

NORCOL 406

Product Description

NORCOL 406 is a thixotropic, pre-accelerated bonding paste formulated with orthophthalic resin. It is recommended for the adhesion of polyester parts in thin joints, filling applications, assembling polyester parts. This bonding paste without shrinkage is reinforced with fiber and it has good mechanical properties. It contains a blue indicator of catalyst ensuring the good distribution and mixing of the catalyst.

Physical Properties of liquid bonding paste (SV version)

Brookfield Viscosity 23°C-sp95-cPoise-0.5rpm	ISO 2555	3900 - 5500 (x1000)
Specific gravity at 23°C	ICON012	1.42 - 1.46
Solid Content - %	ICON003	75 - 77
Storage stability 20°C- months	-	6

Reactivity

Gel Time at 23°C 2 % MEKP (M50) on 100g-minutes	ICON002	10
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Viscosity & Gel time versions available

	NA	08	10	20	45
LV	X	X	X	X	X
SV	X	X	✓	✓	X
HV	X	X	X	X	X

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Application & Specificities

Recommendations before use	Application temperature between 18-25°C. Homogenize the product. 1,25 - 2,5% Methyl Ethyl Ketone Peroxide (MEKP). Mix the catalyst well.
Recommendations during use	If the bonding paste is mixed with peroxide by hand, it must be poured into another container and mixed intensively to ensure a homogeneous mix of peroxide into the bonding paste. Application with a spatula.
Substrate preparation	Surfaces to be bonded should be clean and dry. For better adhesion, sand lightly and clean with acetone before applying the bonding paste.
Thickness	2 to 8 mm
Handling bonded parts	Handling bonded parts after 4 hours. They are completely polymerised after 24 hours (minimum temperature of 18°C)

Storage

The product must be stored in its original closed packaging at a temperature between 15°C and 25°C, away from direct sunlight. It is the responsibility of the customer to ensure that the product is used in good conditions before the use by date mentioned on the keg. The product is subject to the Highly Flammable Liquids Regulations. Please follow the MSDS of this product in order to make sure the operators wear the appropriate personal protective equipment during usage of the product.

All these results were obtained from our internal laboratory tests. Results given in this document are indicative and, to the best of our knowledge, are reliable but cannot be taken as liability. We cannot endorse any responsibility for parts manufactured with this product.