



PRODUCT DATA

4001 Core Bonding Putty

(For use with 50% BPO)

Part No: 0614001F

Description: Orca Composites formulates its *Core Bonding Compound with premium polyester resins resulting in high tensile and flexural strength. Its high adhesive strength provides an excellent bond between the core and laminate. It is suitable for all coring applications and is compatible with popular core materials including balsa and PBC foam. 4001 (controlled for MEK-P) interval and peak exotherm are controlled using 50% BPO.*

Features:

- Semi-flexible for exceptional crack resistance
- Formulated with premium resins
- Low exotherm
- Low styrene content
- Pumpable and trowable

Uses:

- Bonding composites
- Bedding for cores

Viscosity Ranges: Viscosity (m) tests performed on Brookfield DVI HT T-C at 77°F.

<u>rpm</u>	<u>mMIN cps</u>	<u>mMAX cps</u>
2	220,000	280,000
20	28,000	62,000

Gel Properties:

Sample mass is 100 g catalyzed at 2.0% with 50% BPO Past 15 77°F

Gel Time: 45 - 60 min

Interval: 28 - 36 min

Total: 73 - 96 min

Peak Exotherm: 160 - 220° F

Product Specifications:

Color and odor: white with styrene odor

Physical appearance: smooth

Weight per gallon: 6.4 – 6.6 lbs/gal

Uncured stability: 4 to 5 months (depending on storage)