



Data Guide

NORSKI 421 - 4:1 EPOXY SYSTEM

PRODUCT DESCRIPTION

Norski 421 Epoxy system is a specifically designed epoxy laminating/sheathing and adhesive system for marine and general use. It has been developed to provide superior wetting out and curing characteristics at ambient temperature.

AREAS OF USE

- As the structural adhesive in composite systems.
- As a protective epoxy sheathing system on wooden and GRP hulls, with or without glass cloth.
- As a coating system on ferro-cement hulls.
- Designed to be used with a range of "glue" and "filler powders". Extend with fillers for gap fill gluing. Use with "fairing blend" or microballons as a structural fairing and filling compound.

APPEARANCE

Unfilled liquid of clear/translucent amber colour.

TYPE

A highly reactive epoxy resin of low viscosity, and modified polyamine curing agent.

PHYSICAL PROPERTIES

The 421 Epoxy system is especially formulated to have a low mixed viscosity. May require thickening with fumed silica/aerosol on porous surfaces to minimise excessive soakage.

MIXING RATIO

Use four parts standard resin to one part hardener by volume. No thinning required.

NOTE

The correct ratio must be adhered to. Varying the mix ratio will not slow or accelerate the cure time, but will decrease the physical properties of the cured system. Use soap and warm water to clean uncured resin off hands. Thoroughly mix the resin and hardener by stirring with a wide blade spatula for at least one minute.

POT LIFE

100gm mass at 25 degrees celcius will offer 15 - 25 minutes. Because the mixed resins gel quickly in a mass, when thoroughly mixed they should be poured out into a shallow pan.

CURE

Norski 421 system will cure at temperatures down to 10°C. Initial cure is overnight, but total cure is not attained for three to seven days, dependent on temperature. Post curing at 60°C overnight will increase the ultimate strength of the thin film. A handy hint for improving the curing characteristics of the 421 system in colder weather is to allow the mixed resin an induction period before application. That is, mix the resin and hardener, then allow it to stand in the container until the mixture reaches body temperature before use. Care should be exercised in case the resin gets too hot and polymerizes.

SUPPLIED

In the following sizes: 375ml, 750ml, 1.5 ltrs, 3ltrs, 6 ltrs.

SAFETY PRECAUTIONS:

Do not use near fire or flames. Harmful or fatal if swallowed. Use disposable gloves to avoid skin contamination. If resin comes into contact with skin, wash uncured resin off with soap and water. Wear safety glasses to avoid eye contamination. Mixed formulation contains Epoxy Resin and



Aminies. If swallowed do not induce vomiting. Give a glass of water. Contact a Doctor or the Poisons National Information Centre on 0800 764 766 (Urgent information only). Eye Contamination: hold es open and flood with water for at least 15 minutes. See a Doctor immediately