

SPRAYBOND 4020 FINISHING AND MOULD SURFACING PASTE

**HIGHLY ADHESIVE, MINERAL FILLED
SPRAYABLE FINISHING PASTE BASED ON
LLOYDS APPROVED RESIN**

DESCRIPTION

SPRAYBOND 4020 finishing and mould surfacing paste is a sprayable, highly adhesive mineral filled polyester resin paste. The paste is based on a SABS and Lloyds approved, pre-accelerated unsaturated polyester resin in a styrene monomer solution.

SPRAYBOND 4020 is formulated to form a perfect bond with SUPERBOND and FAIRBOND surfaces. Once cured, the SPRAYBOND surface can easily be sanded smooth, and can be polished to full shine after 800 grit sanding. Its final cured surface displays excellent hardness ensuring a long lasting finish.

SPRAYBOND 4020's superior bond and perfect surface finish makes it suitable for forming the finishing surface on yachts etc. before Gelcoat or decorative paint finishes. When utilised in moulds it can form the final mould surface without the need of a Gelcoat topping.

FEATURES	BENEFITS
Strong adhesion	Adheres strongly to a variety of substrates and forms a perfect bond with SUPERBOND or FAIRBOND substrates
Good filling properties	Fills pinholes and small imperfections to form a super smooth surface
Viscosity for manual and vacuum applications	Paste is formulated to be diluted with Acetone for Spraying
Lloyds and SABS 713 approved resin base	Meets national and international quality standards
Specially formulated	High adhesion, tensile strength and surface hardness, in addition to superior adhesion to existing substrates. Works as mould surface.
Patented formulation	Our unique formulation has been patented in 2016

THIS TECHNICAL DATA SHEET, AS WELL AS THE MATERIAL SAFETY DATA SHEET (MSDS) MUST BE READ AND UNDERSTOOD BEFORE WORKING WITH THIS PRODUCT.

The information is given to assist customers in assessing whether our products is suitable for their applications. We request that customers test our products before use to satisfy themselves as to performance and suitability for their requirements. Nothing in this data sheet constitutes any warranty, expressed or implied, including any warranty suitability for customer applications, nor is protection from any law or patent to be inferred. All patent rights are reserved. The exclusive remedy for all proven claims is replacement of our materials, and in no event shall we be liable for special, incidental, or consequential damages. Our standard terms and conditions of sale applies. Errors and omissions excluded.

PHYSICAL PROPERTIES

PROPERTY	SPECIFICATION	TEST METHOD
Relative density @ 25°C, kg/m ³	1,49	
Viscosity @ 25°C, mPa.s	128 7600	Brookfield
Tensile strength, mPa	21	ISO 527
Tensile modulus, mPa	2137.0	ISO 527
Elongation at break	3,5%	ISO 527
Hardness	85	Shore D
Flashpoint	32°C	
Maximum cure temperature @ 25°C ambient, 2 phr* MEKP and 3cm paste layer	72°C	
Geltime @ 25°C and 2 phr* MEKP, minutes	17 - 25	
Stability in the dark @ 25°C, months	6 minimum	

*phr = parts per hundred by mass

GELTIME

The ambient temperature and the amount of catalyst control the geltime of the resin formulation. Catalyst levels should be dosed at a minimum of 1% and a maximum of 3% by mass. Inhibitors or accelerators can be used to adjust the geltime. SPRAYBOND 4020 is a thermosetting resin paste and should not be processed at temperatures below 15°C and ideally not above 35°C.

PIGMENTS, FILLERS AND DILUTION

SPRAYBOND 4020 can be pigmented by the addition of up to 5% by mass pigment paste, but it must be understood that the addition of any pigment will influence the physical, mechanical properties of the bonding paste negatively.

Additional filling of SPRAYBOND 4020 should be avoided, as it will diminish the surface finish. SPRAYBOND 4020 can be diluted with 5-10% by mass with clean Acetone for spray applications to suit spray nozzles used. The dilution should be done in batches to be used within 1 hour, as the acetone evaporates naturally.

STORAGE AND HANDLING

SPRAYBOND 4020 should be stored in closed containers, maintained below 25°C and away from heat sources and sunlight. All storage must comply with local fire and building regulations. Stock rotation should be based on a first-in, first-out principle. If stored correctly, the shelf life is 6 months from date of manufacture. NB: Stir before use! Dilute small batches and only before use.

MATERIAL SAFETY DATA SHEET

A Material Safety Data Sheet (MSDS) is available from KG Polymer Compounds on request. The MSDS outlines the safe handling of this product.

WARNING: DIRECT MIXING OF ANY ORGANIC PEROXIDE (CATALYST) WITH METAL SOAPS, AMINE OR ANY OTHER POLYMERISATION ACCELERATOR OR PROMOTER MUST BE AVOIDED, AS VIOLENT DECOMPOSITION WILL RESULT!

Data sheet version 08/16