

CRYSTIC BP 90-83PAHV

Bonding Paste

Introduction

Crystic BP 90-83PAHV is a low exotherm pre-accelerated polyester bonding paste. It is a viscous, filled compound designed for the assembly and bonding of GRP mouldings. Such applications include panels, inserts, internal frames, ribs, composite constructions and car body components.

Features and Benefits

Highly thixotropic
Low shrink
Good handling

No sagging on vertical surfaces
No print through
Ease of application

Physical Data – Uncured

The following tables give typical properties of Crystic BP 90-83PAHV when tested in accordance with SB, BS EN or BS EN ISO test methods.

Property	Unit	Liquid Bonding Paste
Appearance		Blue Paste
Viscosity at 25°C		Highly Thixotropic
Stability at 20°C ¹	Months	3
Specific Gravity		1.3
Geltime/Working Time* at 20°C ²	Minutes	33

1. Stability defined from date of dispatch when left un-opened in the original containers and out of direct sunlight.

2. Geltime measured with 100g mass of adhesive with 1% Butanox M50.

*1% Butanox M50 (or equivalent catalyst)

Physical Data – Cured

Property	Unit	Fully Cured†	Test Method
Hardness (Shore D)		85	BS EN ISO 868:2003
Tensile Strength	MPa	25.6	BS EN ISO 527-2:1996
Tensile Modulus	MPa	3101	BS EN ISO 527-2:1996
Elongation at Break	%	3.8	BS EN ISO 527-2:1996
Single Lap-Shear Strength	MPa	3.4	BS ISO 4587:2003

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

Surface Preparation

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 90-83PAHV is supplied pre-accelerated. The required hardener is Butanox M50 (or other equivalent MEKP catalyst). The catalyst is added at 1% w/v. Crystic BP 90-83PAHV should be applied with a spatula 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°C and 25°C.

Additives

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

Storage

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

Packaging

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

Health and Safety

Please see separate Material Safety Data Sheet.

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