

# PYROK®

## PYROK 805FR



### Technical Data Sheet

Pyrok 805 FR is a two component fire retardant polyurethane- oxirane adhesive for bonding a wide variety of metals, plastics and composite materials used in the aircraft manufacturing industry.

Meeting the requirements of FAR/JAR/CS 25.853 (a) - 60 second vertical burn.

### Technical Characteristics

Base	Polyurethane	Full Cure (*)	7 days
Viscosity	25,000 – 30,000 mPaS	<b>Lap Shear Strength</b>	
Thixotropic	Flow controlled when mixed	<ul style="list-style-type: none"><li>Range of polycarbonate based thermoplastics 6mm/min</li><li>Abraded alu/Abraded alu 6mm/min</li></ul>	4-11 MPa, with some showing substrate failure in preference of adhesive failure. 11 MPa
Working time (*)	12 minutes		
Mix Ratio - volume	1 : 1		

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

### Packaging

Colour	>Beige >Colour match to suit requirements available
Cartridge twin packs	>50ml / 1.69floz >200ml/6.76floz >400ml / 13.53floz >Bulk hobbocks

### Shelf Life

12 Months in unopened packaging. Store in a cool and dry storage place at temperatures between +15°C and +25°C / +59°F and +77°F



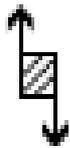
# Health and Safety Recommendations

- As with all chemical produce avoid contact with skin and eyes
- Apply the usual industrial hygiene
- Wear protective gloves
- 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.

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## Test Methods and Footnotes:



- 1 Overlap Shear test pieces configured to ASTM D1002 standard allowed to cure for 7 days at ambient including 2 hours at 80 C (unless otherwise noted) and tested at a rate of 6mm/minute. Strength determined at 24°C unless otherwise noted.