



euromereSprayCore
a division of Illinois Tool Works Inc.

TECHNICAL DATA SHEET

FSP 1934A-7 low density, glass fibre reinforced “anti-bubble” filler paste

APPEARANCE

Blue paste incorporating a blue catalyst indicator. Turns pale grey when cured.

DESCRIPTION

FSP 1934A-7 is a low density, pre-accelerated, high viscosity and highly thixotropic bonding paste specially formulated for core bonding in sandwich structures and for cavity filling (strakes, angles...). This product is also suitable as anti-bubble paste behind gelcoat.

FABRICATION INFORMATION

Core bonding

Best results are achieved on fresh laminates.

Prepare and add the catalyst. The catalyst indicator helps to confirm mixing. A two pot mixing system is advised. Apply the required thickness (max. 20mm), with a paste spatula.

Apply the core onto the paste and press to spread the FSP and force out air.

Anti-bubble paste

FSP 1934A-7 is hand applied using a brush or spatula. FSP 1934A-7 is applied directly to gelcoat that is cured and ready for laminating. It is essential to laminate over the FSP 1934A-7 while it is still in the un-gelled state. FSP 1934A-7 anti-bubble paste is applied to a maximum thickness of 5mm. On addition of catalyst to the FSP 1934A-7 the blue colour change indicator turns gradually from blue to pale grey as the product cures.

Application tips:

Mix the catalyst and FSP 1934A-7 in one container and then transfer this to a second dispensing container before applying the product to the gelcoat. This avoids the possibility of un-catalysed material being applied to the gelcoat. Vary the catalyst from 0.6 to 2phr using Butanox M50 or equivalent.

Use in the temperature range 15°C to 30°C.

Do not dilute the paste and do not add anything other than catalyst.

Do not apply onto products that contain wax.

SUITABLE APPLICATIONS

FSP 1934A-7 is ideally suited as a core bonding adhesive as it has excellent adhesion to core materials balsa and foam...

FSP 1934A-7 increases the radius of tight corners which simplifies the laminating process, saves time and eliminates entrapped air.

FSP 1934A-7 is easy to use and does not form sink marks due to its inherent low shrinkage.

FSP 1934A-7 is suitable for use in boats, pools, sanitaryware, general moulding and a host of GRP applications.

TYPICAL LIQUID PROPERTIES

Density	0.8±0.05 kg/dm ³
Static viscosity	300000-350000 cps
Thixotropy	>8
Mass FSP 1934A-7	130g
Catalyst Type	Butanox M50 or equivalent
Catalyst Quantity	2,0 phr
Geltime @ 23°C	40 - 60 minutes

SUBSTANCE IDENTITY NUMBER

UN 1866

MARKING

UNSATURATED POLYESTER (UP)

SHELF LIFE

4 Months from production date when stored as below.

MATERIAL SAFETY, STORAGE and HANDLING

The barrier coat should be stored below 25°C, away from heat sources, direct sunlight and rain, in a closed opaque container.

Polyester resin solutions contain volatile and flammable monomers such as styrene (Flash Point 32°C). They are subject to the Highly Flammable Liquids and Liquid Petroleum Gases Regulations 1972.

All polyester resins should be handled and used in well ventilated, flame proof areas.

It is preferable to wear gloves and goggles to guard against any skin / eye irritation arising from the presence of styrene.

AVOID DIRECT MIXING OF ANY ORGANIC PEROXIDE (CATALYST) WITH METAL SOAPS, AMINE OR ANY OTHER POLYMERISATION ACCELERATOR OR PROMOTER, AS VIOLENT DECOMPOSITION WILL RESULT! Under no

circumstance must accelerators be mixed with peroxide catalysts directly as the mixture can explode.

A Material Safety Data Sheet is available from your NCS Resin (Pty) Ltd representative. Make certain that you obtain a copy and that it's contents are understood before work commences.

Ref. EDS089/005

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