

## PRODUCT

Formoa® 055 is a high-quality single component, primerless glass bonding adhesive with high adhesive strength and excellent long-term durability. It has fast skin time and rapid strength build up.

**055**  
Formoa



### Characteristics

- High-performance mechanical properties.
- Combines high-stiffness with very high-bond strength.
- High green strength, quick build-up of end strength, high-shear strength after full cure.
- Does not contain isocyanates, silicone, solvent.
- Can be sanded after full cure.
- Flexible elastic rubber - movement accommodation up to 20%.
- No bubble formation within sealant (in high temperature and humidity applications).
- Very easy to tool and finish.
- Colour stability and UV resistance.
- Withstands all climatic conditions.
- Minimal health and safety considerations.

### Applications

- For use in glass bonding applications in the car, coach, caravan, marine, train, aerospace industries, where a tough and flexible bond is required.
- Structural elastic bonding between metal surfaces, coated surfaces and many plastics (not PE, PP, Teflon).
- Structural bonding in vibrating constructions.
- Backfilling / seaming between glass and body side.

### Technical characteristics

Base Material	Hybrid Polymer
Consistency	Stable Paste
Curing System	Moisture
Through Cure Rate (mm/24hrs)	3
Density (Kg/l)	1.43
Elasticity Modulus at 100% (N/mm <sup>2</sup> ) ISO 37	1.2
Elongation at Break (%) ISO 37	>450
Tensile Strength (N/mm <sup>2</sup> ) ISO 37	>3.3
Max Open Time (mins)	15
Shear Strength (N/mm <sup>2</sup> ) ASTM D1002 - rate - 6mm/min	>2.5
Shore A Hardness ±5	60
Skin Over Time (mins)	14
Viscosity C&P @ 0.6 s <sup>-1</sup> (Pa.s)	3000
Volume Alteration (%)	<1
Colour Stability UV Exposure ASTM G154 (CIELab - ΔE)	<1

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

## Packaging

<b>Colour</b>	Black.
<b>Contents</b>	600ml foil pack, 200L on request.
<b>Shelf life</b>	12 months in unopened packaging, in a cool and dry storage place at temperatures between +5°C and +25°C.

## Substrates

<b>Nature</b>	Clean glass and body side frame using Formoa® Surface Activator. Allow 10 minutes to flash off and activate. A 'milky' white residue left on the glass is correct.
<b>Priming</b>	Non-fritted glass needs to be primed with Formoa® Primer PG (see TDS for Formoa® PG for application). We recommend preliminary compatibility tests previous to application.

## Bonding

Formoa® 055 has excellent adhesion on many surfaces. The following metal surfaces have been tested: Steel, AlMgSiI, Brass, Electrogalvanised Steel, AlCuMg1, Firegalvanised Steel, Steel ST1403. Excellent adhesion as well on many plastics: Polystyrene, Polycarbonate (MarcolonR, LexanR), PVC, ABS, Polyamide, PMMA, GRP, Fibre Reinforced Epoxy and Polyester.

Please remove protective films from plastic surfaces, prior to application of Formoa® 055. No adhesion on: PE, PP and PTFE (Teflon).

## Application

<b>Method</b>	Manual or pneumatic caulking gun.
<b>Application temperature</b>	+5°C until +30°C.
<b>Cleaning</b>	White Spirit or Formoa® Surface Cleaner immediately after application and before skin formation.
<b>Tooling</b>	Soapy solution before skin formation.
<b>Repair with</b>	Formoa® 055.

## 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, chlorinated hydrocarbons.



## Remarks, Disclaimer & Health and safety

**Remarks** - Formoa® 055 can be coated with many types of paints and varnishes. Due to the large variety of paints and coatings a compatibility test is strongly recommended. The drying times of alkyd resin based paints may increase. Formoa® 055 can be painted immediately after application "wet on wet" with water-based industrial paints in paint ovens at temperatures of up to 200°C for up to 45 minutes. Formoa® 055 can be applied to a wide variety of substrates. Due to the fact that specific substrates such as plastics, polycarbonate, etc. May differ from manufacturer to manufacturer, we recommend preliminary compatibility tests. This product cannot be used as glazing sealant. See specific application instruction, available on request.

**Disclaimer** - 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.

**Health and safety** - Refer to Safety Data Sheet (SDS) for further information. Apply the usual industrial hygiene.

Reviewed November 2018

