



CRESTABOND[®]

Primerless MMA Structural Adhesives



ADHESIVES by
SCOTT BADER

CRESTABOND®

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.



Market Applications



Marine
from kayaks to super yachts



Land & transportation
buses, coaches, cars, trains and trucks



Building & construction
doors, windows and cladding



Wind energy
blades, housing and nacelles



Recreational vehicles
motorhomes and caravans



Agricultural vehicles
tractors, diggers, off-road and combine harvesters

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, oxidation 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

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

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 1:1 or 10:1 dispensing machine
- ▶ Scott Bader technical support can provide advice on appropriate dispensing equipment



Adhesive Selection Guide - Standard Range

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

► **Step 1** Choose the adhesive with optimal working and fixture times

Crestabond® Product	Description	Colour	Mix ratio by volume	Viscosity (cP)	Working Time (mins)	*Fixture Time (mins)	Tensile Strength (MPa)	Tensile Modulus (MPa)	Elongation at break (%)	Gap Fill (mm)
M1-02	Universal Bonder	Dark Grey	10:1	100,000 - 140,000	1 - 2	2 - 3	12 - 16	600 - 1000	80 - 100	1 - 15
M1-04	Universal Bonder	Dark Grey	10:1	100,000 - 140,000	3 - 5	8 - 10	16 - 20	600 - 1000	80 - 100	1 - 15
M1-04 SL	Universal Bonder	Dark Grey	10:1	10,000 - 30,000	4 - 7	10 - 12	16 - 20	600 - 1000	80 - 100	1 - 5
M1-05	Universal Bonder	Dark Grey	10:1	100,000 - 140,000	4 - 7	12 - 18	16 - 20	600 - 1000	80 - 100	1 - 15
M1-10	Universal Bonder	Dark Grey	10:1	100,000 - 140,000	8 - 12	16 - 23	16 - 20	600 - 1000	80 - 100	1 - 15
M1-20	Universal Bonder	Dark Grey	10:1	100,000 - 140,000	16 - 22	25 - 35	16 - 20	600 - 1000	80 - 100	1 - 25
M1-30	Universal Bonder	Dark Grey	10:1	200,000 - 240,000	25 - 35	60 - 80	18 - 22	600 - 1000	100 - 130	1 - 50
M1-60HV/2	Universal Bonder	Green	10:1	340,000 - 380,000	50 - 70	110 - 140	20 - 25	1000 - 1400	70 - 100	1 - 50
M1-90HV/2	Universal Bonder	Green	10:1	340,000 - 380,000	80 - 100	110 - 140	20 - 25	1000 - 1400	70 - 100	1 - 50
M7-04	Universal Bonder	Off White	1:1	30,000 - 70,000	3 - 5	12 - 15	22 - 25	1200 - 1700	6 - 10	1 - 5
M7-05	Universal Bonder	Off White	1:1	30,000 - 70,000	4 - 7	18 - 22	22 - 25	1200 - 1700	25 - 30	1 - 5
M7-15	Universal Bonder	Off White	1:1	30,000 - 70,000	10 - 20	30 - 45	22 - 25	1200 - 1700	25 - 30	1 - 5
PP-04	Low surface energy Bonder	Off White	1:1	70,000 - 140,000	3 - 5	165 - 180	12 - 17	800 - 1200	2 - 5	0.5 - 5

Pack sizes

Cartridges

- M1 (10:1) range**
- 50ml side-by-side
 - 400ml coaxial
 - 490ml side-by-side
 - 825ml side-by-side

M7 and PP (1:1) Range

- 50ml side-by-side
- 400ml side-by-side

Bulk

- 20 Litre/ 18kg pails
- 200 Litre/ 180kg drums

Consult your representative for information on how to order bulk packed materials

Product	Composites			Metals			Plastics				
	GRP	Stainless Steel	Aluminium	Powder Coated Steel	Cold Rolled Steel	Galvanised	ABS	Acrylic	Polycarbonate	PVC	PP/PE & TPO
M1-02	✓	✓	✓	✓	✓		✓	✓	✓	✓	
M1-04	✓	✓	✓	✓	✓		✓	✓	✓	✓	
M1-04SL	✓	✓	✓	✓	✓		✓	✓	✓	✓	
M1-05	✓	✓	✓	✓	✓		✓	✓	✓	✓	
M1-10	✓	✓	✓	✓	✓		✓	✓	✓	✓	
M1-20	✓	✓	✓	✓	✓		✓	✓	✓	✓	
M1-30	✓	✓	✓	✓	✓		✓	✓	✓	✓	
M1-60HV/2	✓	✓	✓	✓			✓	✓	✓	✓	
M1-90HV/2	✓	✓	✓	✓			✓	✓	✓	✓	
M7 range	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	
PP-04	✓	✓	✓		✓		✓	✓	✓	✓	✓

► **Step 2** Check the adhesive bonds the required substrates:

- Composites
- Metals
- Plastics
- Galvanised

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





Making a **positive** difference

Scott Bader Group Companies

Head Office

Scott Bader Company Limited

Wollaston, England

Tel: +44 (0)1933 663100

Email: enquiries@scottbader.com

Scott Bader France

Amiens, France

Tel: +33 3 22 66 27 89

Email: enquiries@scottbader.com

Scott Bader Spain

Barcelona, Spain

Tel: +34 93 553 1162

Email: enquiries@scottbader.com

Scott Bader Germany

Weiden, Germany

Tel: +49 961 401 84474

Email: enquiries@scottbader.com

Scott Bader Ireland

Dublin, Ireland

Tel: +353 1801 5656

Email: enquiries@scottbader.com

Scott Bader Scandinavia AB

Falkenberg, Sweden

Tel: +46 346 10100

Email: enquiries@scottbader.com

Scott Bader Eastern Europe s.r.o.

Mimon II, Czech Republic

Tel: +420 485 111 253

Email: enquiries@scottbader.com

Scott Bader Croatia

Zagreb, Croatia

Tel: +385 1 240 6440

Email: enquiries@scott bader.com

Scott Bader North America

Mocksville, NC, USA

Email: info@scott bader-na.com

Scott Bader ATC

Drummondville, Canada

Tel: +1 (819) 477 1752

Email: enquiries@scott bader.com

Scott Bader South Africa

Hammarsdale, South Africa

Tel: +27 (0) 31 736 8500

Email: enquiries@scottbader.com

Scott Bader Middle East

Dubai, United Arab Emirates

Tel: +971 481 50222

Email: info@scottbader.ae

Scott Bader Asia Pacific

Shanghai, China

Tel: +86 (21) 5298 7778

Email: enquiries@scott bader.com

Scott Bader Japan KK

Yokohama, Japan

Tel: +81 (0) 45 620 3745

Email: enquiries@scottbader.com

Scott Bader Australia

Perth, Australia

Tel: +61 (08) 9418 4555

Email: enquiries@scottbader.com

Scott Bader India

Scott Bader Pvt. Ltd, Mumbai, India

Tel: +91 22 4220 1555

Email: enquiries@scottbader.com

NovaScott Especialidades

Serra, Brazil

Tel: +55 27 3298 1100

Email: enquiries@scottbader.com

Scott Bader Italia

Tel: +39 3454534391

Email: enquiries@scottbader.com

Scott Bader Turkey

Istanbul, Turkey

Tel: +90 542 207 01 86

Email: enquiries@scottbader.com



+44 (0)1933 663100

enquiries@scottbader.com

scottbader.com

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We invest in people Gold

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