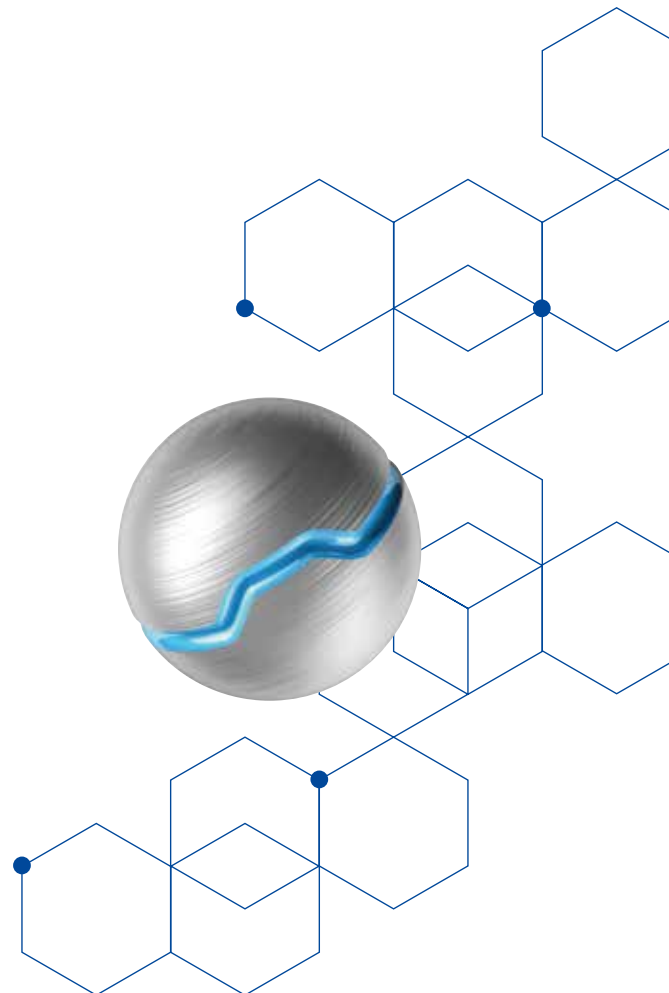


BÜFA®-Bonding Paste Portfolio

**Powerful Connections
From Standard to Special Bonding Applications**





BÜFA®-Bonding Pastes

Bonding Paste Solutions for Efficiency and Process Reliability

Reliable bonding is a decisive success factor for durable, economical and safe composite components.

With BÜFA®-Bonding Pastes, you have access to a modular and comprehensive portfolio specifically designed to meet varying requirements – from standard to special bonding applications in composite manufacturing. Whether for sandwich structures, low-shrinkage or elastic systems, pigmented bonding pastes or fibre reinforced variants: you will find the right solution with us. Different densities filled and unfilled systems as well as more sustainable alternatives provide high flexibility in design and processing.

A large part of BÜFA®-Bonding Pastes are suitable for machine processing and can be efficiently applied using BÜFA®-Tec Bonding Paste Unit systems – such as the Gamma 4 for 25-liter drums or the Theta 11 for 225-liter drums.

This enables reproducible processes, consistent material quality and a significant reduction in manual workload.

Our clearly structured product categories ensure fast and reliable material selection. If standard solutions are not sufficient, we develop individual, practical systems together with you – tailored to process, component and target market.

BÜFA follows a clear approach: technically proven systems, process-reliable application and flexibility for adaptation to industry, component geometry and load profile.

This results in solutions that simplify processes, minimize risks and provide long-term investment security – from initial idea to series production. BÜFA®-Bonding Pastes stand for tested quality, technological innovation and true application expertise. They reduce assembly effort, enable lighter constructions and open new design as well as manufacturing possibilities.

Benefit from application-specific solutions. Talk to us. We deliver the connection that drives your project forward.



BÜFA®-Bonding Paste

Benefits of BÜFA®-Bonding Pastes

High Process Reliability

Different systems with excellent properties tailored to specific applications ensure reproducible results – even with demanding component geometries.

Reliable Mechanical Performance

BÜFA®-Bonding Pastes provide stable bonds for durable composite assemblies.

Adaptability to Industry and Application

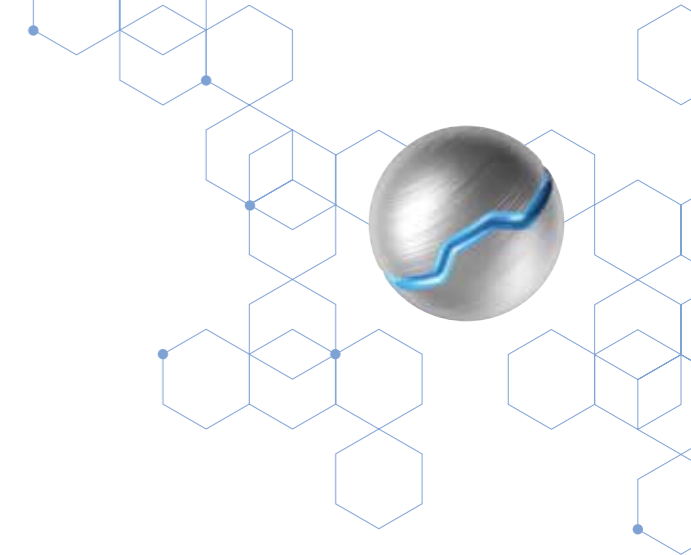
Many products are certified and serve as base solutions. They can be adapted to meet specific standards, requirements or application environments.

Technical Expertise and Consulting Competence

BÜFA supports you not only with products, but with in-depth application know-how along the entire value chain.

Machine Processing

- The BÜFA®-Tec BPU Gamma 4 is specifically designed for processing bonding pastes from 25-liter hobbocks and is particularly suitable for fiber- and hollow-sphere-free products. Also available as a dosing station.
- The BÜFA®-Tec BPU Theta 11 is specifically designed for processing bonding pastes from 225-liter drums and is particularly suitable for fiber- and hollow-sphere-free products. Also available as a dosing station.



Mechanical Measurements



Different Bondings with BÜFA®-Bonding Pastes



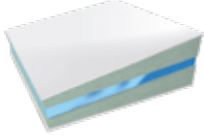
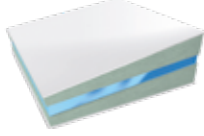
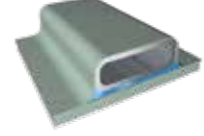
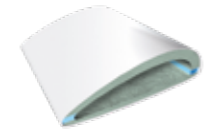
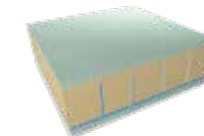
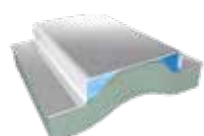

BÜFA®-Tec BPU Gamma 4 Hobbock Production

BÜFA®-Bonding Paste Options

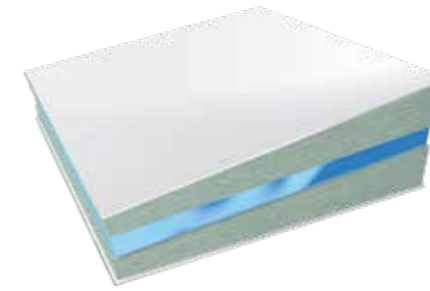
This differentiation enables safe, application-oriented product selection based on load level, safety requirements and component function.

Within each category, additional application-specific products are available and can be individually selected depending on industry, standards or process conditions.

Product Categories Overview

Category	Product Name	Item No.	Typical Application
 <p>Standard Bondings</p>	BÜFA®-Bonding Paste 0600	7400600	Bonding paste for non-load-bearing functional connections of composite components without increased mechanical or thermal requirements
 <p>Structural Bondings</p>	BÜFA®-Bonding Paste 0588	7400588	Fiber-reinforced bonding paste for structural joints with defined load transfer and permanent mechanical stress
 <p>Bonded Joints with Metal and Wood</p>	BÜFA®-Bonding Paste 0139	7400139	Tough elastic bonding paste for stress-compensating joints between different substrates such as GRP, metal, and wood
 <p>High Strength Bondings</p>	BÜFA®-Bonding Paste 0110	7400110	Bonding paste for highly stressed, load bearing, structural applications with very high mechanical and dynamic loading capacity
 <p>Sandwich Constructions</p>	BÜFA®-Bonding Paste 0072	7400072	Lightweight construction-optimized bonding paste for bonding cover layers to foam or balsa cores in sandwich constructions
 <p>Optimal Laminate Constructions</p>	BÜFA®-Bonding Paste 0181	7400181	Special adhesive and laminate systems for improved fiber bonding, surface quality, and structural integrity of laminate structures
 <p>Special Bonding Pastes</p>	BÜFA®-Bonding Paste Specialties	740xxxx	Application-specific bonding paste for special requirements such as increased temperature, chemical fire protection, or process requirements outside of standard applications

The products shown form the basis within their category. Depending on the industry, standard requirements, temperature load or safety requirements, other BÜFA®-Bonding Pastes are available: for higher structural loads, for special environmental conditions or for customer-specific processes.



Standard Bondings BÜFA®-Bonding Paste 0600 Item No. 7400600

Application

Standard bonding is used to reliably join composite components without safety-related or load-bearing functions. The focus is on process reliability, cost-effectiveness and ease of processing.

Typical requirements

- No or low structural loads
- No increased requirements for heat resistance
- Uniform force transmission for non-safety-critical components
- High stability for vertical or complex geometries

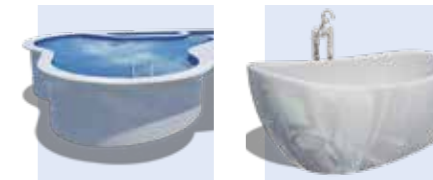
Product recommendation

BÜFA®-Bonding Paste 0600 as a fibre-reinforced standard bonding paste for cured GF-UP laminates

Key benefits

- Excellent stability, even on vertical surfaces
- Simple, manual processing
- Reduced material and process costs
- Reproducible results in series applications
- Clear distinction from structural applications ensures application safety

Typical application sectors and benefits



Sanitary, Swimming Pools and Leisure Industry

- Economical bonding of large components
- Clean surfaces without mechanical fasteners



Vehicle and interior construction

- Secure connection of functional components
- Reduced assembly effort and weight savings



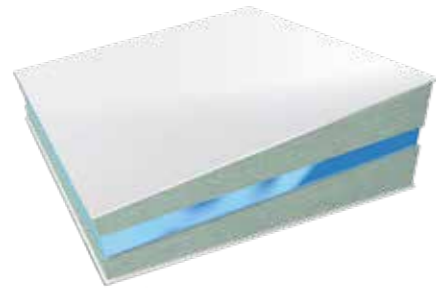
Industrial and series production

- High process stability
- Good scalability for series processes

Variants of BÜFA® Bonding Paste 0600

Description	Item No.	Differentiating features
BÜFA®-Bonding Paste 0600	7400600	
BÜFA®-Bonding Paste 0601	7400601	Like 7400600, medium gel time, without glass fibre reinforcement
BÜFA®-Bonding Paste 0602	7400602	Like 7400600, with a shorter gel time

Please find additional characteristics on page 12 and 14



Structural Bondings BÜFA®-Bonding Paste 0588 Item No. 7400588

Application

Structural bonding is used wherever components have to withstand permanent loads or perform safety-related functions. The focus is on mechanical performance, long-term stability and controlled force transmission

Typical requirements

- Mechanically stressed or load-bearing components
- Permanent load-bearing capacity
- High bond strength between cured laminates

Product recommendation

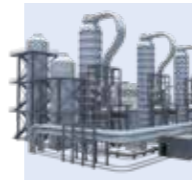
BÜFA®-Bonding Paste 0588

as a fibre-reinforced, structural bonding paste for GF-UP laminates with moderate structural requirements

Key benefits

- Glass fibre reinforcement for improved load transfer
- Good mechanical performance for structural applications
- Process-reliable processing with defined layer thicknesses
- Suitable for fixing applications due to short cycle times

Typical application sectors and benefits



Mechanical and Plant Engineering

- Reliable structural bonding of GRP components
- Uniform stress distribution in the component



Automobiles and Commercial Vehicles

- Reduction of mechanical fasteners
- Fixing applications



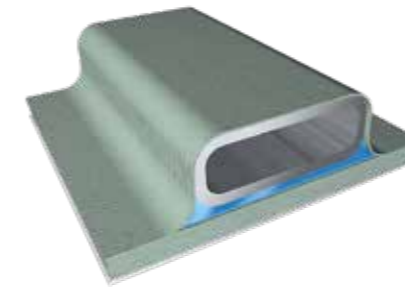
Building and Construction

- Durable, load-bearing composites
- Proven solutions for structural applications

Variants of BÜFA®-Bonding Paste 0588

Description	Item No.	Differentiating features
BÜFA®-Bonding Paste 0588	7400588	
BÜFA®-Bonding Paste 0185	7400185	Variant of 7400588, longer geltimes
BÜFA®-Bonding Paste 0250	7400250	Versatile, flexible bonding paste, medium geltimes
BÜFA®-Bonding Paste 4410	7404410	Like 7400250, shorter geltimes, medium viscosity, white
BÜFA®-Bonding Paste 4425	7404425	Like 7400250, medium geltimes, white

Please find additional characteristics on page 12 and 14



Bonded Joints with Metal and Wood BÜFA®-Bonding Paste 0139 Item No. 7400139

Application

This category refers to the bonding of different materials, in particular the bonding of composite components to metal or wood substrates. The focus is on tough, elastic, tolerance-compensating bonds and secure adhesion in the event of material-related stress differences.

Typical requirements

- Different thermal expansions of the joined parts
- Ductile adhesive bond for stress absorption
- Good adhesion to heterogeneous substrates
- No increased requirements for heat deflection temperature

Product recommendation

BÜFA®-Bonding Paste 0139

as a fiber-reinforced bonding paste for bonding cured GF-UP laminates

Key benefits

- Ductile adhesive bonds in the cured state
- Glass fiber reinforcement for stable, resilient composites
- Good gap bridging due to paste-like consistency
- Suitable for manual and, to a limited extent, machine processing
- Proven solution for bonding different materials

Typical application sectors and benefits



Interior Fittings and Industrial Components

- Secure wood-GRP and metal-GRP bonding
- Clean appearance without mechanical connecting elements



Vehicle and Interior Construction

- Joining GRP structures with metal components
- Damping vibrations and material stresses



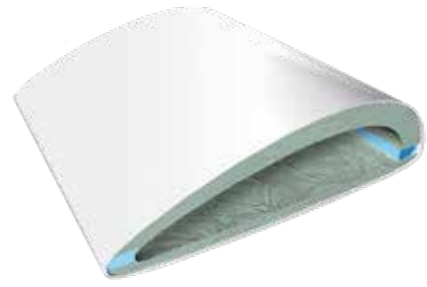
Mechanical and Plant Engineering

- Combination of different materials in assemblies
- Durable, low-maintenance connections

Variants of BÜFA®-Bonding Paste 0139

Description	Item No.	Differentiating features
BÜFA®-Bonding Paste 0139	7400139	
BÜFA®-Bonding Paste 0141	7400141	Modified version of 7400139, white

Please find additional characteristics on page 12 and 14



High Strength Bondings BÜFA®-Bonding Paste 0110 Item No. 7400110

Application

High-strength bonds are designed for applications with high dynamic, mechanical and, in some cases, chemical loads. They perform load-bearing functions and are used where maximum strength and long-term stability are required.

Typical requirements

- High loads
- Load-bearing or safety-related functions
- Wide range of applications with regard to temperature
- Very high mechanical and chemical resistance

Product recommendation

BÜFA®-Bonding Paste 0110

for bonding laminates that are exposed to high dynamic loads.

Key benefits

- Excellent mechanical strength
- Good stability even with machine application
- High dynamic load capacity
- Wide temperature range
- Suitable for highly stressed structural applications
- DNV certified

Typical application sectors and benefits



Wind Energy

- Developed for rotor blade bonding
- Must be tested on a case-by-case basis
- Permanent load bearing under dynamic stress



Boat Building and Maritime Applications

- Structural laminate bonding
- High resistance to mechanical and chemical stress



Pipe and Plant Construction

- High-strength pipe bonding
- Long-term stable connections under changing loads
- Chemical resistance

Variants of BÜFA®-Bonding Paste 0110

Description	Item No. .	Differentiating features
BÜFA®-Bonding Paste 0110	7400110	
BÜFA®-Bonding Paste 0111	7400111	Like 7400110 - with slightly higher thixotropy and stability during machine application
BÜFA®-Bonding Paste 0114	7400114	Like 7400110 - with a shorter gel time

Please find additional characteristics on page 12 and 14



Sandwich Constructions BÜFA®-Bonding Paste 00072 Item No. 7400072

Application

Sandwich bonding pastes are used to securely bond cover layers to lightweight core materials. The aim is to achieve optimum load transfer with minimum weight.

Typical requirements

- Low density for weight reduction
- Good wetting of core materials
- High adhesion between top layer and core
- Suitable for foam and balsa cores

Product recommendation

BÜFA®-Bonding Paste 0072

as a sandwich bonding paste for bonding and constructing lightweight structures.

Key benefits

- Proven solution for lightweight construction applications
- Very good workability due to creamy consistency
- Secure bonding of laminate and core material
- Very good flow properties for filling foam core cavities

Typical application sectors and benefits



Vehicle and Special Vehicle Construction

- lightweight and sandwich panels
- combination of rigidity and weight reduction



Boat and Shipbuilding

- bonding of deck layers with foam or balsa cores
- high structural efficiency with low weight



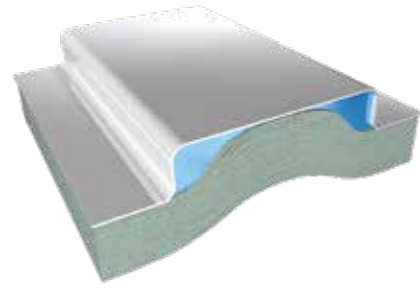
Construction and Infrastructure Components

- sandwich panels for façades and structural elements
- durable composites with reduced dead weight

Variants of BÜFA®-Bonding Paste 0072

Description	Item No.	Differentiating features
BÜFA®-Bonding Paste 0072	7400072	
BÜFA®-Bonding Paste 0073	7400073	Like 7400072, with the lowest density of 0.6 g/ml, longer open times and higher thixotropy
BÜFA®-Bonding Paste 0053	7400053	Similar to 7400072, longer open times and higher thixotropy
BÜFA®-Bonding Paste 0015	7400015	Similar to 7400072 with higher density, more cost-effective

Please find additional characteristics on page 12 and 14



Optimal Laminate Constructions BÜFA®-Bonding Paste 0181 Item No. 7400181

Application

Liquid mat systems serve as a liquid laminate layer between the gelcoat and glass mat. The aim is to improve surface quality and ensure secure fibre bonding in complex geometries.

Typical requirements

- Good wetting of the glass fibres
- Avoidance of air pockets and cavities in tight radii and edges
- Compensation/elimination of sharp edges and unevenness in difficult mould geometries
- High impact strength and elongation at break

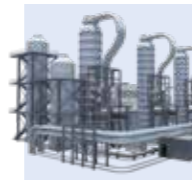
Product recommendation

BÜFA®-Bonding Paste 0181 as an adaptable liquid mat for complex component geometries.

Key benefits

- Very good mechanical properties
- High impact strength and elongation at break
- Smoothing of contours in complex component geometries
- Prevention of fibre lifting and cavities
- Improved laminate build-up result
- Easy processing in radii and edges (brush)
- Simplification and acceleration of laminating processes
- Less reworking/repairs

Typical application industries and benefits



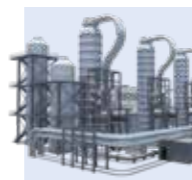
Plant and Equipment Engineering

- Robust laminate joints
- Long component life



Vehicle and Special Vehicle Construction

- Robust and resistant composite components
- Safety under dynamic loads



Industry and Series Production

- Reproducible laminate quality
- Reduced reject rates



Special Bonding Pastes Individual · Application-oriented

Special bonding pastes from the BÜFA®-Bonding Paste portfolio are individually developed solutions that go beyond standard and structural bonding.

In close cooperation with the user, tailor-made products are created that are specifically designed to meet their requirements and operating conditions.

Typical requirements

- Tailor-made solutions for individual applications
- Designed for defined technical and process-specific requirements
- Complement the existing BÜFA® Bonding Paste portfolio
- Developed in close consultation with the user

Key benefits

- Tailor-made product solutions instead of compromises
- High application reliability
- Technical consulting and development from a single source



Are you looking for a product solution beyond the existing BÜFA®-Bonding Paste portfolio?

Then please contact us so that we can discuss your requirements. Together, we will find or develop the right product for your application.

Your contact:

Gerriet Lange
Market and Customer Support
Phone +49 1705748254
Gerriet.Lange@buefa.de

Variants of BÜFA®-Bonding Paste 0181

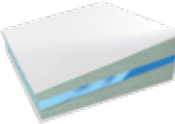
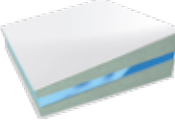
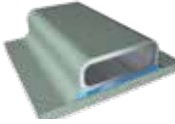
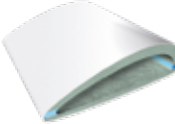
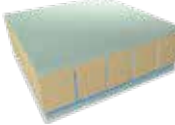
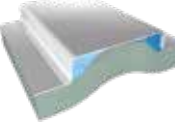

Description	Item No.	Differentiating features
BÜFA®-Bonding Paste 0181	7400181	
BÜFA®-Bonding Paste 0182	7400182	Liquid Mat - similar to 7400181 - higher exothermicity and viscosity
BÜFA®-Firestop-Liquid Mat 0245	7150245	Liquid Mat - with good mechanical properties and fire protection features

Please find additional characteristics on page 12 and 14

Description	Item No.	Differentiating features
BÜFA®-Fine Body Filler Spray	7400002	Repair filler in a spray setting. The filler is primarily characterised by good sanding and polishing properties, fast curing and excellent adhesion to most substrates
BÜFA®-Bonding Paste 0119	7400119	Structural bonding paste with excellent mechanical and chemical properties and an HDT of 105 °C
BÜFA®-Bonding Paste 0188	7400188	Bonding paste for high layer thicknesses (up to 10 cm) with low density and high thixotropy. It is suitable for both standard bonding and gap filling applications up to a layer thickness of 10 cm
BÜFA®-Bonding Paste 0410	7400410	This bonding paste is characterised by its high chemical and/or hydrolysis resistance. It is recommended for bonding GF-UP with hard PVC parts

Please find additional characteristics on page 12 and 14

Processing properties

Bonding Paste Category	Description	Item No.	Density g/ml	Geltime min	Fibre reinforced	Machine Applicable
Standard Bondings 	BÜFA®-Bonding Paste 0600	7400600	1,4	37	Yes	not specified
	BÜFA®-Bonding Paste 0601	7400601	1,46	25	No	BÜFA®-Tec BPU VP Gamma4 / BÜFA®-Tec BPU Theta11
	BÜFA®-Bonding Paste 0602	7400602	1,46	29	Yes	not specified
Structural Bondings 	BÜFA®-Bonding Paste 0588	7400588	1,25	10	Yes	not specified
	BÜFA®-Bonding Paste 0185	7400185	1,4	27	Yes	not specified
	BÜFA®-Bonding Paste 0250	7400250	1,36	20	No	BÜFA®-Tec BPU VP Gamma4 / BÜFA®-Tec BPU Theta11
	BÜFA®-Bonding Paste 4410	7404410	1,36	9	No	BÜFA®-Tec BPU VP Gamma4 / BÜFA®-Tec BPU Theta11
	BÜFA®-Bonding Paste 4425	7404425	1,36	25	No	BÜFA®-Tec BPU VP Gamma4 / BÜFA®-Tec BPU Theta11
Bonded Joints with Metal and Wood 	BÜFA®-Bonding Paste 0139	7400139	1,33	20	Yes	not specified
	BÜFA®-Bonding Paste 0141	7400141	1,3	20	Yes	not specified
High Strength Bondings 	BÜFA®-Bonding Paste 0110	7400110	1,1	62	No	BÜFA®-Tec BPU VP Gamma4 / BÜFA®-Tec BPU Theta11
	BÜFA®-Bonding Paste 0111	7400111	1,1	62	No	BÜFA®-TecBPU VP Gamma4 / BÜFA®-Tec BPU Theta11
	BÜFA®-Bonding Paste 0114	7400114	1,1	35	No	BÜFA®-Tec BPU VP Gamma4 / BÜFA®-Tec BPU Theta11
Sandwich Constructions 	BÜFA®-Bonding Paste 0072	7400072	0,74	35	No	not specified
	BÜFA®-Bonding Paste 0073	7400073	0,6	67	No	not specified
	BÜFA®-Bonding Paste 0053	7400053	0,71	52	No	not specified
	BÜFA®-Bonding Paste 0015	7400015	0,9	29	No	not specified
Optimal Laminate Constructions 	BÜFA®-Bonding Paste 0181	7400181	1,26	30	Yes	not specified
	BÜFA®-Bonding Paste 0182	7400182	1,2	15	Yes	not specified
	BÜFA®-Firestop-Liquid Mat	7150245	1,53	30	Yes	not specified
Special Bonding Pastes 	BÜFA®-Fine Body Filler Spray	7400002	1,41	9	No	Polycon Spray Gun
	BÜFA®-Bonding Paste 0119	7400119	1,21	35	Yes	not specified
	BÜFA®-Bonding Paste 0188	7400188	0,8	29	Yes	not specified
	BÜFA®-Bonding Paste 0410	7400410	1,2	24	No	BÜFA®-Tec BPU VP Gamma4 / BÜFA®-Tec BPU Theta11

These typical characteristic values serve as a guide.

Processing of BÜFA®-Bonding Pastes

Processing

- Stir the material homogeneously and gently before processing
- Substrates must be clean, dry, grease-free and stable
- Mechanical pre-treatment of the adhesive surfaces is recommended
- Cure exclusively with suitable organic peroxides
- Hardener type and dosage according to technical data sheet
- Process within the recommended temperature range
- Adhere to recommended layer thicknesses
- Carry out your own application tests before series release

Storage & handling

- Store in original sealed containers
- Store in a cool, dry place protected from sunlight
- Recommended storage temperature up to max. 20 °C
- Avoid frost
- Seal opened containers tightly
- Observe processing warranty according to technical data sheet

The applicable technical data sheets and safety data sheets must be observed.

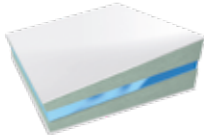
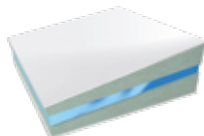
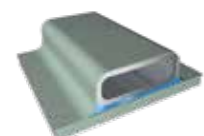
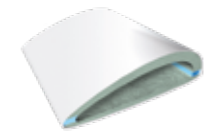
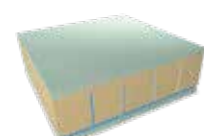
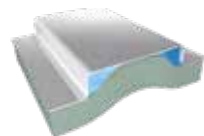

The above information has been compiled to the best of our knowledge and is based on our current knowledge and experience.

This information is solely for product description purposes and does not constitute any guarantee of quality or durability. The processor is obliged to carry out their own tests and investigations in order to take responsibility for the processing and application of our products in their area of application. The current version of the corresponding EU safety data sheet must also be observed.



Processing of BÜFA®-Bonding Paste

End properties

Bonding Paste Categorie	Description	Item No.	Heatdeflection temperature (HDT) °C	Tensile strength N/mm	Fracture elongation %	Modulus of elasticity** N/mm ²	Maritime Approvals
Standard Bondings 	BÜFA®-Bonding Paste 0600	7400600	81,1	44,0	0,7	7156	-
	BÜFA®-Bonding Paste 0601	7400601	73	39,6	0,7	6614	-
	BÜFA®-Bonding Paste 0602	7400602	not specified	not specified	not specified	not specified	-
Structural Bondings 	BÜFA®-Bonding Paste 0588	7400588	88,2	59,5	2,6	4341	-
	BÜFA®-Bonding Paste 0185	7400185	93,3	58,1	1,8	5193	-
	BÜFA®-Bonding Paste 0250	7400250	41,5	32,0	1,8	3851	-
	BÜFA®-Bonding Paste 4410	7404410	75,5	not specified	not specified	not specified	-
Bonded Joints with Metal and Wood 	BÜFA®-Bonding Paste 0139	7400139	32,8	14,2	15	530	DNV
	BÜFA®-Bonding Paste 0141	7400141	33,1	14,3	16	582	DNV
High Strength Bondings 	BÜFA®-Bonding Paste 0110	7400110	60,5	41,8	1,7	3514	DNV
	BÜFA®-Bonding Paste 0111	7400111	60,7	44,2	2,0	3934	DNV
	BÜFA®-Bonding Paste 0114	7400114	60,2	42,5	1,9	3437	DNV
Sandwich Constructions 	BÜFA®-Bonding Paste 0072	7400072	46,2	17,8	3,3	1113	-
	BÜFA®-Bonding Paste 0073	7400073	47,4	20,5	2,6	1371	-
	BÜFA®-Bonding Paste 0053	7400053	not specified	not specified	not specified	not specified	-
	BÜFA®-Bonding Paste 0015	7400015	63,8	16,7	0,7	2715	-
Optimal Laminate Constructions 	BÜFA®-Bonding Paste 0181	7400181	73,9	54,6	1,4	5121	-
	BÜFA®-Bonding Paste 0182	7400182	92,6	58,7	2,7	3711	-
	BÜFA®-Firestop-Liquid Mat	7150245	not specified	not specified	not specified	not specified	-
Special Bonding Pastes 	BÜFA®-Fine Body Filler Spray	7400002	81,3	not specified	not specified	not specified	-
	BÜFA®-Bonding Paste 0119	7400119	105	62,4	1,4	5891	-
	BÜFA®-Bonding Paste 0188	7400188	90,1	27,3	1,1	3222	-
	BÜFA®-Bonding Paste 0410	7400410	75,5	46,1	1,9	3240	-

These typical characteristic values were determined on tempered test specimens under optimal laboratory conditions and correspond to the status as of 02-26.

Final properties of the components

- Permanently resilient and reliable adhesive bonds
- Uniform force transmission for stable component structures
- Reproducible quality through defined routines
- High dimensional and shape stability in long-term use
- Adaptable performance depending on requirements, e.g., temperature, chemical, or viscoelastic resistance
- Basis for durable, low-maintenance composite components



The Complete Range for the User of Composite Materials



UP- & VE-Resins,
Epoxy Resin Systems



Gelcoats & Topcoats



Bonding Pastes



Pigment Pastes



Sustainable Products



Conductive Products



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Additives
& Ancillaries



Reinforcements,
Core & Non-woven
Materials



Fire Retardant
Systems



Tooling Systems



Foaming Resin
Systems



BÜFA Tec
Machine Technology

BÜFA

New chemistry.

BÜFA Composite Systems GmbH & Co. KG
Hohe Looge 2-8
26180 Rastede | Germany

Phone +49 4402 975-0
compositesystems@buefa.de
buefa-composites.com



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AdobeStock(C)chawa, AdobeStock(C)daniy,
AdobeStock(C)TomaszZajda, AdobeStock(C)florynstudio3

The information given above is based on our current knowledge and experience. In view of the many factors that may influence working conditions and application, the user is not relieved from carrying out his own tests and trials. No legally binding warranty of certain properties or suitability for a particular purpose can be derived from this information. It is the responsibility of the receiver or user of our products to observe proprietary rights as well as existing laws and regulations. The latest version of the EU Safety Data Sheet must also be observed. For Technical Data Sheets and information, go to www.buefa-composites.com