



### Product Overview

Crestafix 90-80PA is a pre-accelerated polyester bonding paste. It is viscous, filled compound containing short glass fibres, a low shrink and a flexible additive, specifically designed for the assembly and bonding of GRP mouldings. Such applications include panels, inserts, internal frames, ribs, composite constructions and car body components. The use of this bonding paste gives a high shear strength structure.

### Features and Benefits

Highly thixotropic	▶	No sagging on vertical surfaces
Glass fibres	▶	Good gap filling capabilities
Colour change	▶	Visual check for catalyst mix
Low shrink	▶	No print through

### Typical Application Properties

Working time <sup>1</sup>	12 Minutes
Gap Filling	1 - 25mm (0.04 - 0.6 inch)
Colour Change	Bluish to Grey
Recommended Application Temperature	18 - 25 °C (66 - 77 °F)

### Typical Mechanical Properties

Lap Shear Strength <sup>2</sup>	4 MPa (580 psi) Substrate Failure
Tensile Strength <sup>3</sup>	33 MPa (4800 psi)
Tensile Modulus <sup>3</sup>	4215 MPa (610,000 psi)
Tensile Elongation <sup>3</sup>	2 %
Hardness	38 Barcol

### Typical Liquid Properties

Viscosity <sup>4</sup>	Highly Thixotropic
Specific Gravity	1.25 g/cc
Shelf Life <sup>5</sup>	6 Months

## Substrates

Crestafix 90-80PA is suitable for use on GRP laminate, but can also be used on timber and plasterboard. However, it is recommended that trials are carried out to ensure that adequate bond strengths are obtained.

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

## Surface Preparation

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

## Application

Crestafix 90-80PA is supplied pre-accelerated, requiring only the addition of catalyst to start the curing reaction. The recommended catalyst is Butanox M50, which should be added at 2% v/w into the bonding paste. The catalyst should be thoroughly incorporated into the material with a low shear mechanical stirrer where possible, taking care to keep air entrapment to a minimum. Alternatively the bonding paste can be applied with a dispensing unit.

The use of additional pigments or fillers is not recommended as they can affect the performance of the adhesive.

*For industrial/commercial use only. 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. The properties and strength values have been obtained under controlled conditions at the Scott Bader laboratory.*

## Coverage

As a rough guide, 4.0Kg (9 lbs) of bonding paste will cover one square metre to a depth of approximately 3mm (0.12 inch).

## Storage and Shelf Life

Crestafix 90-80PA should be stored between 2°C and 23°C (36°F and 77°F) in the original, unopened container in a dry, well ventilated place. Protect from freezing and direct sunlight. Avoid contact with oxidising agents.

The shelflife is defined from date of manufacture when stored as recommended. The expiry date is indicated on product labels.

## Packaging

Crestafix 90-80PA is supplied in 25Kg (55 lbs) and 225Kg (500 lbs) containers.

## Health and Safety

See Material Safety Data Sheet.

## Notes

1. Working time measured with 100g of adhesive with Butanox M50 (2%) at 25°C (77°F).

2. GRP lap shear tested to BS ISO 4587.

3. Tensile properties tested to BS EN ISO 527-2.

4. Viscosity measured using Brookfield Viscometer at 25°C (77°F).

5. Shelf life is defined from date of manufacture when stored as recommended.



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