

CRYSTIC BP 90-83PA

General Purpose Bonding Paste

Introduction

Crystic BP 90-83PA is a pre-accelerated orthophathlic polyester 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 and any other non structural bonding applications. Crystic BP 90-83PA has been designed for ease of application.

Features and Benefits

Highly thixotropic
Colour change system
Good handling

No drainage on vertical surface
Visual check for effective catalyst mix (blue to white)
Ease of application

Physical Data – Uncured

Physical Data	Unit	Liquid Bonding Paste
Appearance		Light Blue Paste
Viscosity at 25°C ¹	cP	700,000
Stability at 20°C ²	Months	3
Specific Gravity		1.3
Geltime/Working Time* at 25°C ³	Minutes	30
Geltime/Working Time** at 20°C ³	Minutes	40

1. Measured using Brookfield Viscometer at 25°C.
2. Stability defined from date of dispatch when left un-opened in the original containers and out of direct sunlight.
3. Geltime measured with 100g mass of adhesive and 2% Butanox M50.

*2% Butanox M50 (or equivalent catalyst)

Physical Data – Cured

Physical Data	Unit	Fully Cured†	Test Method
Appearance		White	
Hardness (Shore D)		80	BS EN ISO 868:2003
Tensile Strength	MPa	18	BS EN ISO 527-2:1996
Tensile Modulus	MPa	1500	BS EN ISO 527-2:1996
Elongation at Break	%	4	BS EN ISO 527-2:1996
Single Lap-Shear Strength	MPa	9.8	BS ISO 4587:2003

† Curing Schedule - 24 hrs at 20°C, 16 hrs at 40°C

Substrates

Crystic BP 90-83PA can be used on surfaces other than GRP such as timber and plasterboard. However, it is recommended that trials are carried out to ensure that adequate bond strength is obtained.

Surface Preparation

The surfaces to be bonded should be clean, dry and free from any contamination. It may be necessary to 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 paste has cured.

Application

Crystic BP 90-83PA is supplied pre-accelerated. The required hardener is Butanox M50 (or other equivalent MEKP catalyst). The catalyst is added at 2% w/v. Crystic BP 90-83PA can be applied with a spatula or from a dispensing unit, taking care to keep air entrapment to a minimum. Application should always be carried out at temperatures above 15°C. Recommended temperature range for application is between 18 and 25°C.

Additives

Crystic BP 90-83PA is supplied ready to use. The addition of pigments or other materials can adversely affect the degree of cure and bond strength obtained.

Coverage

As a rough guide, 4Kg of bonding paste will cover one square metre to a depth of approximately 3mm.

Storage

Crystic BP 90-83PA should be stored out of direct sunlight in the original containers. It is recommended that the storage temperature should be between 15 and 20°C. Ideally, containers should be opened only immediately prior to use. Products should never be frozen.

Packaging

Crystic BP 90-83PA is supplied in 25Kg and 225Kg containers.

Health & Safety

Please see separate Material Safety Data Sheets.

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