

CRYSTIC[®] SCOTTBOND 102 PA WHITE

Pourable, Self Levelling Bonding Paste for Flat Panels

Introduction

Crystic ScottBond 102 PA White is a pourable adhesive paste, white in colour, based on a specially selected unsaturated polyester resin. It is pre-accelerated to give a convenient working time.

Application

Crystic ScottBond 102 PA White is a thixotropic polyester resin-based adhesive for bonding GRP to rigid polyurethane foam in sandwich panel systems. It has also been used to bond GRP to plywood, and plywood to polyurethane foam. Generally, foam will require between 0.9 and 1.2kg/m² of Crystic ScottBond 102 PA White, and plywood between 0.6 and 0.9kg/m². As foams and plywood vary in texture and resin absorption level, it is recommended that tests be carried out before commencing production.

Features and Benefits

Crystic ScottBond 102 PA White is formulated for ease of application, by brush or mohair roller. Crystic ScottBond 102 PA White spreads easily under pressure, giving a smoother surface in the finished product, and should not drain, or soak excessively into the polyurethane foam. Some penetration is required to ensure adhesion. Crystic ScottBond 102 PA White contains a blue indicator that is destroyed by peroxide catalyst. The paste changes colour to white when catalysed, allowing a safety check that catalyst has in fact been added.

Formulation

Crystic ScottBond 102 PA White should be allowed to attain workshop temperature before use – 18°C to 25°C. It should be agitated by rolling the drum or stirring if it has been standing for any length of time.

Crystic ScottBond 102 PA White is supplied pre-accelerated. The recommended catalyst is Norox KP9, which should be added to the paste and dispersed thoroughly shortly before use.

Crystic ScottBond 102 PA White is designed to have a long open time to allow for assembly of sandwich panels, using Norox KP9. In warm weather, or where a very long open time is needed to assemble large sandwich structures, it may be necessary to use Norox MEKP 925H which will extend the potlife.

Pot Life

The temperature and the amount of catalyst control the geltime, and hence potlife, of Crystic ScottBond 102 PA White. Table 1 gives the geltime at varying catalyst levels.

Table 1: Pot life at 25°C using 100g Crystic ScottBond 102 PA White:

Catalyst level%	Pot life in minutes (Norox KP9)	Pot life in minutes (Norox MEKP 925H)
1.0	30-35	55-65
1.5	22-27	35-45
2.0	17-20	25-35

Curing should not be carried out at ambient temperatures below 15°C. Scott Bader (Pty) Ltd. will not be liable for problems caused by use at lower temperatures than recommended.

N.B. Peroxide catalysts are highly reactive and may decompose with explosive violence, or cause fires, if they come into contact with flammable materials, metals or accelerators. For this reason they must never be stored in metal containers or be mixed directly with accelerators.

Typical Properties

Table 2 gives the typical properties of liquid Crystic ScottBond 102 PA White:

Table 2:

Property	Units	Nominal value
Appearance		pourable pale blue paste
Viscosity at 25°C Brookfield RVT @ 100 RPM	centipoise	3500 (thixotropic)
Stability in the dark at 25°C	Months	3

Storage

Crystic ScottBond 102 PA White should be stored in the dark in suitable, closed containers. It is recommended that the storage temperature should be less than 20°C where practical, but should not exceed 30°C. Ideally, containers should be opened only immediately prior to use. Where they have to be stored outside, it is recommended that drums be kept in a horizontal position to avoid the possible ingress of water. Wherever possible, containers should be stored under cover.

Packaging

Crystic ScottBond 102 PA White is supplied in 25 kg and 225 kg steel containers.

Health and Safety

Please see the applicable Material Safety Data Sheets, depending on the curing system used.

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Before you use this information, kindly verify that this data sheet is the latest version.

All information is given in good faith but without warranty. We cannot accept responsibility or liability for any damage, loss or patent infringement resulting from the use of this information.

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