

## 1. CHARACTERISTICS

**NORCOL 304** is a bonding paste without fiber, colorless, a low density and pre-accelerated. It has a blue indicator of catalyse in standard version.

- Flexible bonding paste, well unctuous which enables an easy application with spatula or notched hackle.
- Polyester bonding paste pre-accelerated, which cures at room temperature following addition of MEKP.
- Low density to bond pieces like sandwiches, with balsa, PU, PVC foam...
- This bonding paste may be used to assembling polyester parts.
- Indicator of catalyse permits to check the good repartition of catalyst in bonding paste, so there is a homogeneous curing.
- **LLOYDS certified versions: CD304TH, CD304THLGT, certificate n° MATS/4807/1 of 29/07/2016.**

## 2. PROPERTIES

LIQUID BONDING PASTE	
Viscosity Brookfield (ISO 2555 - 23°C - sp95)	0.5 rpm: 800 - 1000 (x1000) cP
Specific gravity (ICON 012)	0.81 - 0.85 g/cm <sup>3</sup>
Gel time (ICON 002) (23°C - 2% MEKP on 100 g)	10 - 14 minutes
No volatile content (ICON 003)	70 - 75%

CAST BONDING PASTE	
Shrinkage (ICON 015)	0 %
Tensile strength (ISO 527)	15 MPa

## 3. VERSIONS

Available in:

- Long gel time version: **CD304LGT** with a gel time of 14 - 18 min (23°C - 2% MEKP M50 on 100 g).
- Thixotropic version: **CD304TH** or **CD304THNOIRE** with a viscosity at 5 rpm: 525 - 675 (x 1000) cP (23°C – sp95) and a specific gravity of 0.90 - 0.94.
- Thixotropic and long gel time version: **CD304THLG** with a viscosity at 0.5 rpm: 2600 - 3400 (x 1000) cP (23°C - sp95), a gel time of 27 - 32 min (23°C - 2% MEKP M50 on 100 g) and a specific gravity of 0.90 - 0.94.

## 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 20 kg.

## 6. STORAGE CONDITIONS AND HANDLING

Storage life: bonding paste **NORCOL 304** 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 **CD 304**, 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.*