

1- DEFINITIONS

A polyester lacquer designed with very high gloss to provide a surface finish for plugs and models. It is possible to obtain a brilliant surface finish due to a high surface hardness and excellent gloss.

2- CHARACTERISTICS

- ◆ Thixotropic, pre-accelerated.
- ◆ Sprayable
- ◆ Cures at ambient temperature with the application of MEKP (Butanox M50 type)
- ◆ Can be sanded
- ◆ Non tacky surface
- ◆ High gloss surface

3- PROPERTIES OF THE LIQUID LACQUER

Brookfield viscosity (ISO2555 - 20°C – sp5)	5 rpm 140 +/-30 cps 50 rpm 22 +/-3 cps
Density (ICON 012)	1.13 +/- 0.03
Solid content (ICON 003)	65 +/-1%

Gel time (20°C- 2 ml MEKP on 100g	16 +/-2 minutes
Film drying time (20°C-2 ml MEKP)	1 hour

4- POLYMERISATION CHARACTERISTICS

Gel time on 100g

	15°C	20°C	25°C	30°C
GEL TIME 1.5mlPMEC	29 min	18 min	13 min	9 min
GEL TIME 2 ml PMEC	22 min	16 min	11 min	7 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 LAQUE 210 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- VERSIONS

Available in 3 tints: white **LAQ 210 BLANC**, clear grey **LAQ 210 GRIS** and black **LAQ 210 NOIR**.

Also available in a long gel time variant (**LGT**) with a pot life of 2hrs with 1.5% of MEKP at 20°C

Only available in a spray version

6- APPLICATION INSTRUCTIONS

- ◆ Mix well before use
- ◆ Use a cup gun with a nozzle of 1.75 or 2.5, gravity pistol type AC 15 G (marketed by Composites Machines Systèmes (CMS)), at a maximum pressure of 4 bars
- ◆ Spray with several fine layers to obtain the best film evenness. (Total recommended thickness of 400 to 500 microns).
- ◆ It is also possible to dilute the product with 2 – 4% ethyl acetate or acetone to improve viscosity and 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 the room temperature (we recommend 20°C).
- ◆ To obtain the best results we recommend to use the **NORD LAQUE 210** in conjunction with the primer / surfacer such as **NORD APPRET 230**.
- ◆ Wait 24 hrs at ambient temperature (typically 20°C), before starting to sand: dry sanding manually or mechanically with a 240 grade paper, then decrease to 320, 400, 600, 800 type ABRANET, then 1000 type ABRALON (sold by CMS).
- ◆ You can then start the polishing stages, using polishing pastes Profile 100, 300, and then 500 made by Farécla and marketed by CMS.
- ◆ For a final, ultra brilliant finish it is best to use Profile Glaze from Farécla.

7- PACKAGING

Available in 5kg or 25kg cans.

8- STORAGE CONDITIONS

Shelf life: 3 months

Sprayable polyester finishing lacquer **NORD LAQUE 210** 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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