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TECHNICAL DATA SHEET

PUROK VX63-80

TECHNICAL CHARACTERISTICS

Base		Hybrid methacrylate	
Appearance		White (adhesive)	White (activator)
Viscosity		130,000 - 150,000	
Mix Ratio:	by volume	10:1	
	by weight	6:1	
Density		1.00 g/cm ³	
Working Time		40 - 45 minutes	
Fixture Time		70 - 80 minutes	
Full Cure		24 hours	
Gap Fill		1mm - 12mm	
Shore Hardness (Shore D)		73	
Elongation		55 - 65%	
Tensile Shear Strength		15 - 18 MPa	
Service Temperature		-40°C to +120°C	

PRODUCT

Purok VX63-80 is a two component hybrid toughened structural methacrylate adhesive for bonding a wide range of plastics, metals and composites

APPLICATIONS

- Effective for bonding dissimilar materials e.g. bare metal, painted metal, plastics, glass and ceramics
- In aerospace for the bonding of aluminium brackets to composite panels, and the structural bonding of composite components
- With GRP bonding of bracketry, and bonding to metallic structures
- In the automotive industry for the bonding of composite components to metallic structure or to composite structures



FORGEWAY

CHARACTERISTICS

- Bright white and UV stable
- Excellent impact, peel and shear resistance
- High durability
- Gap fill up to 12mm
- Non-sagging and thixotropic

PACKAGING

Colour: White
Packaging: 380ml, 18kg drum or 180kg drum

SHELF LIFE

9 months in unopened packaging from date of manufacture, in a cool and dry storage place at temperatures between +10°C and +25°C

LAP SHEAR STRENGTH

Substrate	Average Shear Strength & Failure Mode
Stainless Steel / Stainless Steel	12.1 MPa - cohesive failure
Aluminum / Aluminum	18.6 MPa - cohesive failure
ABS / ABS	11.7 MPa - substrate failure
GRP / GRP	10.7 MPa - fibre tear
Aluminum / ABS	12.1 MPa - substrate failure

SUBSTRATE

- Ideal for bonding all types of PVC, polycarbonate, acrylic, fibreglass, PBT, PPO, ABS, FRT, polyurethane, epoxy, wood, RIM, nylon, GRP, polyesters, gelcoats, styrene stainless steel, carbon steel, aluminium etc
- Ideal for automotive components, marine assemblies, thermoform enclosures, appliances, metal assemblies, electrical components, furniture, plastic fabrications, sign & display, composite assemblies etc

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APPLICATION

<i>Method:</i>	Manual or pneumatic caulking gun, remove resealable cap and pull trigger until both components are extruded, screw on static mixer nozzle, Dispose of first 2cm of mixed adhesive. After application remove nozzle and replace cap. To restart repeat these instructions.
<i>Application temperature:</i>	+5°C to +35°C
<i>Repair with:</i>	Purok VX63-80

HEALTH AND SAFETY

Always use in well ventilated areas
The mixing of the adhesive and hardner starts a chemical reaction which is exothermic (15mm thickness and greater can generate temperatures of over 120°C)

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.