

## 1 CHARACTERISTICS

**NORCOL 547** is a vinylester bonding paste.

- Bonding paste reinforced with fiber for optimum mechanical properties.
- Compatible with **NORESTER® 680** and **NORESTER® 2000** tooling system.
- Easy application with colour change to indicate curing.
- **CD547** had been designed to polymerise at room temperature following addition of MEKP.

## 2 PROPERTIES OF LIQUID BONDING PASTE

Brookfield viscosity (ISO 2555 - 23°C - sp96)	0,5 rpm : 4000 - 6000 (x1000) cP
Specific gravity (ICON 012)	1,10 - 1,20
No volatile content (ICON003)	70 - 75%
Gel time (ICON 002) (23°C - 2% MEKP M50 on 100 g)	6 - 10 minutes

## 3 PROPERTIES OF CAST BONDING PASTE

Tensile strength (ISO 527)	18 MPa
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## 4 APPLICATION ADVISES

Bonding paste applied with a spatula.

Surfaces to be bonded should be clean and dry. In case of any doubt, LSE laminating resin type or resin rich areas, the substrate should be sanded and acetone wiped.

The ambient temperature should be between 18 and 28°C and humidity less than 85%.

Mix the peroxide well, never put under 1% or over 3%.

This bonding paste must be very well mixed with peroxide.

We recommend a rate of MEKP M50 catalyst of 2% at 20°C and a working time maximum of 1 hour.

Thickness of the bonding paste: from 2 to 8 mm.

Bonded parts should be handled after 4 hours, and complete cure will be after 24 hours (minimum temperature 18°C).

## 5 PACKAGING

Available in can of 25 kg.

## 6 STORAGE CONDITIONS AND HANDLING

Storage life: bonding paste **NORCOL 547** 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 547**, 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.*