



### 1. CHARACTERISTICS

**NORCOL 406** is a bonding paste with fiber, pre-accelerated, flexible and without shrinkage.

- Flexible bonding paste, reinforced with glassfiber chopped strands to give a resistant bonding between laminates put under heavy mechanical stress.
- Polyester bonding paste pre-accelerated, which cures at room temperature following addition of MEKP.
- Indicator of catalyst permits to check the good repartition of catalyst in bonding paste, so there is a homogeneous curing.
- Bonding Paste without shrinkage that gives a good stability to the assembled parts, no print through.

### 2. PROPERTIES OF LIQUID BONDING PASTE

Viscosity Brookfield (ISO 2555 - 23°C - sp96)	0.5 rpm : 6000 - 7000 (x 1000) cP
Specific gravity (ICON 012)	1.42 - 1.46 g/cm <sup>3</sup>
Gel time (ICON 002) (23°C - 2% MEKP M50 on 100 g)	6 - 10 minutes
No volatile content (ICON 003)	75 - 77%

### 3. PROPERTIES OF CURED BONDING PASTE

Tensile strength (ISO 527)	14 MPa
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Compression test according to norm ISO 604:

Tensile compression	39 MPa
Compression modulus	2568 MPa

Flexion test on 3 points according to norm NF ISO 178:

Deformation at break	0.55%
Flexion stress	17.7 MPa
Flexural modulus	3358 MPa

### 4. VERSIONS

This bonding paste is available in:

- Long gel time version, **CD406LGT** with a gel time of 20 - 26 min (23°C - 2% MEKP M50 on 100 g).
- Low viscosity version, **CD406LV** with a viscosity at 5 rpm: 750 - 1050 (x 1000) cP (23°C - sp96) and specific gravity of 1.40 - 1.44 g/cm<sup>3</sup>.

### 5. APPLICATION ADVISES

Mix well peroxide catalyst,

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

#### **IMPORTANT**

*All of the results obtained according to trials in our laboratory. However, we don't be responsible of manufactured parts with **CD 406**, 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.*



#### **6. PACKAGING**

Available in cans of 25 kg.

#### **7. STORAGE CONDITIONS AND HANDLING**

Storage life: bonding paste **NORCOL 406** 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.

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