

## Technical data sheet

### **FIBER 60**

#### Fitting adhesive with glass fibre

#### Application:

- Composite manufacturing industry
- manufacture of waterborne vessels (boats: motorboats and sailing yachts)
- wind turbines
- transport (fairings, car bodies, etc.)
- other products made of composite (laminated) materials

#### Properties:

- excellent adhesive properties
- can be applied in thick layers (up to 30 mm)
- no sagging
- high mechanical strength
- hardened with methyl ethyl ketone peroxide

CHARACTERISTICS	FIBER 60	STANDARD
Density	1.40 – 1.50 g/cm <sup>3</sup>	PN-EN ISO 2811-1
Gel time at 20°C	50 - 65 min	--
Colour	olive or white	--
Exotherm peak	< 50 °C	--
Shrinkage	< 1 %	PN EN ISO 3521
Tensile strength	> 30 MPa	PN EN ISO 527
Elongation at break	> 0,9 %	PN EN ISO 527
Flexural strength	> 50 MPa	PN EN ISO 178
Flexural strain	> 2 %	PN EN ISO 178
Glass transition temperature	67 °C	DIN EN ISO 6721
Polish Register of Shipping Type Approval Certificate	<b>TT/1332/710250/22</b>	

**CAUTION:** Tests were made with 1,5% Metox 50WR hardener.

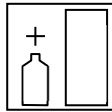
#### SUBSTRATES

polyester, vinyl ester and epoxy laminates	degrease with the PLUS 780 a remover, dry sand P80 – P120, and degrease again.
plywood, wood	dry sand with P80 – P120 and remove dust
rigid polyurethane foams and PVC	remove dust.

#### CAUTION

The adhesive should not be applied directly on wash primers, one-component acrylic or nitrocellulose products

#### MIXING RATIO



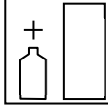
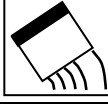

	ADHESIVE HARDENER	Ratio by weight
		100g 1.0-2.0g

#### COATABILITY

Polyester, vinyl ester or epoxy laminates (resins), polyester putties, and acrylic primers

#### APPLICATION CONDITIONS

The minimum application temperature is +10°C at air humidity from 30 to 70%.  
 The minimum temperature of the product for application is +15°C.

APPLICATION	
	Clean and sand the surface
	Degrease the surface with PLUS 780
	Observe the required amount of hardener. Mix the components thoroughly until a uniform colour is obtained. Weight quantity of components: Add 100 g of FIBER to 1.0-2.0 g of hardener.  Gel time at 20°C: 50-65 min
	Apply with a notched trowel (notch height: up to 10 mm).
	The curing time is 5 to 6 h at 20°C with 1.5% of hardener.
SUPPLEMENTARY PRODUCTS	
Hardener – methyl ethyl ketone peroxide (e.g. METOX 50WR).	
EQUIPMENT CLEANING	
THIN 850 acrylic thinner or NC solvent.	
PACKAGING	
20 kg; 250 kg (DRUM).	
STORAGE CONDITIONS	
Store in a cool dry room, away from sources of fire and heat. Avoid direct exposure to sunlight.	
SHELF LIFE	
FIBER 60	6 months / 20°C
SAFETY	
See the Safety Data Sheet.	
NOTES	
Intended for professional use only.	
OTHER INFORMATION	
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