



### 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.

### 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 75 g)	10 - 14 minutes
No volatile content (ICON 003)	70 - 75%

CAST BONDING PASTE	
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 75 g).

### 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

Shelf life: **NORCOL 304** bonding paste is stable for 6 months from date of production. 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.

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

#### **IMPORTANT**

*All of the results have been obtained during the tests in our laboratory. However, we can't be held responsible of manufactured parts with the bonding paste **CD 304**, if the specified application conditions are not properly followed.*

*It is imperative that the user also ensures that his application and his process are appropriate for this product to be used.*

*We guaranty the conformity of our products with the above specifications. We cannot be held responsible for any damage caused by misuse of this product or use of the product for an application not occurred in this data sheet.*