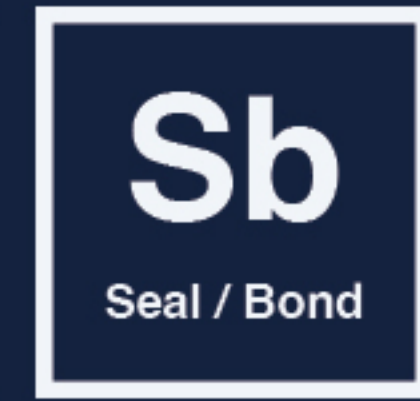




**FORGEWAY**  
GLUE WITH HIGH IQ



## Technical Data Sheet: FORMOA 006 Crystal

### Product Description

**Formoa Crystal** is a single-component Hybrid Polymer sealant. It is designed for sealing applications requiring a crystal clear sealant with low viscosity and high UV stability.

### Key Features

- Silicone and solvent free
- Excellent adhesion
- High performance mechanical properties
- No bubble formation within sealant.
- Primerless adhesion
- Very easy to tool and finish
- Good extrudability
- Minimal health and safety considerations
- Resistance to many chemicals.
- No staining of porous materials such a natural stone, granite, marble, etc.
- High UV performance.



### Applications

- Internal / external sealing applications in the automotive, mass transportation, commercial vehicle, caravan, rail and aerospace industries
- Sealing where a tough / flexible, anti-pick joint is required.
- Sealing where a crystal clear joint is required.

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Technical Characteristics

Formoa Crystal

| Properties                                                        | Formoa Crystal |
|-------------------------------------------------------------------|----------------|
| Base Material                                                     | Hybrid Polymer |
| Consistency                                                       | Stable Paste   |
| Curing System                                                     | Moisture       |
| Through Cure Rate (mm/24hrs)                                      | 2              |
| Density (Kg/l)                                                    | 1.07           |
| Elasticity Modulus at 100% (N/mm2)                                | >0.6           |
| Elongation at Break (%)                                           | >250           |
| Tensile Strength (N/mm2)                                          | >1             |
| Max Open Time (mins)                                              | 20             |
| Shear Strength (N/mm2)                                            | 1.7            |
| Shore A Hardness $\pm$ 5                                          | 45             |
| Skin Over Time (mins)                                             | 10 mins        |
| Viscosity C&P @ 0.6 s-1 (Pa.s)                                    | 800            |
| Volume Alteration (%)                                             | <1             |
| Colour Stability UV Exposure<br>ASTM G154 (CIE Lab - $\Delta E$ ) | -              |

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

Remarks, Disclaimer & Health and Safety

**Remarks** - Formoa® 006 Crystal 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 alkylid resin based paints may increase. Formoa® 006 Crystal can be painted immediately after application “wet on wet” with waterbased industrial paints in paint ovens at temperatures of up to 200°C for up to 45 minutes. Formoa® 006 Crystal 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, we recommend preliminary compatibility tests. This product cannot be used as glazing sealant. See specific application instruction, available on request.

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## Colours

Clear / Transparent



## Shelf Life

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

## Application Instructions

|                         |                                                                                                                                                                                                              |
|-------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Method                  | Manual or pneumatic caulking gun.                                                                                                                                                                            |
| Application Temperature | +10°C until +30°C.                                                                                                                                                                                           |
| Substrates + Priming    | Ensure substrates are clean, dry, free of dust and grease. When bonding, Formoa® Surface Activator may be used on non-porous surfaces. We recommend preliminary compatibility tests previous to application. |
| Cleaning                | White Spirit or Formoa® Surface Cleaner immediately after application and before curing.                                                                                                                     |
| Tooling                 | Soapy solution before skin formation.                                                                                                                                                                        |
| Repair with             | Formoa® 006 Crystal                                                                                                                                                                                          |

## Volumes Available.

Cartridge  
290ml



## Resistance to Chemicals

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

**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 January 2021**