

Spabond 730

Rapid Structural Adhesive

- **Reduced clamp time structural adhesive**
- **Gels in 10 minutes, solid in 2 hours, full properties after an overnight cure at ambient**
- **High strength and toughness**
- **Sag resistance of 14mm at 20°C**
- **Available in 280ml peeler cartridges and pails**

Introduction

Spabond 730 is a fast curing structural adhesive designed for applications where reduced clamp times are important. It has a simple 1:1 by weight and volume mix ratio.

It can be used to bond together a wide variety of dissimilar materials and has been designed to give a durable high strength bond.

Spabond 730 Rapid Structural Adhesive is available in a simple easy to use 280ml cartridge and pails.

Instructions for Use

The product is optimised for use at 15 - 25°C. At lower temperatures the components thicken and may eventually become unworkable. To ensure accurate mixing and good workability pre-warm the resin & hardener as well as the surfaces to be bonded before use.

Surface Preparation

Before using the product ensure that surfaces to be bonded are clean, dry and dust-free. Prepare all surfaces by abrading with medium grit paper or other suitable abrasive, remove dust then wipe with acetone or SP Fast Epoxy Solvent (Solvent A).

Metals usually require a chemical pre-treatment to create the best bond. Please contact SP for a Guide to Surface Preparation and Pre-treatments.

Ensure that polyester or vinylester laminates are fully cured before bonding, then prepare as above.

When bonding epoxy laminates, the use of a suitable Peel Ply as the last stage in their manufacture is recommended, otherwise prepare as above. Trials may be required to test Peel Ply suitability.

For all timber, sand with abrasive paper across grain. Degrease oily timber with a fast evaporating solvent (e.g. SP Fast Epoxy Solvent). For resinous or gummy timber, etch with 2% caustic soda solution, wash off with fresh water and dry.

Mixing & Handling

Spabond 730 Rapid Structural Adhesive Resin and hardener should be mixed in the ratio:-

Spabond 730 Structural Adhesive Resin	Spabond 730 Structural Adhesive Hardener
1 : 1 (by weight)	
1 : 1 (by volume)	

Solvent-free epoxies have a limited pot-life. Mix sufficient only for immediate use to avoid excessive heat build up and resin wastage. With Spabond 730 Adhesive, mix enough for 5-7 minutes use. This product is highly exothermic, and care should be taken when disposing of unused mixed material.

Cartridge Use

When dispensing the product from a cartridge with a mixing dispensing head, please discard the first mix head length of resin and hardener components, prior to applying adhesive to the job, in order to ensure thorough mixing of the system. We recommend the use of a new mix head for each application, particularly where the time between each application approaches the pot life.

Properties

Component Properties		
	Spabond 730 Resin	Spabond 730 Hardener
Mix Ratio (by weight)	100	100
Mix Ratio (by volume)	100	100
Viscosity @ 15°C (P)	1110	793
Viscosity @ 20°C (P)	434	387
Viscosity @ 25°C (P)	174	191
Viscosity @ 30°C (P)	106	89
Shelf Life (months)	12	12
Colour (Gardner)	opaque	4
Mixed Colour (Gardner)	3	3
Component Dens. (g/cm ³)	1.13	1.13
Mixed Density (g/cm ³)	-	1.13
Hazard Definition	Xi, N	N/A

*Due to the thixotropic and filled nature of this system, these values are only indicative.

Notes: For an explanation of test methods used see 'Formulated Products Technical Characteristics'.

All figures quoted are indicative of the properties of the product concerned. Some batch to batch variation may occur.

† All times are measured from when resin and hardener are first mixed together.

Properties (Cont'd)

Cured System Properties		
	R.T. Cure (28 days @ 21°C)	Cured 24 hours @ 21°C +16 hours @ 50°C
Tg DMTA (Peak Tan δ)(°C)	-	80.1
Tg2 - DSC (°C)	48.3	63.2
Tg1 - DMTA (°C)	-	64
Cured Density (g/cm³)	1.1	1.1
Linear Shrinkage (%)	0.4	0.4
Cleavage Strength (N)	4900	6000
Shear Strength on Steel (MPa)	23.2	24
Shear Strength Wet Retention (%)	83.6	87

Working Properties vs. Temperature				
	Resin / Hardener			
	15°C	20°C	25°C	30°C
Initial Mixed Viscosity (P)	712	337	192	81
†*Gel Time - mix in water (mins:secs)	TBD	8:00	7:00	TBD
†Clamp Time (hrs:mins)	TBD	2:30	TBD	1:10
Sag Resistance (mm)	TBD	14	12	TBD

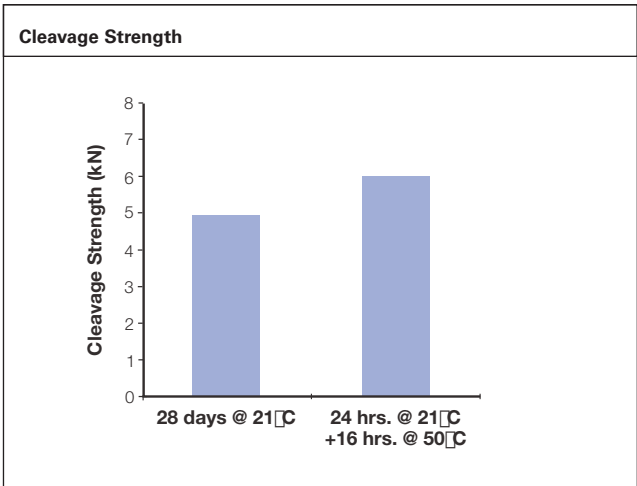
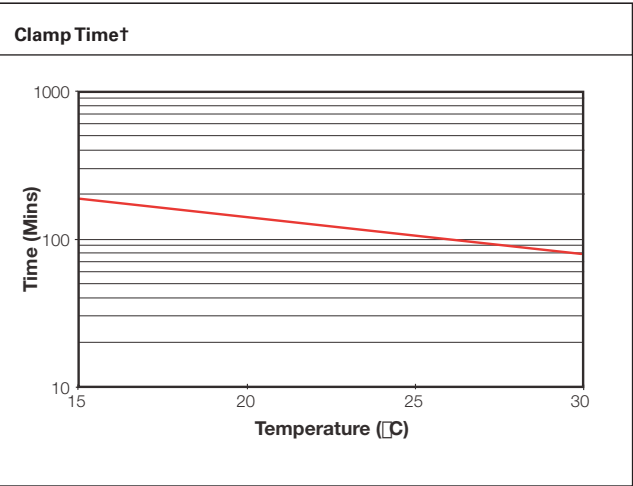
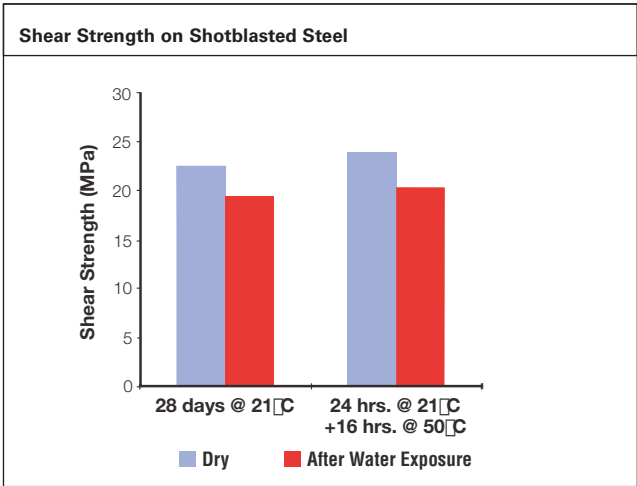
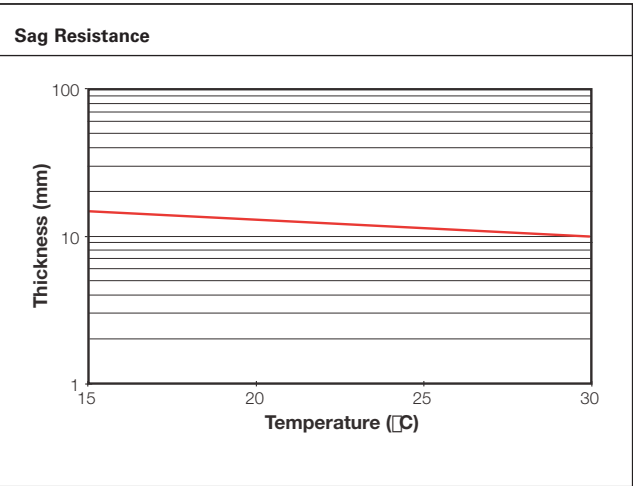
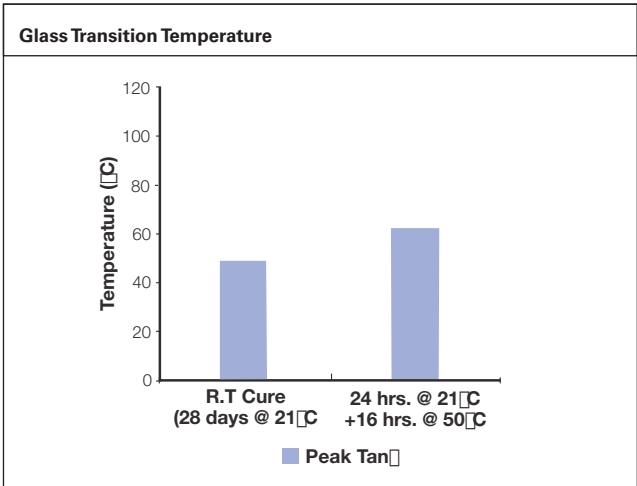
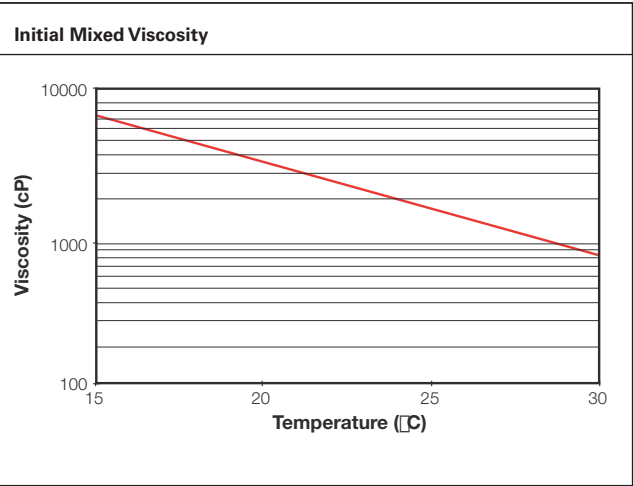
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For an explanation of test methods used see 'Formulated Products Technical Characteristics'.

All figures quoted are indicative of the properties of the product concerned. Some batch to batch variation may occur.

† All times are measured from when resin and hardener are first mixed together

Properties (cont'd)



Notes: For an explanation of test methods used see 'Formulated Products Technical Characteristics'.
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Health and Safety

The following points must be considered:

1. Skin contact must be avoided by wearing protective gloves. SP-High Modulus recommends the use of disposable nitrile gloves for most applications. The use of barrier creams is not recommended, but to preserve skin condition a moisturising cream should be used after washing.
2. Overalls or other protective clothing should be worn when mixing, laminating or sanding. Contaminated work clothes should be thoroughly cleaned before re-use.
3. Eye protection should be worn if there is a risk of resin, hardener, solvent or dust entering the eyes. If this occurs flush the eye with water for 15 minutes, holding the eyelid open, and seek medical attention.
4. Ensure adequate ventilation in work areas. Respiratory protection should be worn if there is insufficient ventilation. Solvent vapours should not be inhaled as they can cause dizziness, headaches, loss of consciousness and can have long term health effects.
5. If the skin becomes contaminated, then the area must be immediately cleansed. The use of resin-removing cleansers is recommended. To finish, wash with soap and warm water. The use of solvents on the skin to remove resins etc must be avoided.

Washing should be part of routine practice:

- before eating or drinking
- before smoking
- before using the lavatory
- after finishing work

6. The inhalation of sanding dust should be avoided and if it settles on the skin then it should be washed off. After more extensive sanding operations a shower/bath and hair wash is advised.

SP-High Modulus produces a separate full Material Safety Data Sheet for all hazardous products. Please ensure that you have the correct MSDS to hand for the materials you are using before commencing work. A more detailed guide for the safe use of SP resin systems is also available from SP-High Modulus, and can be found at www.gurit.com

Applicable Risk & Safety Phrases

Resin

R 36/38, 43, 51/53
S 23, 24, 26, 28, 37/39, 57

Hardener

R N/A
S 23, 24/25, 28



Transport & Storage

The resin and hardeners should be kept in securely closed containers during transport and storage. Any accidental spillage should be soaked up with sand, sawdust, cotton waste or any other absorbent material. The area should then be washed clean (see appropriate Safety Data Sheet).

Adequate long term storage conditions will result in a shelf life of one year for both the resin and hardener. Storage should be in a warm dry place out of direct sunlight and protected from frost. The temperature should be between 10°C and 25°C. Containers should be firmly closed. Hardeners, in particular, will suffer serious degradation if left exposed to air.

Notice

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UK

St Cross Business Park
Newport, Isle of Wight
United Kingdom PO30 5WU

T +44 (0) 1983 828 000
F +44 (0) 1983 828 100
E marine@gurit.com
W www.gurit.com

Australia

Unit 1A / 81 Bassett Street,
Mona Vale, 2103 NSW,
Australia

T +61 (0) 2 9979 7248
F +61 (0) 2 9979 6378
E sales-au@gurit.com
W www.gurit.com

New Zealand

32 Canaveral Drive, Albany,
Private Box 302-191,
North Harbour, 0751
Auckland, New Zealand

T +64 (0) 9 415 6262
F +64 (0) 9 415 7262
W www.gurit.com

Canada

175 rue Péladeau,
Magog, (Québec)
J1X 5G9, Canada

T +1 819 847 2182
F +1 819 847 2572
E info-na@gurit.com
W www.gurit.com