

# NAUTIC LIGHT ADHESIVE

## NAUTIC LIGHT TIX ADHESIVE

**Description:**

Nautic Light is a polyester adhesive for professional use in the construction of yachts, boats, canoes, caravans and other laminate structures. Its primary use is for sandwich constructions, where polyurethane or polyvinyl chloride foams are glued to polyester or epoxy laminates. It may also be used for joining other elements made of wood, plywood, glass fibre and other materials, but only in places that do not transmit large mechanical loads or which are additionally strengthened by laminates. In addition, thanks to a specially chosen rheology, the Nautic Light Tix 30 adhesive does not trickle down vertical surfaces when applied in thicker layers (ca. 3 cm).

The use of special fillers makes it possible to obtain a very low mass density (ca. 0.6 g/cm<sup>3</sup>) and reduce shrinkage when curing to below 1 %.

Nautic Light is available in two versions: Nautic Light 15 and Nautic Light 30. They differ in gelation time (15 and 30 minutes, respectively) and mechanical properties. The versions Nautic Light 15W and Nautic Light 30W are equipped with a colour change indicator that shows if the adhesive has been properly mixed with the hardener.

**Substrates:**

- polyester laminates,
- epoxy laminates,
- plywood,
- wood,
- rigid polyurethane and PVC foams.

**Caution:** The adhesive should not be applied directly on one-component acrylic and nitrocellulose products.

**Surface preparation:**

- polyester and epoxy laminates: degrease, dry grind P80 – P120, degrease again with a silicone remover,
- plywood, wood: dry grind P80 – P120, then remove dust.

**Mixing ratio:**

NAUTIC LIGHT – 100 parts by weight,  
Hardener – 1 to 2 parts by weight.

**Supplementary products:**

Hardener – methyl ethyl ketone peroxide (e.g. METOX 50).

**Application life after mixing with the hardener:**

**NAUTIC LIGHT 15:** 10 to 20 minutes at 20°C (hardener: 2 %).

**NAUTIC LIGHT 30:** 25 to 35 minutes at 20°C (hardener: 2 %).

**NAUTIC LIGHT TIX 30:** 25 to 35 minutes at 20°C (hardener: 2 %).

**Curing time:**

**NAUTIC LIGHT 15:** 1.5 to 2 hours at 20°C (hardener: 2 %).

**NAUTIC LIGHT 30:** 2 to 3 hours at 20°C (hardener: 2 %).

**NAUTIC LIGHT TIX 30:** 2 to 3 hours at 20°C (hardener: 2 %).

**Coatability:**

Polyester finishing filler, polyester spray filler, acrylic primers.

**Procedure:**

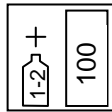
Mix the components thoroughly. Observe the required amount of hardener. Apply a layer not thicker than 10 mm with a trowel. The viscosity of the cured surface improves the adhesion of the following layers. If needed, it may be removed with an NC solvent. Minimal application temperature: +10°C.



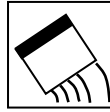
Clean and grind the surface



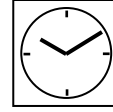
Degrease



Ratio by weight:  
100+1-2  
Pot life:  
15: 10 - 20 min./20°C  
30: 25 - 35 min./20°C



Apply



15: 1.5 – 2 h/20°C  
30: 2 – 3 h

**Specific gravity:**

0.600 g/cm<sup>3</sup>

**Colour:**

Green

**Volumetric shrinkage:**

1 % max.

**Chosen properties:**

Type of adhesive	Tear strength [MPa]	Ultimate elongation [%]	Bending strength [MPa]	Maximum deflection bend test [%]
Nautic Light 15	8÷12	2÷6	10÷20	10÷20
Nautic Light 30	8÷12	2÷6	10÷20	10÷20
Nautic Light Tix 30	8÷12	6÷10	15÷25	10÷20

Resistance tests have been carried out according to the norms PN EN-ISO 527 and PN EN-ISO 179.

**Polish Register of Shipping (PRS) approval:**

No. TT/1222/710250/07 (excluding the Nautic LIGHT TIX 30 adhesive)

**Equipment cleaning:**

NC solvent.

**Storage conditions and shelf life:**

Store in a dry and cool place, away from sources of fire and heat.  
Avoid direct exposure to sunlight.  
Adhesive: 6 months at 20°C.

**Safety requirements:**

See the Safety Data Sheet of the product in question.



The effectiveness of our systems results from laboratory research and many years of experience. We ensure high quality, provided the user follows the instructions and the work is performed in accordance with good construction practices. We may not be held liable for defects if the final results were affected by factors beyond our control.  
NOVOL Sp. z o.o., Komorniki, PL