
Weight density, @ 23°C, g/litro	1500 ± 50	IMIA-02
Solid content, % by weight	71 ± 2	IMIA-03
Viscosity, Ford cup 8 @ 20°C, s.	40 ± 5	IMIA-12
Reactivity @ 23°C – Pot life, min. 100 g. filler + 1,50 g. MEKP 50%	25 ± 5	IMIA-15

TYPICAL CHARACTERISTICS OF THE HARDENED PRODUCT (*)

	Value	Method
Gloss index	65	IMIA-70
Thermo-mechanical properties		
HDT, ° C	53 ± 5	IMIA-50
Hardness, shore-D	68	IMIA-29

(*) on specimens hardened for 24 hours at 23°C and post-hardened for 3 hours at 80°C

FP10

FP11

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FV20 (WHITE) / FV21 (BLACK) / FV22 (GRAY)
POLISHING FINISHING VINYLESTER FILLER WHITE / GRAY / BLACK

Finishing filler based on vinyl ester resins, formulated for obtaining particularly durable and bright finishing surfaces. Especially popular in the nautical industry for spray finishing of models and pre-series milled mould models. Excellent application on vertical surfaces, it allows to obtain remarkable thicknesses. Thanks to the nature of the vinyl ester polymer, at the end of an appropriate sanding and polishing cycle it achieves an excellent level of gloss, while maintaining its performance even when exposed to the heat of the lamination pack of the moulds. Where required, it can be painted over.

SUPPORTS
Sanded fibreglass, wood, MDF, polyester putties, millable pastes.

GENERAL USE INDICATIONS
Apply on clean, sanded surfaces; make sure that the support is free of dust, fibres, dirt and surface condensation.
Dilute with acetone or MEK from 0 to 10% in volume.
Add additives to the solution obtained with 1,5% - 2%of liquid catalyst CT21 (methyl ethyl ketone peroxide) and mix thoroughly, keeping in mind that the quantity of catalyst needed depends on the required operation Temperature and the processing times. Leave the product to disareare for a few minutes before applying it; the applicability time of the catalyzed product varies from 20 to 30 minutes at 23°C according to of the quantity of catalyst used. The recommended operating temperature interval is between 16 and 28°C.
Typical application with an airbrush: 300-400 microns in one hand be applied in two layers, up to a maximum thickness of 1200-1500 microns; nozzle diameter 2.5 mm; air pressure 3.5 bar.
Can be sanded after 6 hours after application at 23°C. Paintable with polyester gelcoat or paint after 8 hours: with other paints after 24 hours. Typical cycle of dry sanding, grit: P220-P320-P400-P600-P800-P1200.
The theoretical yield per m² for 1000 microns dry thickness is approximately 1.8 kg.
In its original packaging the product is stable for 12 months when stored in a dry place at temperatures not exceeding 20°C.

TYPICAL SPECIFICATIONS OF THE LIQUID PRODUCT

	Value FV20 / FV22	Value FV21	Method
Colour	White / Gray	Black	IMIA-01
Weight density, @ 23°C, g/litro	1500 ± 50	1500 ± 50	IMIA-02
Solid content, % by weight	71 ± 2	70 ± 2	IMIA-03
Viscosity, Ford cup 8 @ 20°C, s.	40 ± 5	35 ± 5	IMIA-12
Reactivity @ 23°C			
– Pot life, min.	25 ± 5	25 ± 5	IMIA-15
100 g. filler + 1,50 g. MEKP 50%"			

TYPICAL CHARACTERISTICS OF THE HARDENED PRODUCT (*)

	Value FV20 / FV22	Value FV21	Method
Gloss index	75	80	IMIA-70
Thermo-mechanical properties			
HDT, ° C	60 ± 5	70 ± 5	IMIA-50
Hardness, shore-D	70	74	IMIA-29

(*) on specimens hardened for 24 hours at 23°C and post-hardened for 3 hours at 80°C

FV20

FV22

FV21

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High Gloss Paints

COMPOSITE

professional Composite line

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PRODUCTS FOR
COMPOSITE INDUSTRY

VHG100 / VHG100B / VHG100G

HIGH GLOSS PAINTS COLORLESS / BLACK / GREY

Finishing varnish based on special polyester resins for obtaining surfaces of exceptional quality.
Specifically formulated for the composite industry where it is used in spray finishing of models with a high level of gloss (High Gloss).
Easy to apply, once dried it allows to obtain a particularly dry and perfectly workable layer of varnish.

SUPPORTS

Sanded polyester and vinyl ester foundations.

GENERAL USE INDICATIONS

Make sure that the surface to be treated is clean and the work area dry, free of dust and silicones.
Add the accelerator solution CT40 based on cobalt promoter at 2% to the varnish.
Mix thoroughly.
Dilute the varnish with the addition of 5 - 15% of MEK solvent (recommended). The dilution % varies depending on the temperature and the spreading of the product to be obtained.
Mix well and slowly to avoid air entrapment.
Finally, add 1 to 2% of MEKP liquid hardener (ex. Butanox M50 or equivalent), always mixing thoroughly.
The product is workable for 15 - 20 minutes in the cup at a dilution of 10% at 23°C.
Apply by spraying, up to a maximum thickness of 500 to 600 microns in 4-6 coats of 100-150 microns each.
Apply each coat with 2 or 3 crossed hands, leaving the product to vent and stretch for 5 minutes between one coat and the next one.
Use a gravity airbrush, with 1.4 - 1.7 mm nozzle and 2,0 – 2,5 bars (or 40 Psi) pressure.
Theoretical yield: 1,0 - 1,2 kg/m^2 per 600 micron of thickness.
The product can be sanded after 12 hours from the application at a temperature of 20°C.
Typical sanding cycle: by hand P240-P320- P400 then after 12 hours P600-P800-P1200.
Polish the product 12 hours after the sanding operation using water-borne products.
Do not use it at temperatures lower than 16°C.
In its original packaging the product is stable for 6 months when stored in a dry place at temperatures not exceeding 20°C.
Note: for surface cleaning use silicon-free cloth

TYPICAL SPECIFICATIONS

	Value	Method
Colour	Colorless (VHG100) Black (VHG100B) Grey (VHG100G)	IMIA-01
Weight density, @ 23°C, g/litro	1000 ± 50	IMIA-02
Solid content, % by weight	50 ± 2	IMIA-03
Viscosity, Ford cup 4 @ 20°C, s.	60 ± 5	IMIA-12
Gloss index	90 ± 5	IMIA-70

VHG100

VHG100G

VHG100B

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Tooling Gelcoats

COMPOSITE

professional Composite line

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PRODUCTS FOR
COMPOSITE INDUSTRY

ITEM CODE	ITEM NAME	COLOR	APPLICATION	PACKAGING
GI20H	TOOLING GELCOAT ISOPHTHALIC	black	hand	KG 25
GI10H	TOOLING GELCOAT ISOPHTHALIC	green	hand	KG 25
GI20S	TOOLING GELCOAT ISOPHTHALIC	black	spray	KG 25
GI10S	TOOLING GELCOAT ISOPHTHALIC	green	spray	KG 25
GV20H	TOOLING GELCOAT VINYLESTER	black	hand	KG 25
GV10H	TOOLING GELCOAT VINYLESTER	green	hand	KG 25
GV20S	TOOLING GELCOAT VINYLESTER	black	spray	KG 25
GV10S	TOOLING GELCOAT VINYLESTER	green	spray	KG 25

Barriercoats

COMPOSITE

professional Composite line

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PRODUCTS FOR
COMPOSITE INDUSTRY

BC90V

VINYLESTER BARRIERCOAT

BC90V it's a syntactic foam based on vinyletser resin and low density mineral loads, specially formulated to be applied as first coat after the gelcoat and become a barrier for the marking caused by the fibers and the souls reinforced composite laminate, also after weeks and months from the extraction of the pieces from the respective molds.
BC90V is an effective alternative, partial or total, to the first manual MAT coat (skincoat), with significant advantages in terms of the laminate construction speed.
It has an high thermal resistence (HDT > 80°C), is an exceptional barrier against the osmosis, with a reduced water absorption and it grant a higher surface finishing.
Can be easily applied with a normal gelcoat machine.

SUGGESTED SUPPORTS

Gelcoat Polyester and vinylester Vinilestere properly prepared and cleaned.

GENERAL USE INDICATIONS

Applicable on support withour dust, fibers, dirt. It's suggested to apply BC90V maximum after 2 hours from the gelcoat application. Mix BC90V with 1,0-2,0% of liquid catalyst CT23 (methyl ethyl ketone peroxide), keeping in mind that the quantity of catalyst needed depends on the required operation Temperature and the processing times. The recommended operating temperature interval is between 16 and 28°C.
The product contains a colour-changing additive to check the homogeneous dispersion of the peroxide into the product during the catalysis. Typical application with brush or spray with a gelcoat machine; the spray application is suggested because it reduce the application time and allows a greater uniformity of the thickness obtained. Recommended thickness: 800 - 1000 microns by 2 two hands spaced by 5 min. It is suggested to start the lamination maximum after two hours from the barrier coat application.
When stored in the original, sealed cans at a temperature less than 23°C, the product is stable at least 6 months.

TYPICAL SPECIFICATIONS OF THE LIQUID PRODUCT		
	Value	Method
Colour	Azure viracolor	IMIA-01
Weight density, @ 23°C, g/litro	850 ± 50	IMIA-02
Tixotropy index	4	IMIA-10
Viscosity @ 23°C.p	20000-30000	IMIA-10
Reactivity @ 23°C		
– gel time, min.	20 ± 5	IMIA-15
100 g. barrier coat + 1,50 g. MEKP 50%		

TYPICAL CHARACTERISTICS OF THE HARDENED PRODUCT (*)		
	Value	Method
Linear shrinkage % (sample dim.: 500x50x10 mm)	0,5 %	IMIA-26
Surface hardness		
Shore D	65 ± 2	ISO 868
Thermo-mechanical properties		
HDT, ° C	90 ± 5	ISO 75-A
TG,° C	95 ± 5	ASTM 11359-2
Water absorption %	0,2	IMIA-46
(*) on specimens hardened for 24 hours at 25°C and post-hardened for 3 hours at 80°C		

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Tooling Resins

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PRODUCTS FOR
COMPOSITE INDUSTRY

R999

RESIN FOR POLYSTYRENE LAMINATION

Orthophtalic polyester resin in solution of styrene and a methacryic monomer.
Specific adhesion to polystyrene foam as unlike the common polyester resins, it does not attack at all the polystyrene of any density.
The resin in pre-accelerated and has medium viscosity and reactivity.

GENERAL USE INDICATIONS

The resin in pre-accelerated and has medium viscosity and reactivity.
Mix the resin with 1,0-2,0% of liquid catalyst (methyl ethyl ketone peroxide), bearing in mind that the quantity of catalyst selected depends both on the required operating temperature and processing times.
The recommended temperature interval of the product is between 16°C. and 28°C.
The products is table for 6 months in a sealed container at a storage temperature of 20°C.

TYPICAL SPECIFICATIONS OF THE LIQUID PRODUCT		
	Value	Method
Colour of liquid resin	Brown	IMIA-01
Colour of hardened resin	Light yellow	IMIA-01
Density @ 23°C, g/litre	1100 ± 50	IMIA-02
Solid content, % by weight	61,4	IMIA-03
Viscosity @ 25°C, mPa.s	800 - 900	IMIA-10
Reactivity @ 23°C		
– gel time, minutes,	25 ± 5	IMIA-15
100 g. resin + 2 g. BUTANOX M50		

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RV2015

MODIFIED VINYL ESTER RESIN FOR SKINCOAT

RV2015 is an accelerated, thixotropic viny ester resin, to be used as thin layer (skincoat) during the mould building process and for the boat/other composite parts building process.
Applied in a thin layer (skincoat), allow to improve the osmosis resistance; allow also to get composite parts with excellent hardness; allow to increase the resistance to the gelcoat breakages caused by the laminate flexion or shock; It provides hardness and heat resistance needed for the building process of a long durable mould, that needs low maintenance operations.
When high thermos-mechanical properties of the artefact are required, RV2015 can be used as resin for the whole lamination process.

GENERAL USE INDICATIONS

RV2015 can be applied by hand lamination or by spray lamination.
Hardener: CT21 (Metyil Ethyl Ketone Peroxide/Butanox M50)1,0%-2,0% of the resin total weight. The best result are obtainable working inside the temperature range 18°C-32°C and the humidity range 40%-90%.
It is recommended to maintain constant application conditions to get constant viscosity and gel time.
In its original packaging the product is stable for six months stored in a dry place at temperatures not exceeding 20°C.

TECHNICAL PROPERTIES - LIQUID STATE AT 25°C. * (1)

Test	Measurament units	Results	Method
Brookfield viscosity, LV#3@60	mPa*s	550 - 600	Intec – mf,gg
Thixotropy index 6/60	-	3	Intec – mf,gg
Styrene content	%	32-34	Intec – mf,gg
Gel Time 1,25% Methyl Ethyl Ketone peroxide CT21	minutes	38 - 42	Intec – mf,gg
Total polymerization time	minutes	50 - 58	Intec – mf,gg
Exotherm peak C°	°C.	152-158	Intec – mf,gg

TYPICAL MECHANICAL PROPERTIES * (2)

Test	Measurament units	Results	Method
Tensile strength	MPa	78 - 82	ISO 527-1
Tensile modulus	GPa	3,8 – 4,2	ISO 527-1
Traction elongation	%	2,5 – 2,9	ISO 527-1
Flexural strength	MPa	102 - 105	ISO 178
Flexural modulus	GPa	4,0 – 4,2	ISO 178
HDT	°C	97-103	ISO 75-A

** (1): gel and hardening time are approximate and can be modified by the hardener % and by the mould and dpt. temperature conditions*
**(2): data based on test made at 25°C and 50% of humidity on samples of cast resin not reinforced hardened 24 hours at 25°C and post cured 4 hours at 90°C. Don't use as specific values.*

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RS2005

PREFILLED TOOLING RESIN EASYMOULD

RS2005 is a resin based on unsatured polyester, loaded and pre-accelerated at a low content of styrene. RS2005 was formulated for the rapid realization of the laminate resulting in excellent surface finish and high dimensional stability of the moulds.
RS2005 is particularly suitable for the stratification of large surfaces characterized by a lower shrinkage, low emission of styrene, remarkably improving the working environment and the exposure of the operators.

GENERAL USE INDICATIONS

Manual lamination:

- Apply a thin layer of pure resin onto the hardened gelcoat
- Laminate the first well impregnated MAT of 225 gr/m2, carefully removing the air bubbles
- Laminate immediately 4 MAT of 300 gr/m2
- Allow the resin to harden until it reaches a uniform whitening
- Laminate the second layer with 4 MAT of 450 gr/m2; wait for a further whitening of the resin
- Continue to laminate with 4 MAT of 450 gr/m2 at a time until obtaining the project whickness

Cutting and spraying

- Apply a thin layer of pure resin onto the hardened gelcoat
- Laminate manually the first well impregnated MAT of 225 gr/m2, carefully removing the air bubbles
- Spray immediately a cutting-spraying layer of 4 mm., hands crossed method
- Allow the resin to harden until it reaches a uniform whitening
- Continue to laminate 4 mm. of cutting-spraying at a time until obtaining the project thickness.

Application notes:
Shake well before using the product; the best results are obtained when working at temperatures between 20°C. and 25°C. It is recommended cleaning and sanding the surfaces in the case of long intervals (over 8-12 hours) of overlamination.

TYPICAL SPECIFICATIONS OF THE LIQUID PRODUCT	Value	Method
Colour	Azzurro viracolor	IMIA-01
Weight density, @ 23°C, g/litre	1450 ± 50	IMIA-02
Solid content, % by weight	78 ± 2	IMIA-03
Reactivity @ 23°C		
– Gel time, minutes	30 - 40	IMIA-15
– Exothermic peak °C	80 - 90	
100 g. paste + 1,50 g. MEKP 50%		

TYPICAL CHARACTERISTICS OF THE HARDENED PRODUCT (*)	Value	Method
Hardened colour	White	IMIA-01
Surface hardness, barcol	35 - 40	IMIA-28
HDT, ° C	60 - 65	IMIA-50
Tg, ° C	80 - 85	STM D3418
Linear shrinkage %	< 0,9	IMIA-25
Resistance to traction, Mpa	75 - 80	ASTM D638 (**)
Elongation at break, %	1,0 - 1,1	
Modulus at traction, GPa	7,5 - 8,0	
Resistance to flexion, Mpa	145 - 155	ASTM D790 (**)
Modulus at flexion, GPa	7,0 - 7,5	

(*) specimens hardened for 24 hours at 23°C and post-hardened for 3 hours at 80°C
(**) resin reinforced with 20% in weight of glass fibre (MAT 450 g./mq.)

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RS2030

PREFILLED TOOLING RESIN HP MOULD

RS2030 is a resin based on unsatured polyester, loaded and pre-accelerated at a low content of styrene. RS2030 was formulated for the rapid realization of moulds with excellent surface finish and high dimensional stability of the moulds. Characterized by a low linear shrinkage and medium HDT.
RS2030 is particularly suitable for the stratification of large surfaces and construction of infused pieces; characterized by a low emission of styrene, remarkably improving the working environment and the exposure of the operators.

GENERAL USE INDICATIONS

Manual lamination:

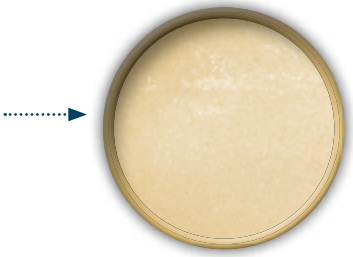
- Apply a thin layer of pure resin onto the hardened gelcoat
- Laminate the first well impregnated MAT of 225 gr/m2, carefully removing the air bubbles
- Laminate immediately 4 MAT of 300 gr/m2
- Allow the resin to harden until it reaches a uniform whitening
- Laminate the second layer with 4 MAT of 450 gr/m2; wait for a further whitening of the resin
- Continue to laminate with 4 MAT at a time until obtaining the project whicknessss

Cutting and spraying

- Apply a thin layer of pure resin onto the hardened gelcoat
- Laminate manually the first well impregnated MAT of 225 gr/m2, carefully removing the air bubbles
- Spray immediately a cutting-spraying layer from of 4 mm. , hands crossed method
- Allow the resin to harden until it reaches a uniform whitening
- Continue to laminate 4 mm. of cutting-spraying at a time until obtaining the project thickness.

Application notes:
Shake well before using the product; the best results are obtained when working at temperatures between 20°C. and 25°C. It is recommended cleaning and sanding the surfaces in the case of long intervals (over 8-12 hours) of overlamination.

TYPICAL SPECIFICATIONS OF THE LIQUID PRODUCT	Value	Method
Colour	Beige	IMIA-01
Weight density, @ 23°C, g/litre	1450 ± 50	IMIA-02
Solid content, % by weight	78 ± 2	IMIA-03
Reactivity @ 23°C		
– Gel time, minutes	30 - 40	IMIA-15
– Exothermic peak °C	70 - 80	
100 g. paste + 1,50 g. MEKP 50%		



TYPICAL CHARACTERISTICS OF THE HARDENED PRODUCT (*)	Value	Method
Hardened colour	White	IMIA-01
Surface hardness, barcol	40 - 45	IMIA-28
HDT, ° C	65 - 70	IMIA-50
Tg, ° C	85 - 90	STM D3418
Linear shrinkage %	< 0,8	IMIA-25
Resistance to traction, Mpa	85 - 90	ASTM D638 (**)
Elongation at break, %	1,2 - 1,4	
Modulus at traction, GPa	8,5 - 9,0	
Resistance to flexion, Mpa	160 - 180	ASTM D790 (**)
Modulus at flexion, GPa	8,0 - 8,5	

(*) specimens hardened for 24 hours at 23°C and post-hardened for 3 hours at 80°C
(**) resin reinforced with 20% in weight of glass fibre (MAT 450 g./mq.)

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RS6060LP

PREFILLED LP TOOLING RESIN POLYESTER

RS6060LP is a resin based on unsatured polyester, prefilled, pre-accelerated with a low content of styrene containing a low profile additive to grant a linear shrinkage near to 0. RS6060LP was formulated for the rapid realization of moulds with excellent surface level and high dimensional stability. Particularly suggested for the construction of large moulds destinated also to the production of objects with infusion method and little moulds that perfectly copy the plugs. Characterized by a linear shrinkage near to 0, high HDT, and low emission of styrene, remarkably improving the working environment and the exposure of the operators.

GENERAL USE INDICATIONS

Manual lamination:

- Apply a thin layer of pure resin onto the hardened gelcoat
- Laminate the first well impregnated MAT of 225 gr/m2, carefully removing the air bubbles
- Laminate immediately 4 MAT of 300 gr/m^2
- Allow the resin to harden until it reaches a uniform whitening
- Laminate the second layer with 4 MAT of 450 gr/m^2; wait for a further whitening of the resin
- Continue to laminate with 4 MAT of 450 gr/m^2 at a time until obtaining the project thickness

Cutting and spraying

- Apply a thin layer of pure resin onto the hardened gelcoat
- Laminate manually the first well impregnated MAT of 225 gr/m^2, carefully removing the air bubbles
- Spray immediately a cutting-spraying layer of 4 mm., hands crossed method
- Allow the resin to harden until it reaches a uniform whitening
- Continue to laminate 4 mm. of cutting-spraying at a time until obtaining the project thickness.

Application notes:

Shake well before using the product; the best results are obtained when working at temperatures higher than 25°C. It is recommended cleaning and sanding the surfaces in the case of long intervals (over 8-12 hours) of overlamination.

TYPICAL SPECIFICATIONS OF THE LIQUID PRODUCT		
	Value	**Method**
Colour	Beige	IMIA-01
Weight density, @ 23°C, g/litre	1330 ± 50	IMIA-02
Solid content, % by weight	75 ± 2	IMIA-03
Reactivity @ 23°C		
– Gel time, minutes	20 - 30	IMIA-15
– Exothermic peak °C	130 - 140	
100 g. paste + 1,50 g. MEKP 50%		

TYPICAL CHARACTERISTICS OF THE HARDENED PRODUCT (*)		
	Value	Method
Hardened colour	White	IMIA-01
Surface hardness, barcol	40 - 45	IMIA-28
HDT, ° C	85 - 90	IMIA-50
Tg, ° C	88 - 95	STM D3418
Linear shrinkage %	< 0,2	IMIA-25
Resistance to traction, Mpa	115 - 125	ASTM D638 (**)
Elongation at break, %	1,3 - 1,6	
Modulus at traction, GPa	10,0 - 10,5	
Resistance to flexion, Mpa	200 - 220	ASTM D790 (**)
Modulus at flexion, GPa	9,0 - 10,0	
(*) specimens hardened for 24 hours at 23°C and post-hardened for 3 hours at 80°C		
(**) resin reinforced with 20% in weight of glass fibre (MAT 450 g./mq.)		

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RV8080LP

PREFILLED LP TOOLING RESIN VINYLESTER

RV8080LP is a resin based on vinylester, prefilled, pre-accelerated with a low content of styrene, containing a low profile additive to grant a linear shrinkage near to 0. RV8080LP was formulated for the rapid realization of moulds with excellent surface level and high dimensional stability. Particularly suggested for the construction of large moulds destinated also to the production of objects with infusion method and little moulds for RTM. Characterized by a linear shrinkage near to 0, excellent thermos mechanical properties.

GENERAL USE INDICATIONS

Manual lamination:

- Laminate the first well impregnated MAT of 225 gr/m^2, carefully removing the air bubbles
- Laminate immediately 4 MAT of 300 gr/m^2
- Allow the resin to harden until it reaches a uniform whitening
- Laminate the second layer with 4 MAT of 450 gr/m^2; wait for a further whitening of the resin
- Continue to laminate with 4 MAT of 450 gr/m^2 at a time until obtaining the project thickness

Cutting and spraying

- Apply a thin layer of pure resin onto the hardened gelcoat
- Laminate manually the first well impregnated MAT of 225 gr/m^2, carefully removing the air bubbles
- Spray immediately a cutting-spraying layer of 4 mm., hands crossed method
- Allow the resin to harden until it reaches a uniform whitening
- Continue to laminate 4 mm. of cutting-spraying at a time until obtaining the project thickness.

Application notes:

Shake well before using the product; the best results are obtained when working at temperatures higher than 25°C. It is recommended cleaning and sanding the surfaces in the case of long intervals (over 8-12 hours) of overlamination.

TYPICAL SPECIFICATIONS OF THE LIQUID PRODUCT	Value	Method
Colour	Light brown	IMIA-01
Weight density, @ 23°C, g/litre	1300 ± 50	IMIA-02
Solid content, % by weight	70 ± 2	IMIA-03
Reactivity @ 23°C		
– Gel time, minutes	40 - 50	IMIA-15
– Exothermic peak °C	110 - 120	
100 g. paste + 1,50 g. MEKP 50%		

TYPICAL CHARACTERISTICS OF THE HARDENED PRODUCT (*)	Value	Method
Hardened colour	White	IMIA-01
Surface hardness, barcol	45 - 50	IMIA-28
HDT, ° C	94 - 100	IMIA-50
Tg, ° C	115 - 125	STM D3418
Linear shrinkage %	< 0,1	IMIA-25
Resistance to traction, Mpa	120 - 130	ASTM D638 (**)
Elongation at break, %	1,4 - 1,7	
Modulus at traction, GPa	10,5 - 11,0	
Resistance to flexion, Mpa	220 - 230	ASTM D790 (**)
Modulus at flexion, GPa	10,0 - 11,0	

(*) specimens hardened for 24 hours at 23°C and post-hardened for 3 hours at 80°C
(**) resin reinforced with 20% in weight of glass fibre (MAT 450 g./mq.)

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Polishing products

COMPOSITE

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PRODUCTS FOR
COMPOSITE INDUSTRY

L70 / L71

MORDANT ABRASIVE PASTE / EXTRA MORDANT ABRASIVE PASTE

Mordant/Extra mordant creamy abrasive pastes based on emulsifiers and special abrasives suitable for polishing articles and gelcoat finished moulds.
Its special mordant/high mordant formulation allows a fast polishing of very hard surfaces and the removal of medium depth marks and scratches.

GENERAL USE INDICATIONS

Ready to use. If necessary, dilute with water or solvent (oil, petrol). Thoroughly clean the surface to be treated and make sure it is free from grease and foreign matter.
Place the paste evenly over the entire surface, ensuring that the gelcoat is cold. Use with a polishing machine at a speed of between 1500-200 turns per minute (L70) or 1000 - 1500 turns per minute (L71) with suitable swabs.
Avoid heating the gelcoat too much for too long in the same area. At the end of the polishing eliminate any residual paste with clean rags or swabs.
To achieve a higher gloss, complete the polishing with Polish.
Stability two years in a cool, dry place, far from heat sources.

TYPICAL SPECIFICATIONS OF THE LIQUID PRODUCT			
	Value L70	Value L71	Method
Colour	White	White	IMIA-01
Weight density, @ 23°C, g/litro	1500 ± 50	1700 ± 50	IMIA-02
Solid content, % by weight	68	74	IMIA-03

L80

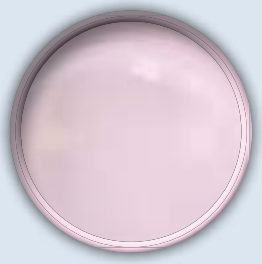
UNIVERSAL POLISH

Idirect multiemulsion compound with cosmetic volatile oils, soaking wetting and coating, biodegradable
when in aqueous phase.
Contains vegetal thixotropic which make coat even.
It has an excellent cleaning, shining and polishing power.
Gives uniformity to the threated surfaces and
protects from pollution.
When used on glass and transparent surfaces it doesn't leave iridescences.

APPLICATION

Apply product by hand or machine with special tampons or soft clothes.
Let dry the product and eliminate the residue with clean clothes or tampons.
100 gr of product are enough to polish 3/4 mq of surface.
Its dilution with water is suggested, specially in summer.

TYPICAL SPECIFICATIONS OF THE LIQUID PRODUCT		
	Value	Method
Colour	Pink	IMIA-01
Weight density, @ 23°C, g/litro	1000 ± 50	IMIA-02
Solid content, % by weight	63	IMIA-03



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Hardeners /Accelerators

COMPOSITE

professional Composite line

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PRODUCTS FOR
COMPOSITE INDUSTRY

CT10 HARDENERS IN PASTE

PACKING CODE	TYPE OF PACKAGING	PACKAGING	COLOR
TUBO5ML	Tube	ML. 5	white
TUBO6R	Tube	ML. 6	red
TUBO20B	Tube	ML. 20	white
TUBO22R	Tube	ML. 22	red
VAS35B-R	Jar	ML. 30	white
TUBO35B-R	Tube	ML. 30	white/red
CART40B-R	Cartridge	GR. 40	white/red
TUBO40B-R	Tube	ML. 40	white/red
TUBO55R	Tube	ML. 55	red
TUBO145R	Tube	GR. 145	red
TUBO180B	Tube	ML. 180	white
VAS500B	Jar	GR. 500	white
IND25KB-R	Keg	KG. 25	white/red

CT20 LIQUID HARDENERS FOR POLYESTER SPRAY PUTTY (Cyclohexanone Peroxide)

PACKING CODE	TYPE OF PACKAGING	PACKAGING	COLOR
BO50	Bottle	ML. 50	colorless
BO65	Bottle	ML. 65	colorless

CT21 LIQUID HARDENERS FOR POLYESTER AND VINYLESTER

PACKING CODE	TYPE OF PACKAGING	PACKAGING	COLOR
BO125CEPBX	Bottle	ML. 125	colorless

CT22 LIQUID HARDENER FOR TOOLING PASTES

PACKING CODE	TYPE OF PACKAGING	PACKAGING	COLOR
CYCLONOX	Little drum	KG. 25	colorless

CT23 LIQUID HARDENER FOR HIGH GLOSS CLEARCOAT VHG100 AND BARRIERCOAT

PACKING CODE	TYPE OF PACKAGING	PACKAGING	COLOR
BO80	Bottle	ML. 80	colorless

CT40 COBALT ACCELERATOR SOLUTION

PACKING CODE	TYPE OF PACKAGING	PACKAGING	COLOR
CT40	Bottle	ML. 80	blue

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COMPOSITE

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PRODUCTS FOR
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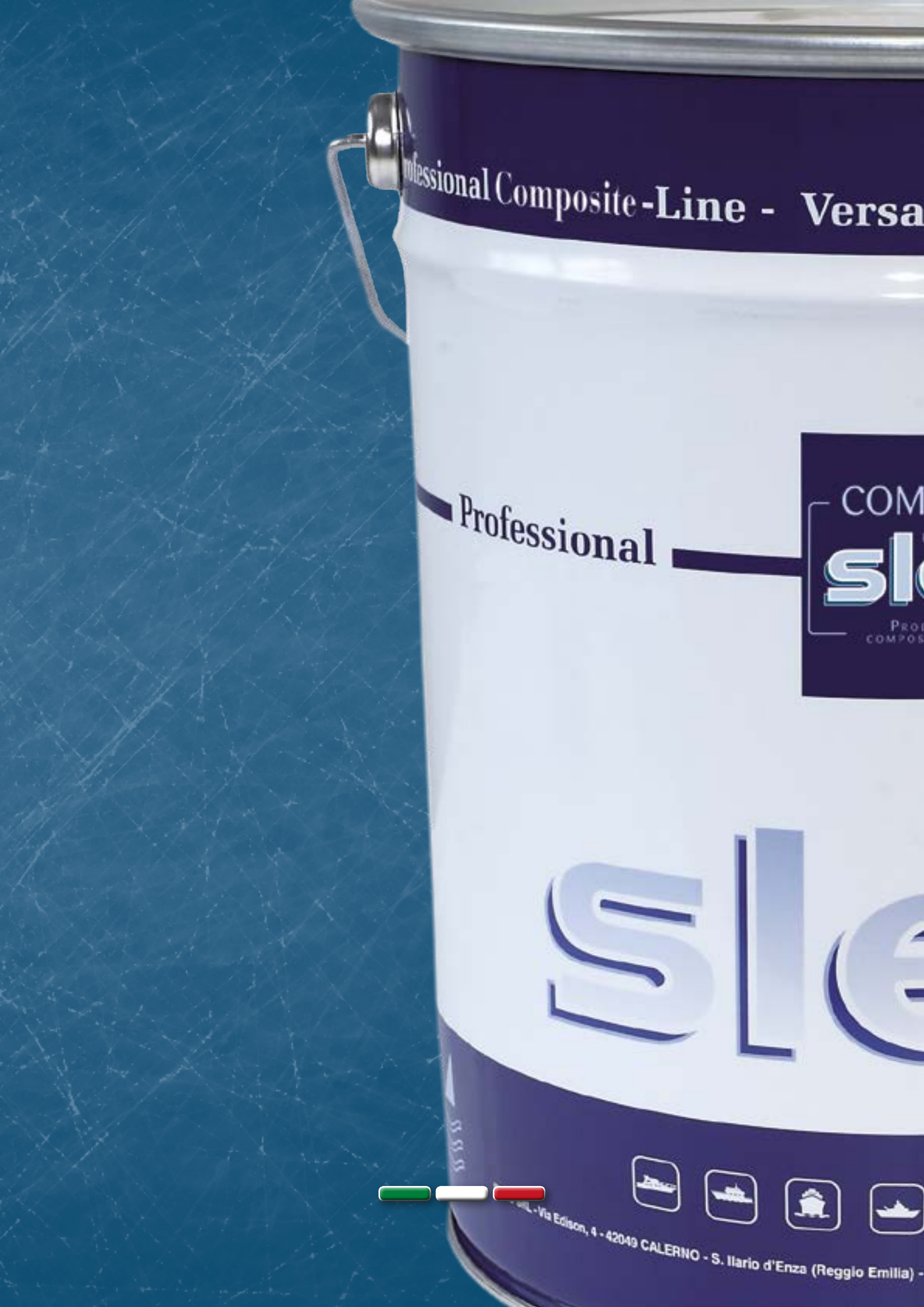
Marine, Renewable energies, Aeronautical,
Aerospace, Transport and advanced mobility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CHEMICAL PRODUCTS FOR COMPOSITE INDUSTRY

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