

 NORD COMPOSITES	TECHNICAL DATA SHEET	CD 404 Bonding paste polyester NTC 013 G – 01/12/17 Page : 1/1
--	-----------------------------	---

1. CHARACTERISTICS

NORCOL 404 is a bonding paste with fiber, clear, pre-accelerated, flexible.

- Flex, charged with filler permits a resistant bonding for polyester parts subject to high mechanical solicitations.
- Polyester bonding paste pre-accelerated, which cures at room temperature following addition of MEKP.
- Low density to bond laminates with Balsa and PU but also to realize bond with polyester parts.

2. PROPERTIES OF LIQUID BONDING PASTE

Viscosity Brookfield (ISO 2555 - 23°C - sp96)	0.5 rpm: 9 000 - 15 000 (x1000) cP
Specific gravity (ICON 012)	0.76 - 0.80 g/cm3
Gel time Peak pro (23°C - 2% MEKP M50)	8 - 14 minutes
Non volatile content (ICON 003)	65 - 70%

3. PROPERTIES OF CURED BONDING PASTE

Tensile strength (ISO 527)	15 MPa
-------------------------------	--------

4. APPLICATION ADVISES

Mix well peroxide catalyst,

Percentage of catalyst to add: from 1% to 3% (never use less catalyst or more catalyst).

5. PACKAGING

Available in cans of 15 kg.

6. STORAGE CONDITIONS AND HANDLING

Storage life: bonding paste **NORCOL 404** is stable for 6 months from date of production. The product must be stored in original closed packaging at a temperature between 15°C and 25°C, away from direct sunlight.

It is the responsibility of the customer to assure that the product is used in good conditions overall before the date limitation mentioned on the keg.

This bonding paste is subject to the Highly Flammable Liquids Regulations.

IMPORTANT

*All of the results obtained according to trials in our laboratory. However, we don't be responsible of manufactured parts with **NORCOL 404**, if the application conditions specified are not respected.*

It is imperative that the user must also ensure that his application and his process are appropriate for this product to be used. We hereby the conformity of our products with the above specifications. We cannot be responsible for any damage caused by misuse of this product or use of the product for an application not covered in the design.