



Product Overview

The Crestafix 621CC range is a pre-accelerated urethane acrylate / isophthalic polyester high performance bonding paste. It is a non-sagging, filled compound, specifically designed for the assembly and bonding of GRP mouldings. Such applications include panels, inserts, internal frames, ribs, internal core materials, composite constructions and car body components. All Crestafix 621CC products provide a high shear strength bonded joints without the need for mechanical fixings.

Features and Benefits

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|------------------------|---|---|
| Highly thixotropic | ▶ | No drainage on vertical surfaces |
| Colour change system | ▶ | Visual check for effective catalyst mix |
| Low shrink system | ▶ | No print through, excellent surface aspect |
| Urethane acrylate base | ▶ | Excellent adhesion and good elongation at break |

Application Properties

Property	Typical Value				
	621CC White 20	621CC 30	621CC 45	621CC 65	621CC 85
Geltime/ Working time (minutes) ¹	18 - 22	16 - 20	22 - 28	32 - 38	45 - 55
Gap Filling	1 - 25 mm	1 - 25 mm	1 - 25 mm	1 - 25 mm	1 - 25 mm
Colour Change	Pale Blue to White	Blue/Green to Grey	Blue/Green to Grey	Blue/Green to Grey	Blue to Grey

Mechanical Properties

Property	Typical Value				
	621CC White 20	621CC 30	621CC 45	621CC 65	621CC 85
Hardness	80 Shore D	80 Shore D	80 Shore D	80 Shore D	80 Shore D
Max. Tensile Strength ⁵	25 MPa	25 MPa	25 MPa	25 MPa	25 MPa
Tensile Modulus ⁵	3000 MPa	3000 MPa	3000 MPa	3000 MPa	3000 MPa
Elongation at Break ⁵	3%	3%	3%	3%	3%
GRP Lap-Shear Strength ⁵	10 MPa	10 MPa	10 MPa	10 MPa	10 MPa
Approvals	Grade 2 DNV	Grade 2 DNV	Grade 2 DNV	Grade 2 DNV	Grade 2 DNV

Liquid Properties

Typical Value					
Property	621CC White 20	621CC 30	621CC 45	621CC 65	621CC 85
Viscosity ¹	120,000 - 200,000 cP	120,000 - 200,000 cP	120,000 - 200,000 cP	320,000 - 390,000 cP	180,000 - 240,000 cP
Specific Gravity	1.25	1.25	1.25	1.25	1.25
Mix Ratio (by volume) ³	50:1	50:1	50:1	50:1	50:1
Colour	Light Blue	Blue	Blue/Green	Blue/Green	Blue
Shelf Life ⁴	6 months	6 months	6 months	6 months	6 months

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 621CC are supplied pre-accelerated, requiring only the addition of catalyst to start the curing reaction. The recommended catalyst is Catalyst M (or Butanox M50 or other equivalent MEKP catalyst), which should be added at 1% to 2% w/v 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 bonding paste, moulding and workshop should all be at, or above, 15°C before curing is carried out. Recommended temperature range for application is between 18°C and 25°C. 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 obtained under controlled conditions at the Scott Bader laboratory.

Coverage

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

Storage

Crestafix 621CC should be stored out of direct sunlight in their original container. It is recommended that the storage temperature should be between 15°C and 20°C. Containers should be opened only immediately prior to use. Product should never be frozen.

Packaging

Crestafix 621CC is supplied in 25Kg and 225Kg containers.

Health and Safety

Please see separate Material Safety Data Sheets.

1. Measured using Brookfield Viscometer at 25°C

2. Geltime measured with 100g mass of adhesive with 2% Catalyst M at 25°C

3. Mix ratio based on weight/ volume for hand mixing

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

5. Test to BS EN ISO 527-2-1996.



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