

1 CHARACTERISTICS

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.

- 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

2 PROPERTIES OF LIQUID GEL COAT

Brookfield viscosity (ISO 2555 - 20°C - sp5)	5 rpm : 110 - 170 Poise 50 rpm : 19 - 25 Poise
Specific gravity (ICON 012)	1.10 - 1.16 g/cm ³
No volatile content (ICON 003)	64 - 66 %
Geltime (ICON 002) (20°C – 2% MEKP on 100 g)	14 - 18 minutes
Film drying time (20°C – 2% MEKP on 100g)	40 - 60 minutes

3 POLYMERISATION CHARACTERISTICS

Gel time	15°C	20°C	25°C	30°C
1.5 mL MEKP on 100g	29 min	18 min	13 min	9 min
2 mL MEKP on 100g	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.

4 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 2 hours with 1.5% of MEKP at 20°C

Available no pre-accelerated version (**NPA**) with a gel time 16 minutes with 0.2% Co6% and 2% MEKP at 20°C (Be careful not to mix the accelerator and the peroxide together. Add accelerator and the peroxide separately in the resin and well mix).

Only available in a spray version.

IMPORTANT

*All of the results obtained according to trials in our laboratory. However, we don't be responsible of manufactured parts with the **NORD LAQUE 210**, 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.

5 APPLICATION ADVICES

- 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 BV**.
- 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.

6 PACKAGING

Available in cans of 5 or 25 kg.

7 STORAGE CONDITIONS AND HANDLING

Storage life: **NORD LAQUE 210** is stable for 3 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.

The gel coat is subject to the Highly Flammable Liquids Regulations.

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