

## NAUTIC VE 60 ADHESIVE

**Description:**

NAUTIC VE 60 is a two-component Vinylester-based product for professional use. Despite the fact that it does not contain fibreglass, it has a very good resistance (ca. 20 MPa). It is used to join, fasten and fill construction elements made of polyester or epoxy laminates. It works perfectly with these types of materials due to the resin base used. It is easy to apply and has low shrinkage. Its properties ensure durable and strong connections.

**Substrates:**

- polyester laminates,
- epoxy laminates,
- plywood,
- wood.

**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 VE 60 – 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 VE 60:** 50 to 60 minutes at 20°C (hardener: 2 %).

**Curing time:**

**NAUTIC VE 60:** 2 to 3 hours at 20°C (hardener: 2 %).

**Colour:**

**NAUTIC VE 60:** Grey

**Coatability:**

NAUTIC VE 60 works well with all NAUTIC products from NOVOL, as well as polyester finishing fillers, polyester spray fillers and acrylic primers.

**Procedure:**

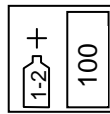
Mix the components thoroughly. Observe the required amount of hardener. Apply a layer not thicker than 10 mm with a trowel. Minimal application temperature: +10°C.



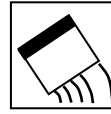
Clean and grind the surface



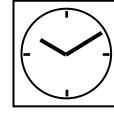
Degrease



Ratio by weight:  
100+1-2  
Pot life: 50 - 60 min.



Apply



2 – 3 h/20°C

**Specific gravity:**

**NAUTIC VE 60:** 1.05 – 1.15 g/cm<sup>3</sup>

**Volumetric shrinkage:**

1 % max.

**Chosen properties:**

Type of adhesive	Tear strength [MPa]	Ultimate elongation [%]	Bending strength [MPa]	Maximum deflection bend test [%]
Nautic VE 60	15÷25	0.8÷1.2	30÷40	1.5÷2.5

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

**Equipment cleaning:**

NC solvent.

**Storage conditions and shelf life:**

Store in tightly sealed containers in a cool and well-ventilated place, away from sources of fire and heat. Avoid direct exposure to sunlight.  
NAUTIC VE 60: 6 months at 20°C.

**Safety requirements:**

See the Safety Data Sheet of the product in question.

**Packaging:**

NAUTIC VE 60 is delivered in unit packages individually agreed upon with the customer.

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