

# CRESTABOND® M1-60HV

## Technical Data Sheet



### Product Overview

Crestabond M1-60HV is a toughened, two component 10:1 acrylic adhesive designed for bonding composites, thermoplastics and metals. This new generation of structural methacrylate adhesive meets the bonding requirements of most assembly operations. Demonstrating excellent impact, peel, shear, compressive strength and fatigue resistance properties across all bonded parts.

### Features and Benefits

|   |   |   |
|---|---|---|
| Primerless metal application                | ▶ | No need for extra materials or processes          |
| Excellent adhesion to dissimilar substrates | ▶ | Affords greater flexibility in design checks      |
| Fast setting and curing                     | ▶ | Speeds up assembly process                        |
| Non-sag                                     | ▶ | Application on vertical surfaces                  |
| High strength, modulus and toughness        | ▶ | Designed for demanding structural applications    |
| Excellent environmental resistance          | ▶ | Designed for demanding environmental applications |

#### Application Properties

|                                     |                            |
|-------------------------------------|----------------------------|
| Working Time <sup>1</sup>           | 50 - 70 Minutes            |
| Fixture Time <sup>2</sup>           | 150 - 180 Minutes          |
| Gap Filling                         | 1 - 50 mm/ 0.04 - 2.0 inch |
| Mixed Colour                        | Green                      |
| Recommended Application Temperature | 18 - 25 °C/ 66 - 77°F      |

#### Mechanical Properties

|                                   |                           |
|-----------------------------------|---------------------------|
| Tensile Strength <sup>5</sup>     | 22 - 26 MPa               |
| Tensile Modulus                   | 1200 - 1600 MPa           |
| Tensile Elongation                | 50 - 70%                  |
| Aluminium Lapshear                | 12 - 16 MPa               |
| Recommended Operating Temperature | -40 - 100 °C/ -40 - 212°F |

#### Liquid Properties

| Product                 | M1-60HV Adhesive     | Activator 1         |
|-------------------------|----------------------|---------------------|
| Viscosity <sup>3</sup>  | 340,000 - 380,000 cP | 80,000 - 120,000 cP |
| Specific Gravity        | 0.97 - 1.03          | 1.05 - 1.15         |
| Mixed Ratio (by volume) | 10                   | 1                   |
| Mixed Ratio (by weight) | 9.1                  | 1                   |
| Colour                  | Off white            | Green               |
| Shelf Life <sup>4</sup> | 12 months            | 12 months           |

## Recommended Substrates

|            | Recommended Substrates<br>(Lap Shear Strength MPa <sup>6</sup> )   | Non - Recommended<br>Substrates   |
|------------|--|---|
| Plastics   | Acrylic 15 - 20 MPa<br>PVC 14 - 18 MPa<br>ABS 10 - 14 MPa<br>Other: Styrenics, Urethanes,<br>CPVC  | Low Surface Energy<br>Plastics<br>e.g. PP, PE, PTFE<br>(use Crestabond PP-04) |
| Metals     | Stainless 12 - 16 MPa<br>Aluminium 12 - 16 MPa<br>Other: Powder Coated Metals,<br>Carbon Steel   | Zinc/ Galvanised Coated<br>Metals,<br>Copper                                  |
| Composites | GRP/FRP <sup>7</sup> 8 - 12 MPa<br>Carbon Fibre/ Polyester<br>DCPD Modified Vinyl Esters<br>Epoxy <sup>9</sup><br>Gelcoats <sup>10</sup> | -   |

## Surface Preparation

The surface to be bonded can affect the strength and durability of the bond joint. Appropriate treatment may be required to ensure that there are no traces of oil, grease or dirt through the use of a degreasing agent, for instance acetone or another degreasing agent on the joint surfaces.

Mechanically abrading or chemically etching degreased surfaces can make bond joints more durable and stronger. If abrading, a second treatment of degreasing is highly recommended.

Do not use gasoline (petrol), low grade alcohol or paint thinners.

### i) Metals

Typically, the surface should be clean and dry by using an alcohol/solvent wipe and allowing the solvent to evaporate before application. Certain metals, such as carbon steel may also require mechanical abrasion and a subsequent alcohol solvent wipe prior to bonding.

### ii) Thermoplastics

The surface must be clean, dust-free and dry. A suitable solvent such as iso-propanol can be used to degrease.

### iii) Composites

The surface must be clean, free of dust and dry. This can be achieved by the use of proprietary strippable cloths such as peel-ply (without lubricant contaminants). The laminate should be fully cured prior to bonding and if the laminate surfaces are more than 3 days old, it is recommended that the surface must be cleaned with a suitable solvent or cleaner with a lint-free, clean cloth prior to bonding.

Surface preparation, such as mechanical abrasion, is likely to be needed on gel coat surfaces and moulded surface where release agents are likely to be present. When bonding epoxy laminates please test bond strength prior to application.

## Application

Prior to bonding, ensure the substrate surface is clean by following instructions provided. Bulk dispensing equipment should be in good operating condition. Dispense the adhesive at slow rate initially onto a non-bonding surface until the bead colour is uniform opaque grey or black, depending on the adhesive grade. Check the dispensed bead for cure quality before beginning the bonding process.

Dispense enough adhesive to fill the bond gap before parts are mated. Avoid dry bonds by using adequate pressure to mate parts and clamp properly to prevent joint movement. The working time is the approximate time after mixing that the adhesive is still useable. The bonding process must be completed before the working time of the mixed adhesive expires. The effect of temperature upon this working time can be seen in the graph on the previous page. The viscosities of both adhesive and activator are affected by temperature. The adhesive, activator and parts to be bonded should be allowed to attain workshop temperature of between 18°C and 25°C/ 64 and 77°F prior to bonding. This temperature should be maintained during the bonding process and until the adhesive is sufficiently cured to allow movement of the assembly. Typically, such movement may be possible after the fixture time of the adhesive is achieved. Ambient temperature, bondline thickness and the substrate materials being bonded can all affect the fixture time.

For industrial/commercial use only. Not to be used in household applications. 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 and Shelf Life

Crestabond products should be stored in their original container out of direct sunlight. The bulk product or cartridge material should be opened only immediately prior to use. The expiry date is indicated on the product labels.

The shelf life is defined from date of manufacture when stored at a recommended temperature between 2°C and 23°C/ 36 and 73°F. It is highly recommended that products should never be frozen. Exposure to temperatures above 23°C will reduce the shelf life of these materials. Exposure above 35°C/ 95°F of activators, including the cartridges, should be avoided as the reactivity of the product is quickly diminished.

## Packaging

Crestabond M1-60HV is supplied in 18Kg/ 40lb plastic pails, 180Kg/ 397lb drums, pre-packed 400ml co-axial and 825ml side by side cartridges.

## Health and Safety

See separate Material Safety Data Sheet.

|  |  |
|--|--|
| 1. Working time measured with 10g mass of adhesive with 10:1 mix ratio by volume at 24°C/ 75°F.  | 2. Fixture time defined using an ISO 4587 lap-shear sample, 0.26mm bondline thickness with 23°C ambient temperature achieving >1.4MPa. |
| 3. Viscosity measured using a Brookfield Viscometer at 24°C/ 75°F.   | 4. Shelf life defined from date of manufacture when stored as recommended.   |
| 5. Tested to ASTM D638.  | 6. Metals tested according to ISO 4587, Thermoplastics according to ASTM 2564 and GRP according ASTM 5868.                             |
| 7. Substrate failure when tested.  | 8. Maximum temperature where an ISO 4587 lap-shear sample, 0.26mm bondline thickness achieves >3MPa.                                   |
| 9. Surface preparation of epoxy laminates may be necessary and testing should be performed to ensure sufficient bond strength is achieved. | 10. Surface preparation is likely to be needed on gelcoat surfaces to ensure no release agents are present.                            |



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