

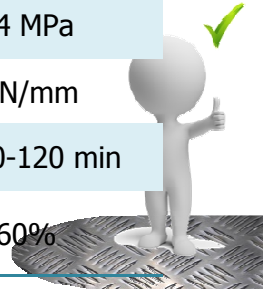
# Marine : Hull on Deck

## MARKET INFO

<b>Market</b>	Marine
<b>Segment</b>	Composite
<b>Country</b>	France
<b>Substrate</b>	Polyester composite

## MAIN PROPERTIES

<b>Lap Shear</b>	14 MPa
<b>Peel</b>	4 N/mm
<b>Open time</b>	30-90-120 min
<b>Elongation</b>	60%



H6236 is designed to bond big composite parts. It offers long open time and high thixo (but can be used with pressurized tank thanks to a combination of physical and chemical thixo) to fill gap up to 60mm. It has a Lloyd's approval : no doubt on final properties.

## OVERVIEW

This company is the world leisure boat manufacturer leader. All assembly in leisure boats (sail or motor) are done by bonding.

Partition wall giving rigidity to the hull.

Deck to hull are bonded.

After facing some cracks when polyester glue is used a switch was done to PU with a competitor. Now Axson is the supplier for motor boats.



## APPLICATIONS & ACHIEVEMENTS

- Polyester to Polyester (infusion)
- Polyester to wood
- As the top coat of the polyester doesn't show a good curing, a primer is applied to re-enforced this top layer (a peel ply or a sanding are also good solutions)
- Simple dosing machine (pressurized tank) is feed by pail
- H6236 offers toughness and high bonding. All tests done show substrate failure
- Lloyd's approval : this product is approved by Lloyd's for Marine application. No question mark on performances ! This approval includes fatigue test done on million of cycles
- Product is available in 3 cure speeds, including one for hand mix (the slowest)