



Product Overview

The Crestafix 621CC range is a pre-accelerated urethane acrylate/ isophthalic polyester high performance bonding paste. It is a non-sagging, filled compound, specifically designed for the assembly and bonding of GRP mouldings.

Features and Benefits

Highly thixotropic	▶	No drainage on vertical surfaces
Colour change system	▶	Visual check for effective catalyst mix
Low shrink system	▶	No print through, excellent surface aspect
Urethane acrylate base	▶	Excellent adhesion and good elongation at break

Typical Application Value

Product	621CC 10	621CC White 20	621CC 30	621CC 45	621CC 65	621CC 85
Working time ¹	10	20	18	25	35	50
Gap Filling	1 - 25 mm	1 - 25 mm	1 - 25 mm	1 - 25 mm	1 - 25 mm	1 - 25 mm
Colour Change	Blue to Brown	Pale Blue to White	Blue/Green to Grey	Blue/Green to Grey	Blue/Green to Grey	Blue to Grey
Recommended Application Temperature	18 - 25 °C (66 - 77 °F)	18 - 25 °C (66 - 77 °F)	18 - 25 °C (66 - 77 °F)	18 - 25 °C (66 - 77 °F)	18 - 25 °C (66 - 77 °F)	18 - 25 °C (66 - 77 °F)

Typical Mechanical Properties

Product	621CC 10	621CC White 20	621CC 30	621CC 45	621CC 65	621CC 85
Lap-Shear Strength ³		10 MPa (1450 psi)	10 MPa (1450 psi)	10 MPa (1450 psi)	10 MPa (1450 psi)	10 MPa (1450 psi)
Tensile Strength ⁴		25 MPa (3600 psi)	25 MPa (3600 psi)	25 MPa (3600 psi)	25 MPa (3600 psi)	25 MPa (3600 psi)
Tensile Modulus ⁴		3000 MPa (435,000 psi)	3000 MPa (435,000 psi)	3000 MPa (435,000 psi)	3000 MPa (435,000 psi)	3000 MPa (435,000 psi)
Tensile Elongation ⁴		3%	3%	3%	3%	3%
Hardness	70 Shore D	80 Shore D	80 Shore D	80 Shore D	80 Shore D	80 Shore D
Approvals		Grade 2 DNV	Grade 2 DNV	Grade 2 DNV	Grade 2 DNV	Grade 2 DNV

Typical Liquid Properties

Product	621CC 10	621CC White 20	621CC 30	621CC 45	621CC 65	621CC 85
Viscosity ⁵	280,000 - 320,000 cP	120,000 - 200,000 cP	120,000 - 200,000 cP	120,000 - 200,000 cP	120,000 - 200,000 cP	180,000 - 240,000 cP
Specific Gravity	1.25 g/cc	1.25 g/cc	1.25 g/cc	1.25 g/cc	1.25 g/cc	1.25 g/cc
Shelf Life ⁶	6 Months	6 Months	6 Months	6 Months	6 Months	6 Months

Substrates

Crestafix 621CC range is suitable for use on GRP laminate, but can also be used on timber and plasterboard. However, it is recommended that trials are carried out to ensure that adequate bond strengths are obtained.

Please contact Scott Bader technical services for information on other substrates and advice.

Surface Preparation

The surfaces to be bonded should be clean, dry and free from any contamination. It may be necessary to mechanically 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 adhesive has hardened.

Application

Crestafix 621CC range is supplied pre-accelerated, requiring only the addition of catalyst to start the curing reaction. The recommended catalyst is Butanox M50, which should be added at 2% v/w into the bonding paste. The catalyst should be thoroughly incorporated into the material with a low shear mechanical stirrer where possible, taking care to keep air entrapment to a minimum. Alternatively the bonding paste can be applied with a dispensing unit.

The use of additional pigments or fillers is not recommended as they can affect the performance of the adhesive.

For industrial/commercial use only. 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 have been obtained under controlled conditions at the Scott Bader laboratory.

Coverage

As a rough guide, 4.0Kg (9 lbs) of bonding paste will cover one square metre to a depth of approximately 3mm (0.12 inch).

Storage and Shelf Life

The Crestafix 621CC range should be stored between 2°C and 23°C (36°F and 77°F) in the original ,unopened container in a dry, well ventilated place. Protect from freezing and direct sunlight. Avoid contact with oxidising agents.

The shelflife is defined from date of manufacture when stored as recommended . The expiry date is indicated on product labels.

Packaging

The Crestafix 621CC range is supplied in 25Kg (55 lbs) and 225Kg (500 lbs) containers.

Health and Safety

See Material Safety Data Sheet.

Notes

1. Working time measured with 100g of adhesive with Butanox M50 (2%) at 25°C (77°F).

2. GRP lap shear tested to BS ISO 4587.

3. Tensile properties tested to BS EN ISO 527-2.

4. Viscosity measured using Brookfield Viscometer at 25°C (77°F).

5. Shelf life is defined from date of manufacture when stored as recommended.



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