CRESTA BOND®
Primerless MMA Structural Adhesives
Scott Bader is a global company with over 40 years experience in designing and manufacturing high quality adhesives.

Scott Bader benefits from an industry leading technical support team available to assist customers with technical advice. Scott Bader also boasts in house laboratory testing facilities allowing for a rapid response to customer requests. The Crestabond® range of M7 / PP (1:1) and M1 (10:1) structural adhesives are unique to the market due to the incorporation of our novel tougheners. The Crestabond® range of adhesives benefits from a range of working times to suit different applications.

Guide To Bonding

Check first:
- Product is within shelf life
- Cartridge has been stored correctly
- No obvious defect or damage to cartridge
- No blockages at the cartridge outlet
- Correct static mixing nozzle is being used

Key points:
- Higher or lower working temperatures will cause the working time to decrease or increase
- Static mixers must always be discarded after use
- Operating temperature of Crestabond® is from -40°C up to 100°C

3 main groups of substrates to bond to:

Metals
- Some surface cleaning is required – remove any obvious dirt, grease and other contaminants with either acetone, MEK or IPA
- Galvanised or zinc coated metals should be bonded using the Crestabond® M7 (1:1) range
- When bonding cold rolled steel (CRS), ensure that the substrate has been cleaned, abraded and then cleaned once more in order to achieve the best results

Composites
- Some surface cleaning is required – remove any obvious dirt, grease and other contaminants with either acetone, MEK or IPA
- Gelcoat substrates need to be cleaned and may require a light abrasion with a 100-140 grit sandpaper and a further clean
- All composites can be bonded with Crestabond®

Plastics
- Some surface cleaning is required – remove any obvious dirt, grease and other contaminants with either acetone, MEK or IPA
- For bonding low surface energy plastics such as Polypropylene (PP), Polyethylene (PE) and other Polyolefins, Crestabond® PP-04 must be used
## Crestabond® Features & Customer Benefits

<table>
<thead>
<tr>
<th>Crestabond® features</th>
<th>Customer benefits</th>
</tr>
</thead>
<tbody>
<tr>
<td>Primerless adhesives</td>
<td>Dramatically enhances production efficiency and reduces consumable costs</td>
</tr>
<tr>
<td>Minimal surface preparation</td>
<td>Reduces dust emissions and preparation time</td>
</tr>
<tr>
<td>Excellent fatigue and impact resistance</td>
<td>Confidence in the longevity of the finished product</td>
</tr>
<tr>
<td>Range of working and fixture times</td>
<td>Optimises production cycles to reduce manufacturing costs</td>
</tr>
<tr>
<td>Good gap filling capability</td>
<td>Adhesive can be used in multiple applications</td>
</tr>
<tr>
<td>Bonds dissimilar substrates</td>
<td>Provides flexibility in structural designs</td>
</tr>
</tbody>
</table>

## Crestabond® Dispensing Equipment

- The Crestabond® cartridges can be used with a manual or pneumatic gun. Suitable dispense guns and static mixers are available from Scott Bader.
- Crestabond® adhesives can be dispensed directly from pails and drums using an automated 11 or 10.1 dispensing machine.
- Scott Bader technical support can provide advice on appropriate dispensing equipment.
Adhesive Selection Guide

Selection of the appropriate product is essential for long-term adhesion and durability.

### Step 1
Choose the adhesive with optimal working and fixture times

### Step 2
Check the adhesive bonds the required substrates:
- **Composites**
- **Metals**
- **Plastics**
- **AISI**
- **Acrylic**
- **Polycarbonate**
- **PVC**
- **PP/PE & TPO**

### Step 3
Arrange a demonstration or trial by contacting your local Scott Bader representative or email enquiries@scottbader.com

### Crestabond®

<table>
<thead>
<tr>
<th>Product</th>
<th>Description</th>
<th>Colour</th>
<th>Mix ratio</th>
<th>Viscosity Working</th>
<th>Time (mins)</th>
<th>Tensile Strength (MPa)</th>
<th>Tensile Modulus (MPa)</th>
<th>Elastication at break (%)</th>
<th>Gap Fill (mm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>M1-02</td>
<td>Universal Bonder</td>
<td>Grey</td>
<td>10:1</td>
<td>100,000 - 140,000</td>
<td>1 - 2</td>
<td>12 - 16</td>
<td>500 - 1000</td>
<td>90 - 120</td>
<td>1 - 15</td>
</tr>
<tr>
<td>M1-04</td>
<td>Universal Bonder</td>
<td>Grey</td>
<td>10:1</td>
<td>100,000 - 140,000</td>
<td>3 - 5</td>
<td>16 - 20</td>
<td>600 - 1000</td>
<td>90 - 120</td>
<td>1 - 15</td>
</tr>
<tr>
<td>M1-05</td>
<td>Universal Bonder</td>
<td>White, Grey or Black</td>
<td>10:1</td>
<td>100,000 - 140,000</td>
<td>4 - 7</td>
<td>12 - 18</td>
<td>600 - 1000</td>
<td>90 - 120</td>
<td>1 - 15</td>
</tr>
<tr>
<td>M1-10</td>
<td>Universal Bonder</td>
<td>Grey, White, Black</td>
<td>10:1</td>
<td>100,000 - 140,000</td>
<td>8 - 12</td>
<td>16 - 20</td>
<td>600 - 1000</td>
<td>90 - 120</td>
<td>1 - 15</td>
</tr>
<tr>
<td>M1-20</td>
<td>Universal Bonder</td>
<td>Grey, White, Black</td>
<td>10:1</td>
<td>100,000 - 140,000</td>
<td>16 - 20</td>
<td>600 - 1000</td>
<td>90 - 120</td>
<td>90 - 120</td>
<td>1 - 15</td>
</tr>
<tr>
<td>M1-30</td>
<td>Universal Bonder</td>
<td>Grey, White, Black</td>
<td>10:1</td>
<td>200,000 - 240,000</td>
<td>25 - 30</td>
<td>18 - 22</td>
<td>100 - 160</td>
<td>100 - 160</td>
<td>1 - 10</td>
</tr>
<tr>
<td>M1-60HV</td>
<td>Universal Bonder</td>
<td>Grey</td>
<td>10:1</td>
<td>540,000 - 680,000</td>
<td>23 - 30</td>
<td>1200 - 1500</td>
<td>500 - 700</td>
<td>50 - 70</td>
<td>1 - 15</td>
</tr>
<tr>
<td>M1-90HV</td>
<td>Universal Bonder</td>
<td>Green</td>
<td>10:1</td>
<td>540,000 - 680,000</td>
<td>40 - 60</td>
<td>1500 - 1700</td>
<td>200 - 240</td>
<td>50 - 70</td>
<td>1 - 15</td>
</tr>
<tr>
<td>M7-04</td>
<td>Universal Bonder</td>
<td>Off White</td>
<td>1:1</td>
<td>30,000 - 70,000</td>
<td>3 - 5</td>
<td>12 - 15</td>
<td>22 - 25</td>
<td>1000 - 1700</td>
<td>5 - 10</td>
</tr>
<tr>
<td>M7-05</td>
<td>Universal Bonder</td>
<td>Black</td>
<td>1:1</td>
<td>30,000 - 70,000</td>
<td>4 - 7</td>
<td>18 - 22</td>
<td>25 - 28</td>
<td>1000 - 1700</td>
<td>5 - 10</td>
</tr>
<tr>
<td>M7-15</td>
<td>Universal Bonder</td>
<td>Off White</td>
<td>1:1</td>
<td>100,000 - 140,000</td>
<td>10 - 20</td>
<td>45 - 55</td>
<td>1500 - 1700</td>
<td>50 - 70</td>
<td>1 - 15</td>
</tr>
<tr>
<td>FR-04</td>
<td>Universal Bonder</td>
<td>Black</td>
<td>1:1</td>
<td>100,000 - 140,000</td>
<td>1 - 5</td>
<td>165 - 180</td>
<td>1200 - 1500</td>
<td>50 - 70</td>
<td>0.5 - 5</td>
</tr>
<tr>
<td>FR-05</td>
<td>Universal Bonder</td>
<td>Off White</td>
<td>1:1</td>
<td>70,000 - 94,000</td>
<td>5 - 5</td>
<td>165 - 180</td>
<td>1200 - 1500</td>
<td>2 - 5</td>
<td>0.5 - 5</td>
</tr>
</tbody>
</table>

**Note:** Viscosity is dependent on temperature. *Time taken at 23°C to achieve 1.4MPa strength in lap shear tests according to BS ISO 4587

**Cartridges and Bulk Pack sizes:**

<table>
<thead>
<tr>
<th>Cartridges</th>
<th>Bulk</th>
</tr>
</thead>
<tbody>
<tr>
<td>M1 (10:1 range)</td>
<td>20 Litre/18kg packs</td>
</tr>
<tr>
<td>400ml kit</td>
<td>200 Litre/180kg drums</td>
</tr>
<tr>
<td>M7 and PP (1:1) Range</td>
<td>50m side-by-side</td>
</tr>
<tr>
<td>20 Litre/18kg packs</td>
<td>200 Litre/180kg drums</td>
</tr>
<tr>
<td>400ml side-by-side</td>
<td></td>
</tr>
</tbody>
</table>

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**How to order bulk packed materials:**

<table>
<thead>
<tr>
<th>Product</th>
<th>Adhesive</th>
<th>Activator</th>
</tr>
</thead>
<tbody>
<tr>
<td>M1-02</td>
<td>M1-02</td>
<td>Activator 4</td>
</tr>
<tr>
<td>M1-04</td>
<td>M1-04</td>
<td>Activator 4</td>
</tr>
<tr>
<td>M1-05</td>
<td>M1-05</td>
<td>Activator 1*</td>
</tr>
<tr>
<td>M1-10</td>
<td>M1-10</td>
<td>Activator 1*</td>
</tr>
<tr>
<td>M1-20</td>
<td>M1-20</td>
<td>Activator 1*</td>
</tr>
<tr>
<td>M1-30</td>
<td>M1-30</td>
<td>Activator 1*</td>
</tr>
<tr>
<td>M1-60HV</td>
<td>M1-60HV</td>
<td>Activator 2 Green</td>
</tr>
<tr>
<td>M1-90HV</td>
<td>M1-90HV</td>
<td>Activator 2 Green</td>
</tr>
<tr>
<td>M7-04</td>
<td>M7-04</td>
<td>Activator 1*</td>
</tr>
<tr>
<td>M7-05</td>
<td>M7-05</td>
<td>Activator 1*</td>
</tr>
<tr>
<td>M7-15</td>
<td>M7-15</td>
<td>Activator 1*</td>
</tr>
</tbody>
</table>

*Activator 1 gives a standard grey mix. Also available in black or white.

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