

CRYSTIC BP 90-78PA & CRYSTIC BP90-79PA

Fast Curing General Bonding Paste

Introduction

Crystic BP 90-78PA and Crystic BP 90-79PA are pre-accelerated orthophthalic polyester bonding pastes. They are non-sagging, filled compounds specifically designed for the assembly and bonding of GRP mouldings. Such applications include panels, inserts, internal frames, ribs and any other non structural bonding applications.

Physical Data – Uncured

Property	Unit	Liquid Bonding Paste	
		BP 90-78PA	BP 90-79PA
Appearance		White Paste	Grey Paste
Viscosity at 25°C ¹	cP	600,000	600,000
Stability at 20°C ²	Months	3	3
Specific Gravity		1.3	1.3
Geltime/Working Time* at 20°C ³	Minutes	10	5
Geltime/Working Time* at 25°C ³	Minutes	8	4

1. Measured using Brookfield Viscometer at 25°C.
2. Stability defined from date of dispatch when left un-opened in the original containers and out of direct sunlight.
3. Geltime measured with 100g mass of adhesive and 1% Butanox M50.

*1% Butanox M50 (or equivalent catalyst).

Physical Data – Cured

Property	Unit	Fully Cured†		Test Method
		BP 90-78PA	BP 90-79PA	
Barcol Hardness		47	39	BS EN ISO 868:2003
Tensile Strength	MPa	28	29	BS EN ISO 527-2:1996
Tensile Modulus	MPa	3100	3200	BS EN ISO 527-2:1996
Elongation at Break	%	1.0	1.3	BS EN ISO 527-2:1996
Single Lap-Shear Strength	MPa	10.5	10.9	BS ISO 4587:2003

† Curing Schedule - 24 hrs at 20°C, 3 hrs at 80°C

Features and Benefits

Highly thixotropic
Fast cure
Good handling

No drainage on vertical surface
Quick production cycles
Ease of application

Substrates

Crystic BP 90-78PA and Crystic BP 90-79PA can be used on surfaces other than GRP such as timber and plasterboard. However, it is recommended that trials are carried out to ensure that adequate bond strength is obtained.

Surface Preparation

The surfaces to be bonded should be clean, dry and free from any contamination. It may be necessary to abrade the surfaces to be bonded in order to obtain the bond strength required. Each surface should be coated with the catalysed bonding paste and held together until the paste has cured.

Application

Crystic BP 90-78PA and Crystic BP 90-79PA are supplied pre-accelerated. The required hardener is Butanox M50 (or other equivalent MEKP catalyst). The catalyst is added at 1% w/v. Crystic BP 90-78PA and Crystic BP 90-79PA can be applied with a spatula or from a dispensing unit, taking care to keep air entrapment to a minimum. Application should always be carried out at temperatures above 15°C. Recommended temperature range for application is between 18 and 25°C.

Additives

Crystic BP 90-78PA and Crystic BP 90-79PA are supplied pre-accelerated. The addition of pigments or other materials can adversely affect the degree of cure and bond strength obtained.

Coverage

As a rough guide, 4Kg of bonding paste will cover one square metre to a depth of approximately 3mm.

Storage

Crystic BP 90-78PA and Crystic BP 90-79PA should be stored out of direct sunlight in the original containers. It is recommended that the storage temperature should be between 15 and 20°C. Ideally, containers should be opened only immediately prior to use. Products should never be frozen.

Packaging

Crystic BP 90-78PA and Crystic BP 90-79PA are supplied in 25Kg and 225Kg containers.

Health & Safety

Please see separate Material Safety Data Sheets.

Version 3 : February 2013

All information on this data sheet is based on laboratory testing and is not intended for design purposes. Scott Bader makes no representations or warranties of any kind concerning this data. Due to variance of storage, handling and application of these materials, Scott Bader cannot accept liability for results obtained. The manufacture of materials is the subject of granted patents and patent applications; freedom to operate patented processes is not implied by this publication.

SCOTT BADER COMPANY LIMITED

Wollaston, Wellingborough, Northamptonshire, NN29 7RL

Telephone: +44 (0) 1933 663100

Facsimile: +44 (0) 1933 666623

www.scottbader.com