

## 1- DEFINITIONS

Nord Appret polyester is a sprayable primer for the surfacing of plugs (models). These plugs can then be used to produce high quality moulds. It has good adherence to plugs made from wood, sanded laminated polyester, and polyester plug surfacing putties such as Nord Core Light (NCL 804 PRBV Grey).

## 2- CHARACTERISTICS

- ◆ Thixotropic, pre-accelerated.
- ◆ Cured at ambient temperature with the addition of catalyst MEKP(Butanox M50 type)
- ◆ Good spreadability
- ◆ Can be sanded
- ◆ Only available in a spray version

## 3- PROPERTIES OF LIQUID APPRET POLYESTER

<u>Brookfield Viscosity</u> (ISO2555 - 20°C – sp5)	5 rpm    160 +/-20 cps 50 rpm    25+/-3 cps
<u>Solids content</u> (ICON 003)	62 +/-1%
<u>Colour</u>	ivory

<u>Gel time</u> (20°C – 2 ml MEKP on 100gr)	11 +/-2 minutes
<u>Density</u> (ICON 012)	1.22 +/- 0.02

## 4- POLYMERISATION CHARACTERISTICS

Gel time on 100g

	15°C	20°C	25°C	30°C
1.5ml MEKP	24 min	13 min	8 min	6 min
2ml MEKP	18 min	12 min	7.5 min	5.5 min

The values at 15°C are given only as an indication, it is recommended to use the product at a temperature between 18 and 25°C.

*All these results are obtained from tests in our laboratory. Nord Composites cannot be responsible for moulds and fabricated parts made with NORD APPRET230, if the application conditions are not followed. The user must make sure beforehand that this system is appropriate for the application. We guarantee the conformity of our products with the specifications given above. We do not accept any responsibility for damage or loss caused by a misuse of this product.*

## 5- APPLICATION INSTRUCTIONS

- ◆ Stir the product well before use
- ◆ Apply with a cup gun with a nozzle of 2.5 (gravity pistol AC 15 G retailed by Composites Machines Système (CMS)), at a maximum pressure of 4 bars.
- ◆ Spray several thin layers in order to get an even film.
- ◆ It is also possible to dilute the product with 2 – 4% acetone to improve the spray application.
- ◆ To obtain optimum polymerization, the level of catalyst MEKP (Butanox M50 type) should be between 1% and 2% according to the size of the part to be made and room temperature (we recommend 20°C).
- ◆ To obtain the best results we recommend to apply 450 to 600 microns of **NORD APPRET 230** in several fine passes.

The base to spray on should be dry, de-greased and free from dust.

Plug types can be :

- Wooden plugs, smoothed down, filled if necessary and sanded.
  - Polyurethane plugs sprayed with a coating of machinable NORD CORE LIGHT **NCL 804 GRIS PRBV**
  - Polystyrene foam of density 25 Kg/m<sup>3</sup> minimum, laminated with a styrene free polyester reference **R 854** followed by an application of **NCL 804 GRIS PRBV**
- ◆ Leave 24 hrs at ambient temperature (18 to 25°C), before starting to dry sand manually or mechanically with a 240 grade paper.
  - ◆ For a high gloss finish we recommend a final application of polyester lacquer reference **NORD LAQUE 210**.

## 6- PACKAGING

Available in 5kg or 25kg cans.

## 7- STORAGE CONDITIONS

Shelf Life: 3 months

Sprayable polyester primer **NORD APPRET 230** is subject to the Highly Flammable Liquids Regulations. The resin should be stored under cool conditions in closed, opaque containers at a temperature not exceeding 25°C. Avoid exposure to heat sources such as direct sunlight.

A safety data sheet is available on request.

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