

CRYSTIC[®] SCOTTBOND 102PA WHITE

Pourable, Self Levelling Bonding Paste for Flat Panels

Introduction

Crystic[®] Scottbond 102PA 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.

Applications

Crystic[®] Scottbond 102PA 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 102PA 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.

Formulation

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

Crystic[®] Scottbond 102PA White is designed to have a long open time to allow for assembly of sandwich panels, using Andonox[®] 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 pot life.

Features and Benefits

Crystic[®] Scottbond 102PA White is formulated for ease of application, by brush or mohair roller. Crystic[®] Scottbond 102PA 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 102PA 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.

Pot Life

The temperature and the amount of catalyst control the geltime, and hence pot life, of Crystic[®] Scottbond 102PA White. The below table gives the geltime at varying catalyst levels.

Application Conditions	Catalyst Level %	Pot life in minutes (Andonox [®] KP9)	Pot life in minutes (Norox [®] MEKP 925H)
At 25°C measured in a cup (100g)	1	30-35	55 - 65
At 25°C measured in a cup (100g)	1.5	22-27	35 - 45
At 25°C measured in a cup (100g)	2	17-20	25 - 35

The bonding paste, moulding and workshop should all be at, or above, 15°C before curing is carried out.

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

The following table gives typical properties of Crystic® Scottbond 102PA White.

Property	Units	Liquid Bonding Paste
Appearance		Pale Blue Paste
Viscosity at 25°C Brookfield RVT @ 100 RPM	cP	3500 (Thixotropic)
Stability in The Dark at 20°C	Months	3

Storage

Crystic® Scottbond 102PA 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 102PA White is supplied in 25Kg and 225Kg steel containers.

Health and Safety

Please see separate Material Safety Data Sheets.

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