



TECHNICAL DATA SHEET

FORBOND 4600FR+

TECHNICAL CHARACTERISTICS

Base	Epoxy Resin
Density - g/cm ³	1.1
Viscosity	Low viscosity liquid
Thixotropic	No
Usable Life (*)	1 hour
Setting Time at 25°C (*)	12 hours
Setting Time at 60°C (*)	20 minutes
Lap Shear Strength	>12MPa
Temperature Resistance	40°C to +70°C
Temperature Resistance - ground soak	55°C to +90°C
Water Absorption	<0.1
Mix Ratio	163A : 100B by weight

(*) These values may vary depending on environmental factors such as: temperature, moisture and type of substrates.

PRODUCT

Forbond 4600FR+ is a two component low viscosity modified epoxy adhesive for laminating. Developed for bonding aluminium, laminate, foam-structural core materials etc. The product needs to be cured at elevated temperatures >60°C for best performance. Commonly used in bonding applications in aircraft and mass transit interiors where fire, smoke and toxicity standards need to be met

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APPLICATION

Forbond 4600FR+ can be applied by roller coater (40-60gsm - depending on substrate) or by notched trowel (60-80gsm). The adhesive has long pot life and very long open time on application rollers. Press time will vary with temperature and substrates but typical press temperature is 80°C for 10 minutes. Can be used with Forbond aluminium cleaner for bonding laminate to aluminium sheet without the need of abrading and primers.

PACKAGING

Colour: Resin - Red, Hardener - Blue
Packaging: 5 litre and 20 litre plastic pails

SELF LIFE

12 months from date of manufacture in unopened packaging in a cool and dry storage place at temperatures between plus 5°C and plus 25°C.

HEALTH AND SAFETY RECOMMENDATIONS

- Apply the usual industrial hygiene
- Avoid contact with skin and eyes
- A barrier cream / gloves are recommended
- Consult the label for more information

The variability of materials, substrates and conditions of use is such that no warranty of their functionality for a specific application can be deducted from this information, written recommendation or any other type of suggestion offered. Each user has the responsibility to complete adequate evaluations on the efficacy of the materials offered by Forgeway, of its products, services, recommendations and suggestions for the specific application need, and must accomplish sufficient testing to ascertain that the final product will be safe and sound for the final intent of the end-user.