



CRYSTIC 621 CC 65

Bonding paste

Introduction

CRYSTIC 621 CC 65 is pre-accelerated Urethane Acrylate / Isophtalic structural adhesive. It is a viscous, filled compound, specifically designed for the assembly and bonding of GRP mouldings. Such applications include panels, inserts, internal frames, ribs, internal core materials, hull to deck assemblies, composite constructions and car body components. The use of these bonding pastes gives high shear-strength structures without the need for mechanical fixings.

Formulation

CRYSTIC 621 CC 65 should be allowed to attain workshop temperature (18°C - 20°C) before use. **CRYSTIC 621 CC 65** requires only the addition of catalyst to start the curing reaction. The recommended catalyst is Catalyst M (or Butanox M50), which should be added at 1 to 2 % into the bonding paste. (Please consult our Technical Service Department if other catalysts are to be used). The catalyst should be thoroughly incorporated into the material with a low shear mechanical stirrer where possible.

Features and benefits

Acrylate base resin Very best adhesion performance	
Urethane base resin Very elongation at break	
Highly thixotrop No drainage on vertical surface	
Colour change system	
Low shrink additive No print through, excellent surface aspe	ect

Pot Life

Catalyst level (MEKP at 50%)	Pot life in min. at 25 °C
1 %	45
2 %	25

The bonding paste, moulding and workshop should all be at, or above, 15°C before curing is carried out.

Application

The surfaces to be bonded should be clean, dry and free from any contamination. It may be necessary to roughen 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 adhesive has hardened.

Coverage

As a rough guide, 3.8 kg of bonding paste will cover one square metre to a depth of approximately 3mm.

Additives

CRYSTIC 621 CC 65 is supplied ready to use. The addition of pigments or other materials can adversely affect the degree of cure and bond strength obtained.

Typical Properties

The following table gives typical properties of CRYSTIC 621 CC 65 when tested in accordance with BS2782.

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Property		Liquid Bonding Paste
Appearance		Blueish paste
Viscosity @ 25°C		Highly thixo
Stability in the dark @ 20°C	months	3
Geltime @ 25°C using		
2% Catalyst M (or Butanox M50)	minutes	30 - 40

		Fully Cured*	
Property		(unfilled casting)	
Appearance		Grey	
Elongation at Break	%	3.3	
Single Lap Shear Strength	MPa	9.8	

Post Curing

Satisfactory bonds for most applications can be obtained by curing **CRYSTIC 621 CC 65** at workshop temperature (20°C).

Storage

CRYSTIC 621 CC 65 should be stored in the dark in suitable, closed containers. It is recommended that the storage temperature should be less than 20°C where practical, but should not exceed 30°C. Ideally, containers should be opened only immediately prior to use. Where they have to be stored outside, it is recommended that they are kept in a horizontal position to avoid the possible ingress of water.

Packaging

CRYSTIC 621 CC 65 is supplied in 25kg and 225kg containers.

Health and Safety

Please see separate Material Safety Data Sheets

All information is given in good faith but without warranty. We cannot accept responsibility or liability for any damage, loss or patent infringement resulting from the use of this information.



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