Product Overview

Crestabond M1-90HV is a toughened, two component 10:1 acrylic adhesive designed for bonding composites, thermoplastics and metals. This new generation of structural methacrylate adhesive meets the bonding requirements of most assembly operations. Demonstrating excellent impact, peel, shear, compressive strength and fatigue resistance properties across all bonded parts.

Features and Benefits

- Primerless application
- Excellent adhesion to dissimilar substrates
- Long working time and high gap fill
- Exceptional sag resistance
- High strength, modulus and toughness
- Excellent environmental resistance
- No need for extra materials or processes
- Affords greater flexibility in design
- Allows for use on large structures
- Application on vertical surfaces
- Designed for demanding structural applications
- Designed for demanding environmental applications

Application Properties

<table>
<thead>
<tr>
<th>Property</th>
<th>M1-90HV Adhesive</th>
<th>Activator 2 Green</th>
</tr>
</thead>
<tbody>
<tr>
<td>Working Time$^1$</td>
<td>70 – 100 Minutes</td>
<td></td>
</tr>
<tr>
<td>Fixture Time$^2$</td>
<td>210 – 240 Minutes</td>
<td></td>
</tr>
<tr>
<td>Gap Filling $^3$</td>
<td>1 – 50 mm (0.04-2.0 inch)</td>
<td></td>
</tr>
<tr>
<td>Mixed Colour</td>
<td>Green</td>
<td></td>
</tr>
<tr>
<td>Recommended Application Temperature</td>
<td>18 - 25 °C (64 - 77°F)</td>
<td></td>
</tr>
</tbody>
</table>

Mechanical Properties

<table>
<thead>
<tr>
<th>Property</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Tensile Strength$^3$</td>
<td>22 - 26 MPa (3.2 - 3.8 ksi)</td>
</tr>
<tr>
<td>Tensile Modulus$^3$</td>
<td>1200 - 1600 MPa (174 - 232 ksi)</td>
</tr>
<tr>
<td>Tensile Elongation$^3$</td>
<td>50 - 70%</td>
</tr>
<tr>
<td>Aluminium Lap shear$^4$</td>
<td>12 - 16 MPa (1.7 - 2.3 ksi)</td>
</tr>
<tr>
<td>Recommended Operating Temperature$^5$</td>
<td>-40 - 100 °C (-40 - 212°F)</td>
</tr>
</tbody>
</table>

Liquid Properties

<table>
<thead>
<tr>
<th>Property</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Product</td>
<td>M1-90HV Adhesive</td>
</tr>
<tr>
<td>Viscosity$^6$</td>
<td>340,000 - 380,000 cP</td>
</tr>
<tr>
<td>Specific Gravity</td>
<td>0.97 - 1.03 g/cc</td>
</tr>
<tr>
<td>Mix Ratio (by volume)</td>
<td>10</td>
</tr>
<tr>
<td>Mix Ratio (by weight)</td>
<td>9.1</td>
</tr>
<tr>
<td>Colour</td>
<td>Off white</td>
</tr>
<tr>
<td>Shelf Life$^7$</td>
<td>12 months</td>
</tr>
</tbody>
</table>
Substrates

Plastics

- **Acrylic**: 15 - 20 MPa
- **PVC**: 14 - 18 MPa
- **ABS**: 8 - 12 MPa
- Other: Urethanes and common engineering thermoplastics

Metals

- **Stainless**: 12 - 16 MPa
- **Aluminium**: 12 - 16 MPa
- Other: Powder Coated Metals, Carbon Steel

Composites

- **GRP/FRP**: 8 - 12 MPa
- **Carbon Fibre/Polyester**:
- **DCPD Modified Vinyl Esters**: Epoxy
- **Gelcoats**:

Non - Recommended Substrates

- Low Surface Energy Plastics e.g. PP, PE & PTFE (use Crestabond PP-04)
- Zinc/ Galvanised Coated Metals, Copper

Please contact Scott Bader technical services for information and advice on other substrates

Surface Preparation

The surface to be bonded can affect the strength and durability of the bond joint. Appropriate treatment may be required to ensure that there are no traces of oil, grease, dirt or release agents through the use of a degreasing agent, for instance acetone or another degreasing agent on the joint surfaces.

Mechanically abrading or chemically etching degreased surfaces can make bond joints more durable and stronger. If abrading, a second treatment of degreasing is highly recommended.

Do not use petrol (gasoline), low grade alcohol or paint thinners.

**i) Metals**

Typically, the surface should be clean and dry by using an alcohol/solvent wipe and allowing the solvent to evaporate before application. Certain metals, such as carbon steel may also require mechanical abrasion and a subsequent alcohol solvent wipe prior to bonding.

**ii) Thermoplastics**

The surface must be clean, dust-free and dry. A suitable solvent such as iso-propanol can be used to degrease.

**iii) Composites**

The surface must be clean, dust-free and dry. This can be achieved by the use of proprietary strippable cloths such as peel-ply (without lubricant contaminates). The laminate should be fully cured prior to bonding and if the laminate surfaces are more than 3 days old, it is recommended that the surface must be cleaned with a suitable solvent or cleaner with a lint-free, clean cloth prior to bonding.

Surface preparation, such as mechanical abrasion, is likely to be needed on gel coat surfaces and moulded surfaces where release agents are likely to be present. When bonding epoxy laminates please test bond strength prior to application.
Application

Prior to bonding, ensure the substrate surface is clean by following the surface preparation instructions provided. Bulk dispensing equipment should be in good operating condition. Dispense the adhesive at a slow rate initially onto a non-bonding surface until the mixed bead colour is uniform. Check the dispensed bead for cure quality before beginning the bonding process.

Dispense enough adhesive to fill the bond gap before parts are mated. Avoid dry bonds by using adequate pressure to mate parts and clamp properly to prevent joint movement. The working time is the approximate time after mixing that the adhesive is still usable. The bonding process must be completed before the working time of the mixed adhesive expires. The viscosities of both adhesive and activator are affected by temperature. The adhesive, activator and parts to be bonded should be allowed to attain workshop temperature of between 18°C and 25°C (64°F and 77°F) prior to bonding. The operating temperature should be maintained during the bonding process and until the adhesive is sufficiently cured to allow movement of the assembly. Typically, such movement may be possible after the fixture time of the adhesive is achieved. Ambient temperature, bondline thickness and the substrate materials being bonded can all affect the fixture time.

For industrial/commercial use only. Not to be used in household applications. The user must determine the suitability of a selected adhesive for a given substrate and application. Contact your local Scott Bader representative for questions or assistance with the selection of adhesives for your use. This product is intended for use by skilled individuals at their own risk. Recommendations contained herein are based on information we believe to be reliable.

Storage and Shelf Life

Crestabond products should be stored in their original container out of direct sunlight. The bulk product or cartridge material should be opened only immediately prior to use. The expiry date is indicated on the product labels.

The shelf life is defined from date of manufacture when stored at a recommended temperature between 2°C and 23°C (36°F and 73°F). It is highly recommended that products should never be frozen. Exposure to temperatures above 23°C (56°F) will reduce the shelf life of these materials. Exposure above 35°C (95°F) of activators, including the cartridges, should be avoided as the reactivity of the product is quickly diminished.

Packaging

Crestabond M1-90HV is supplied in 18Kg (40 lb) plastic pails, 180Kg (397 lb) drums, pre-packed 400ml co-axial and 825ml side by side cartridges.

Health and Safety

See separate Material Safety Data Sheet.