Product Overview
Crestomer 1152PA is a two part pre-accelerated, highly thixotropic structural adhesive based on unsaturated urethane acrylate in a styrene monomer. It is used in many structural composite applications and has excellent adhesion to FRP laminates, core materials, wood and some metals. Due to its excellent adhesion to a wide range of materials, 1152PA can also be used as a general purpose adhesive. It can be used for bonding diesel tanks, contour joints in FRP components, to build up damaged areas and to bond “green” FRP.

Features and Benefits
- Urethane acrylate base
- Excellent retention of toughness
- Highly thixotropic
- Controlled cure and exotherm behaviour
- Improved aesthetic and better surface finish
- Excellent adhesion and high elongation at break
- Non sagging on vertical surfaces
- Excellent fatigue and impact resistance

Application Properties
- Working Time: 50 Minutes
- Fixture Time: 10 hours
- Gap Filling: 1 – 25 mm/ 0.04 - 1.0 inch
- Colour change (over cure): None
- Recommended Application Temperature: 18°C - 25°C/ 66°F - 77°F

Mechanical Properties
- Tensile Strength: 22 - 25 MPa
- Tensile Modulus: 1000 - 1500 MPa
- Tensile Elongation: 100 - 120%
- Hardness: 65 Shore D
- Water Absorption: 0.36%
- Approvals: Lloyds, RINA, DNV.GL
**Recommended Substrates**

**Metals**
- Stainless Steel
- Aluminium

**Wood**
- Marine Ply
- Balsa

**Composites**
- GRP/FRP
- Polyester Resin
- DCPD
- Vinyl Ester
- Epoxy

**Non - Recommended Substrates**

**Exotherm of Crestomers**

High exotherm in an adhesive can cause the substrate to distort and give poor aesthetic characteristics to the parts being bonded. The chemistry of Crestomer adhesives ensures that high exotherm temperatures, a characteristic of some other adhesives do not occur. The graph shows the exotherm temperatures of Crestomer adhesives over a range of test temperatures.
Surface Preparation
Crestomer 1152PA has excellent adhesion to FRP material provided that the surface has been maintained free of dust and grease. This can be guaranteed by the use of proprietary stripable cloths such as peel ply (without lubricant contaminates). If the laminate surface is more than three days old it is recommended that they are lightly abraded and wiped with acetone or styrene on a lint-free, clean cloth prior to bonding.

Application
Crestomer 1152PA is supplied pre-accelerated. The required hardner is Butanox M50 (or other equivalent MEKP catalyst). The catalyst is added at 2% v/w. Crestomer 1152PA 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/ 59°F. Recommended temperature range for application is between 18°C and 25°C/ 64°F - 77°F. 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 are obtained under controlled conditions at the Scott Bader laboratory.

Storage and Shelf Life
Crestomer 1152PA should be stored between 2°C and 23°C/ 36°F and 73°F in the original unopened container in a dry well ventilated place. Protect from freezing and direct sunlight. Avoid contact with oxidising agents. Exposure to temperatures outside these conditions will affect shelf life. Ideally containers should be opened only immediately prior to use.

The shelf life for Crestomer products is defined from date of manufacture if stored as recommended. The expiry date is indicated on the product labels.

Packaging
Crestomer 1152PA is supplied in 25Kg/ 55lbs and 200Kg/ 440lbs containers.

Health and Safety
See separate Material Safety Data Sheet.