



AEROK®

PYROK®

FORMOA®

FORBOND®

PUROK™

## Material Technical Data Sheet

## FORMOA 024TH

Reviewed on 24 April 2003

### TECHNICAL CHARACTERISTICS

Base	MS Polymer®
Consistency	Stable Paste
Curing Rate (*)	3-4mm/24h (20°C/65% R.V.)
Hardness	50 - 55 Shore A (DIN 53504)
Specific Gravity	1.40g/ml
Application Temperature	5°C until 35°C
Temperature Resistance (fully cured)	-40°C until 100°C
Elasticity Modulus 100%	1.3 - 1.6 MPa (DIN 53504)
Tear Resistance ASTM D624 - 73	18 - 20kg/cm
Elongation at Break	>350% (DIN 53504)

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

### PRODUCT

Formoa 024TH is a high quality single component moisture curing adhesive-sealant based on MS Polymer®. Permanently elastic and flexible combined with excellent adhesion to a great variety of surfaces, with high cohesive strength, make Formoa 024TH suitable for making high performance elastic adhesive seals and joints. Fast cure and overpaintability make Formoa 024TH an ideal product for use in coach building and construction applications.

### CHARACTERISTICS

- Solvent and isocyanate free
- No shrinkage
- Fast cure
- Permanently elastic -40°C to 100°C
- Odourless
- Compatible with most paints
- Overpaintable soon after skin formation
- Good adhesion to a wide variety of substrates



## PACKAGING

*Colour:* White, grey  
*Packaging:* Cartridge 290ml, Foil Bag 600ml, hobbock 20L

## SHELF LIFE

12 months in unopened packaging, in a cool and dry storage place at temperatures between +5°C and +25°C.

## RESISTANCE TO CHEMICAL AGENTS

Good resistance to water, aliphatic solvents, mineral oils, grease, diluted inorganic acids and alkalis. Poor resistance to aromatic solvents, concentrated acids and chlorinated hydrogens.

## SUBSTRATES

*Nature:* Clean, dry, free of dust and grease  
*Priming:* Porous surfaces should be primed with **Primer 150**.  
**Formoa Surface Activator** may be used on non porous surfaces.

We recommend preliminary compatibility tests previous to application.

## JOINT DIMENSIONS

*Minimal width:* 2mm (bonding)  
5mm (joints)  
*Maximal width:* 10mm (bonding)  
30mm (joints)  
*Minimal depth:* 5mm (joints)  
*Recommendation:* width of joint = 2X depth of joint

AEROK®

PYROK®

FORMOA®

FORBOND®

PUROK™



## APPLICATION

<i>Method:</i>	Manual or pneumatic caulking gun
<i>Application temperature:</i>	+5°C until +30°C
<i>Cleaning:</i>	White Spirit or <b>Surface Cleaner</b> immediately after application and before curing
<i>Tooling:</i>	With soapy solution before skin formation
<i>Repair with:</i>	<b>Formoa 024TH</b>

## HEALTH AND SAFETY RECOMMENDATION

Apply the usual industrial hygiene

### Remarks:

Formoa 024TH may be overpainted, however, due to the large number of paints and varnishes available, we strongly advise a compatibility test before application. The drying time of alkyd resin based paints may increase. Formoa 024TH can be applied to a wide variety of substrates. Due to the fact that specific substrates, such as: plastics, polycarbonates, etc, may differ from manufacturer to manufacturer we recommend preliminary compatibility tests.

AEROK<sup>®</sup>

PYROK<sup>®</sup>

FORMOA<sup>®</sup>

FORBOND<sup>®</sup>

PUROK<sup>™</sup>

