

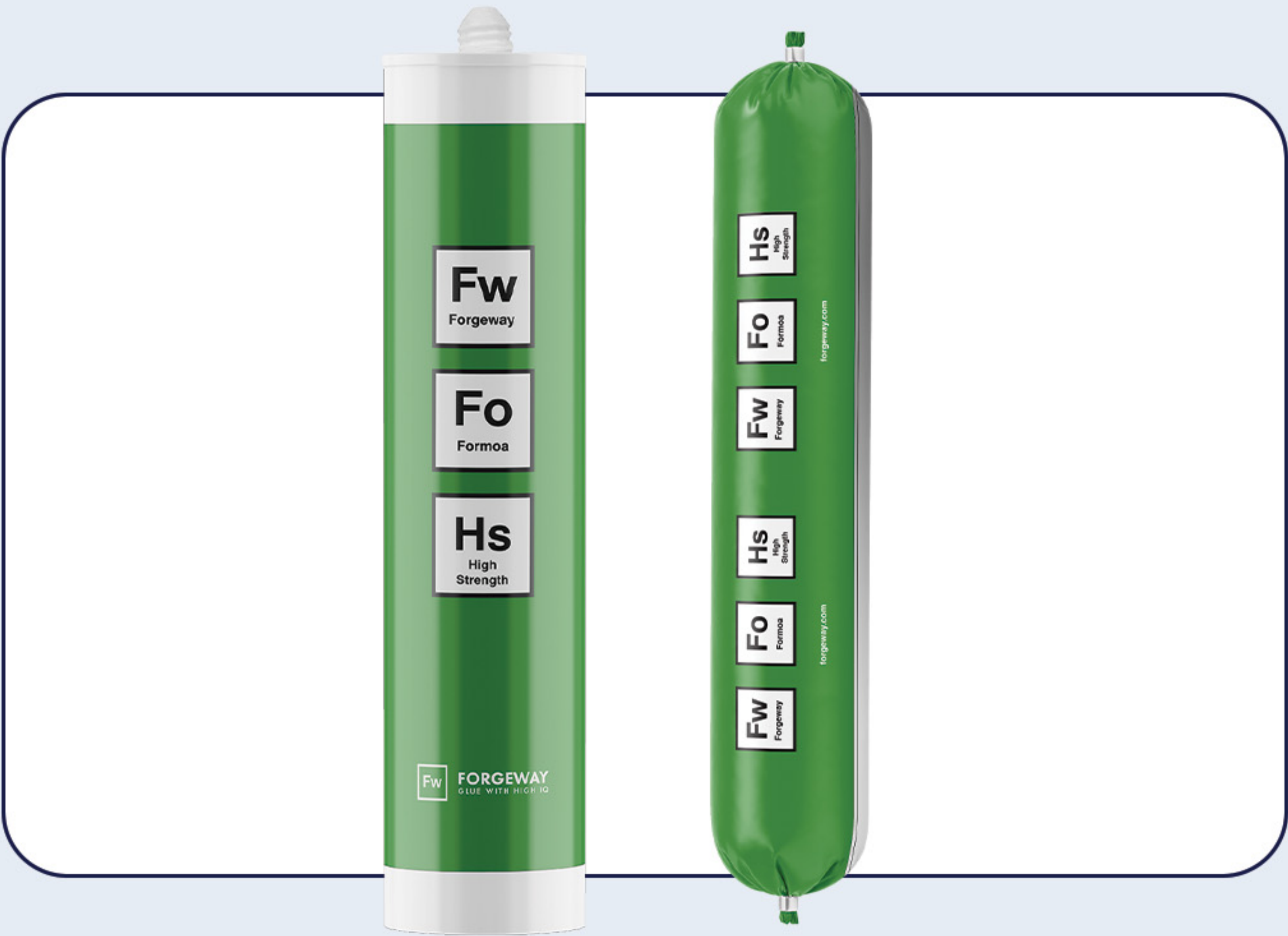
Technical Data Sheet: FORMOA 017 FE

Product Description

Formoa 017 FE is a single-component MS Polymer adhesive. It is designed for applications that need a high strength, flexible, and medium viscosity but with increased curing speed.

Key Features

- Excellent adhesion.
- High bond strength.
- Quick build-up of end strength.
- Does not contain isocyanates, silicone or solvents.
- Can be sanded after full cure.
- Flexible, movement accommodation up to 20%.
- Very easy to tool and finish.
- Colour stable and UV resistant.
- Withstands all climatic conditions.
- Easy to extrude.



Applications

- Structural elastic bonding in vibrating constructions between metal, composites, painted surfaces, and most plastics (will require primer with PE, PP, and Teflon).
- Structural bonding applications in automotive, mass transportation, caravan, marine, and aerospace industries.
- Bondings which pass through paint tunnels.

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Technical Characteristics

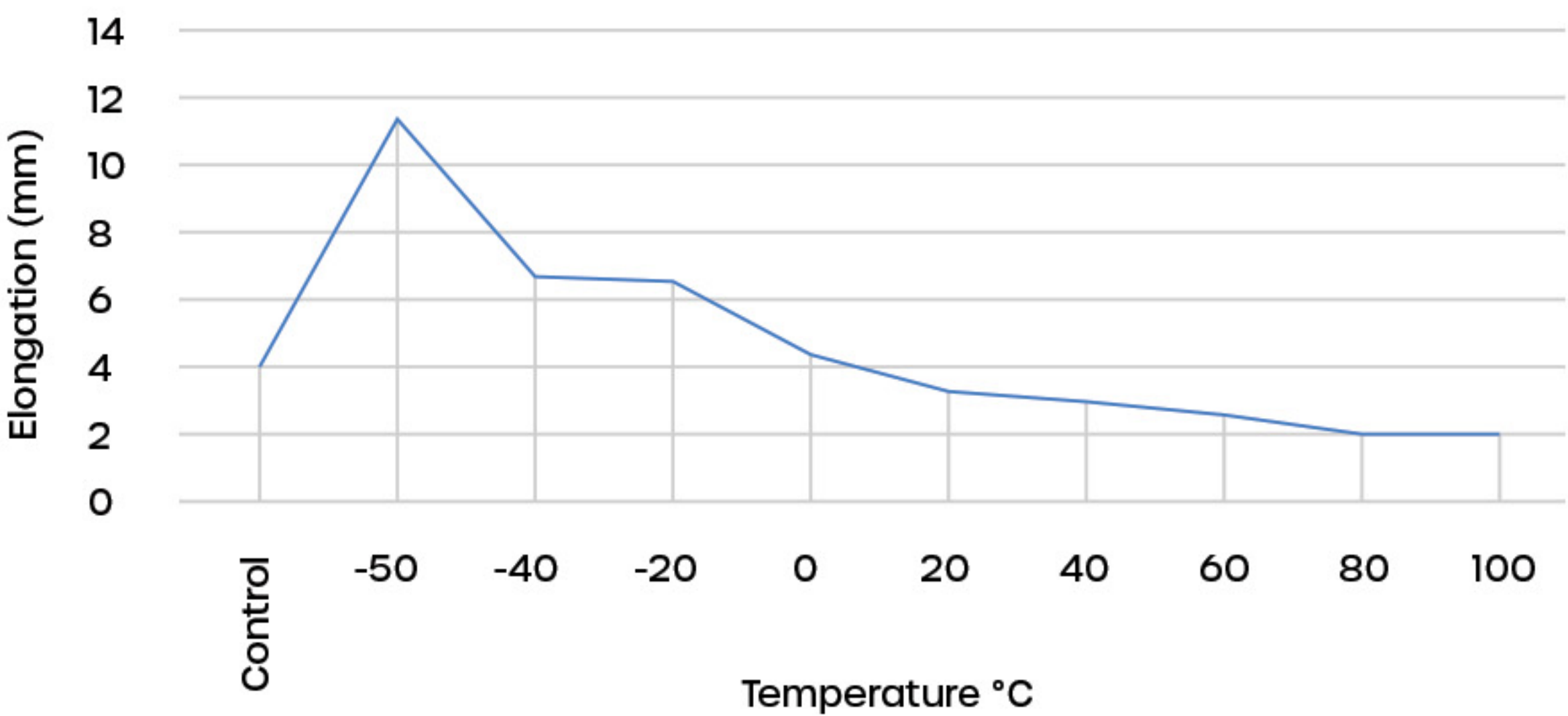
Formoa 017 FE

Properties	Formoa 017 FE
Base Material	Hybrid Polymer
Consistency	Stable Paste
Curing System	Moisture
Through Cure Rate (mm/24hrs)	4
Density (g/ml)	1.46
Elasticity Modulus at 100% (N/mm2) ISO 37	>1
Elongation at Break (%) ISO 37	>300
Tensile Strength (N/mm2) ISO 37	4
Max Open Time (mins)	20
Shear Strength (N/mm2) ASTM D1002 - rate 6mm/min	>2.5
Shore A Hardness ±5	65
Skin Over Time (mins)	10
Viscosity C&P @ 0.6s (Pa.s)	2700
Volume Alteration (%)	<1
Colour Stability UV Exposure ASTM G154 (CIELab- AE)	<1

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

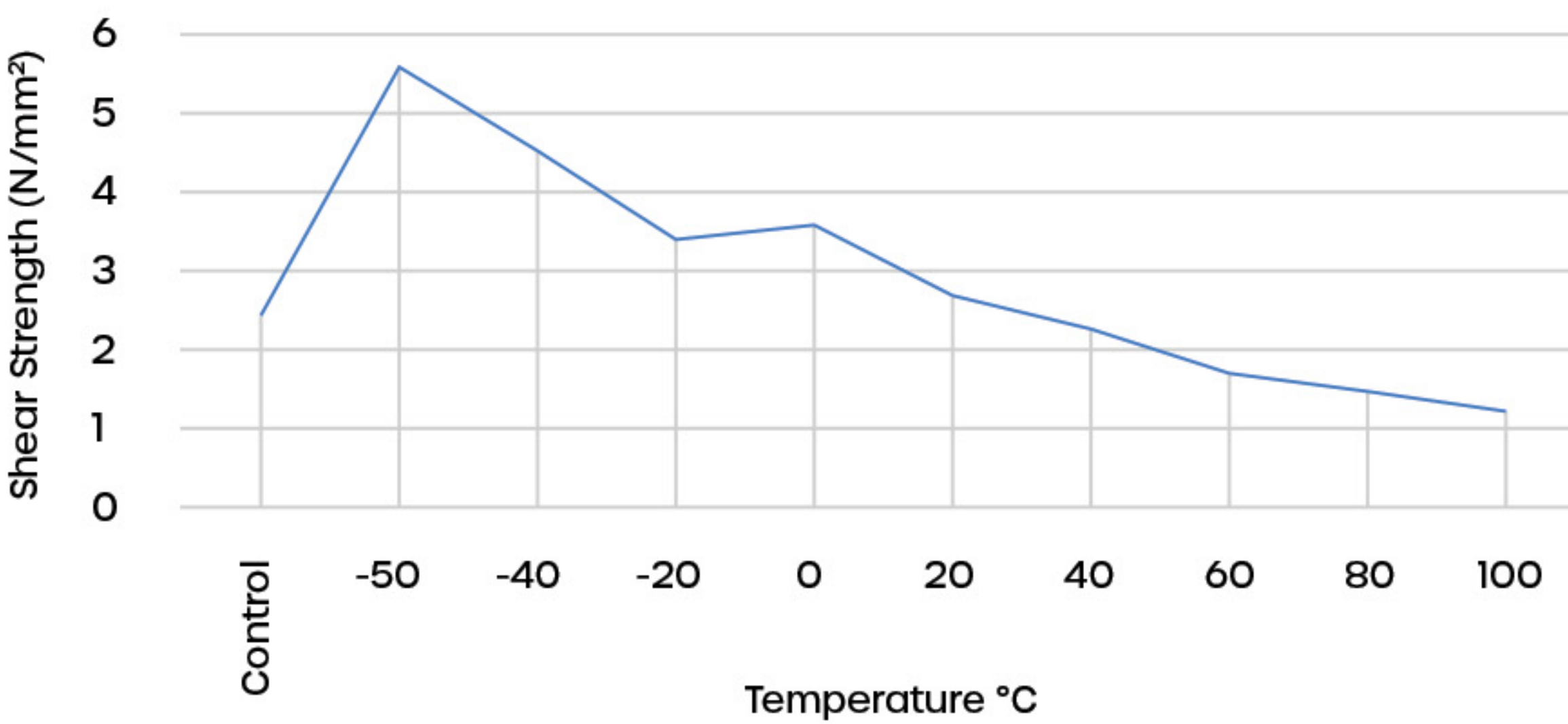
Elongation at break

(ASTM D1002)
25mm Overlapped Joint



Temperature Resistance

(ASTM D1002)



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Colours

White & Grey



Shelf Life

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

Application Instructions

Surface	Clean, dry, free of dust and grease
Preparation	When using Formoa 017 FE, Formoa Surface Activator may be used on non-porous surfaces to improve adhesion and performance We recommend test prior to application to ensure compatability
Bondline Thickness	We recommend a bondline thickness between substrates of at least 2mm

Volumes Available.

Cartridge
290ml



Foil
600ml



200L
on request

Resistance to Chemicals

Good resistance to water, aliphatic solvents, mineral oils, grease, diluted inorganic acids and alkalis.

Poor resistance to aromatic solvents, concentrated acids and chlorinated hydrogens.

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Substrates

Formoa 017 FE has excellent adhesion to the following surfaces

Metals such as:

Steel, AlMgSiI, Brass, Electro-galvaised Steel, AlCuMgI, Fire Retardant Galvanised Steel, Steel ST1403.

Plastics such as:

Polystyrene, Polycarbonate, (MarcolonR, LexanR), PVC, ABS, Polyamide, PMMA, GRP, Fibre Reinforced Epoxy and Polyester

Substrates with protective coatings or low surface energy will not have good adhesion with **Formoa 017 FE**. Polyethylene, Polypropylene and PTFE (Teflon) will have poor adhesion.

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 July 2023