

# CRESTOMER 1151A

## Structural Adhesive

### Product Overview

Crestomer 1151A is an advanced structural adhesive and filleting compound specifically formulated for use in bulk metering systems. Crestomer 1151A is non-sagging, fast curing and parts bonded using Crestomer 1151A are workable in 2 hours. It bonds a wide range of substrates with minimal surface preparation and has demonstrably lower odour than competitive structural adhesives.

Crestomer 1151A is based on Scott Bader's innovative urethane acrylate technology and exhibits exceptional impact strength and toughness. Its excellent adhesion and gap filling capabilities offer the user great flexibility in design with significant time and cost savings.

### Features and Benefits

Urethane acrylate base  
Highly thixotropic  
Excellent retention of toughness  
Fast curing and setting

Excellent adhesion and high elongation at break  
No sagging on vertical surfaces  
Excellent fatigue and impact resistance  
Reduced assembly time

### Characteristics Using 1151A

Crestomer 1151A has been formulated specifically for use in variable ratio bulk metering systems allowing the gel time to be turned to suit specific applications.

Characteristics	Typical Value
Working Time/Geltime <sup>1</sup>	25 – 30 Minutes
Working Time/Geltime <sup>2</sup>	15 – 20 Minutes
Fixture Time	2 Hours
Gap Filling	1 – 20 mm

1. Geltime measured using 2% BPO at 22°C.
2. Geltime measured using 2.5% BPO at 22°C.

### Typical Material Properties

Property	Typical Value	Test Method
Hardness	65 Shore D	BS EN ISO 868
Maximum Tensile Strength	22 MPa	BS EN ISO 527-2
Tensile Modulus	500 MPa	BS EN ISO 527-2
Elongation at Break	120%	BS EN ISO 527-2
Lap Shear: Cohesive Strength	12 – 15 MPa	ISO 4587

### Approvals

Crestomer 1151A has a Statement of Acceptance from Lloyd's Register of Shipping for use in the construction of craft built under their survey.

### Surface Preparation

As with all adhesives, maximum performance is only achieved with adequate surface preparation. When bonding the back surface of (polyester) GRP, a simple solvent wipe with acetone is satisfactory pre-treatment to clean and degrease the surface. However, for gelcoated GRP surfaces and for other substrates, a de-grease using acetone or similar followed by abrasion and a final de-grease is recommended.

## **Applications**

Crestomer 1151A is supplied pre-accelerated and ready to use in bulk application systems with standard benzoyl peroxide paste Lucidol BT50. Working time can be optimised through catalyst ratio variation to suit specific applications. To maximise properties it is recommended that Crestomer 1151A is applied via a bulk dispensing machine. Hand mixing and application is possible but there will be an associated reduction in performance.

Crestomer 1151A is a versatile material as the recommended temperature range for application is between 5°C and 30°C without loss of strength. However, it gives best results when used between 18°C and 25°C. Crestomer 1151A will remain free flowing even at low temperatures and so is suitable for use year round. The use of additional pigments or fillers is not recommended as they can affect the performance of the adhesive.

Crestomer 1151A has been shown to bond most materials commonly used in the GRP industry, however, 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.

## **Storage**

The shelf life for Crestomer 1151A is 5 months from date of manufacture when stored at a recommended temperature between 15°C and 20°C. Long term exposure above 23°C will reduce the shelf life of these materials.

The product should be stored in its original container out of direct sunlight. The bulk product material should be opened only immediately prior to use, and it's highly recommended that products should never be frozen or exposed to temperatures above 35°C during shipping or storage.

## **Packaging**

Crestomer 1151A is available in parallel sided 25Kg and 200Kg containers.

## **Health and Safety**

See separate Material Safety Data Sheet.

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