

Structural adhesives

A new range from thyssenkrupp Materials (UK)

Market Applications

- ➔ **Marine** *from kayaks to super yachts*
- ➔ **Land Transportation** *buses, coaches, trains and trucks*
- ➔ **Building & Construction** *doors, windows and cladding*
- ➔ **Wind Energy** *blades, housing and caravans*
- ➔ **Recreational Vehicles** *motorhomes and caravans*
- ➔ **Agricultural Vehicles** *tractors, diggers and combine harvesters*

CRESTABOND[®]
— STRUCTURAL ADHESIVES —



COMPOSITES METALS PLASTICS

Adhesive Selection Guide

Selection of the appropriate product is essential for long-term adhesion and durability.

Product	Description	Colour	Mix Ratio by Volume	Viscosity (cP)	Working Time (mins)	Fixing Time (mins)	Tensile Elongation (%)	Tensile Strength (MPa)	Tensile Modulus (MPa)	Gap Fill (mm)
M1-04	Universal Bonder	Grey	10:1	100,000 - 140,000	3 - 5	8 - 10	70	14 - 17	400 - 600	1 - 15
M1-05	Universal Bonder	Grey or Black	10:1	100,000 - 140,000	4 - 7	12 - 18	70	14 - 17	400 - 600	1 - 15
M1-20	Universal Bonder	Grey or Black	10:1	100,000 - 140,000	14 - 22	25 - 35	70	16 - 19	600 - 850	1 - 25
M1-30	Universal Bonder	Grey or Black	10:1	200,000 - 240,000	25 - 35	60 - 80	>100	17 - 20	750 - 1000	1 - 50
M1-60	Universal Bonder	Grey	10:1	200,000 - 240,000	50 - 70	150 - 180	>100	16 - 18	650 - 850	1 - 50
M1-90	Universal Bonder	Off White	10:1	200,000 - 240,000	80 - 100	210 - 240	>100	16 - 18	650 - 850	1 - 50
M7-05	Universal Bonder	Off White	1:1	30,000 - 70,000	4 - 7	18 - 22	44	23 - 26	1300 - 1700	1 - 5
M7-15	Universal Bonder	Off White	1:1	30,000 - 70,000	10 - 20	30 - 45	43	20 - 23	1400 - 1700	1 - 5

Based on laboratory results

Suitability Guide

Product	GRP	Stainless Steel	Aluminium	Powder Coated Steel	Cold Rolled Steel	ABS	Acrylic	Polycarbonate	Galvanised
M1-04	✓✓	✓✓	✓✓	✓✓	✓✓	✓	✓✓	✓	
M1-05	✓✓	✓✓	✓✓	✓✓	✓✓	✓	✓✓	✓	
M1-20	✓✓	✓✓	✓✓	✓✓	✓✓	✓	✓✓	✓	
M1-30	✓✓	✓	✓✓	✓	✓	✓	✓	✓	
M1-60	✓✓	✓	✓	✓	✓	✓	✓	✓	
M1-90	✓✓	✓	✓	✓	✓	✓	✓	✓	
M7-05	✓✓	✓✓	✓✓	✓✓	✓✓	✓	✓✓	✓	✓✓
M7-15	✓✓	✓✓	✓✓	✓✓	✓✓	✓	✓✓	✓	✓✓

Multiple ticks denote exceptional suitability