NORPOL® FI-184

First Emission: 31/10/2024 Version: 1, 31/12/2025

Product type

Pre-accelerated bonding paste based on epoxy vinylester resin.
Cures at room temperature (15 - 25°C).

Appearance

Main resin characteristics

Bonding Paste
Cured using MEKP peroxide.
Good flexibility and good impact resistance
TC : catalyst indicator.
Without glass fiber

Main applications

All operations of gap filling, surface filling and sealing.

Moulding informations

Bonding paste without fibres for thin joints.
Offers excellent adhesion properties with GRP Composites.
Visocosity adapted for application using casting equipment.

Shelf life and storage

When the product is sealed in its original packing, stored indoors away from direct sunlight and direct heat sources and ideally at ambient temperature between 15°C and 25°C .

Precaution for handling

Surface to be bonded should be free from dust and contaminants which can adversely affect the bond adhesion strength.
Preparation of surface is recommended using light abrasion / sanding followed by cleaning with appropriate solvent.
The bonding paste is ready to use. Add the correct dosage of peroxide (1 to 3%) under normal workshop application conditions (15 and 25°C).
Make sure that the mixture is completely homogeneous.
Apply a uniform bead of bonding paste onto one of the surfaces and press parts together evenly to obtain the desired thickness of bond (greater than 5mm).
We recommend allowing sufficient time for cohesive bond to form between laminates before handling bonded parts.

FEATURES OF THE LIQUID RESIN (1)

Properties	*Test Method*	*Unit*	*Typical values*
Density - 23°C		g/cm³	**1.1-1.2**
Cone & Plate	ISO 2884-1999	mPa.s	**800 - 1000**
Brookfield HB B/ 5 rpm	A040	mPa.s	**115000 - 150000**
Reactivity	100 g + 2% MEKP LA		
25°C - 35°C		minutes	**50 - 90**
Curing time		minutes	**65-145**
Peak exotherm		°C	**75-105**
Storage stability at 23°C in the dark	MT-CU 002S	months	**4**

1) Thoroughly test in your applications before full-scale use. Geltimes may vary due to the reactive nature of these materials and due to different brands of curing additives. Always test on small scale before formulating large quantities.

PROPERTIES OF THE CURED UNREINFORCED RESIN (2)

2) Properties are typical values, based on material tested in our laboratories, but varies from sample to sample. Typical values should not be construed as a guaranteed analysis of any specific lot or as specification items.