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Code: RC-VE-21
Date of revision: Mar-01-2023
Version: 04

FORTA 802

1. IDENTIFICATION OF THE CHEMICAL AND SUPPLIER

Trade name: Forta 802
Product type: Acrílico Estructural
Company name: FORDEPRO SA de CV
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2. PRODUCT DESCRIPTION

Forta 802 is a methacrylate- based adhesive, 100% reactive with high hardness excellent impact, peel and shear resistance. The thixotropic formula prevents the mixture from sinking, getting excellent coverage and gluing on the pieces to be glued. Forta 802 bonds a wide variety of metals, thermoplastics, composite plastics, assembled products, wood and more, getting a fast and resistant bond.

Initial cure at 5 minutes, 70% of final strenght after 1 hour.

APPLICATIONS:

Ideal for adhesion of all materials such as:

- PVC,
- Polycarbonate,
- Acrylic,
- Glass fiber,
- Galvanized steel
- PPO, PBT
- ABS,
- FRT
- Polyurethanes
- Wood,
- RIM,
- Nylon,
- FRP
- Polyesters
- Gel coats
- Styrene
- Stainless steel
- Magnets

APPLICATIONS:

Excellent for repairing and/or gluing automotive components, sporting goods, appliances, computer assemblies, electrical components, furniture, marine assemblies, plastic fabrications, signs and displays, etc.

3. UNCURED ADHESIVE PROPERTIES

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Information	Resin base 802 A	Resin base 802 B
	Adhesivo	Activador
Appearance/ Colour	White	Light beige
Viscosity (cps @ 25°C)	80,000 – 100,000	80,000 – 100,000
Flash point (TCC)°C	--	10.55
Density (lbs/gal)	8.55	8.71
Mixture proportion	1	1

Properties of cured product

Viscosity of mixture (cPs):	210,000 – 250,000
Working time:	2 – 3 minutos
Initial cure:	10 min
Functional cure:	1 – 2 horas
Total cure:	24 hrs.
Service temperature	- 60 a 121 °C
Density of mixture (lbs/gal)	8.59
Solvent resistance	Good
Assembly time	4 minutes at 25 °C

4. CURED ADHESIVE PROPERTIES

Gap filling:	hasta .50 pulgadas
Hardness:	65 – 70 D
Elongation:	19%
Tensile strength:	4,200 psi
Tear strength:	15-21 pli
Adhesive strength (Steel/Steel)	3,950 psi
Adhesive strength (Al/Al)	>3,200 psi
Adhesive strength (ABS/PVC)	1,500 psi
Adhesive strength (Glass fiber)	>1,650 psi
Impact resistance	19 ft.lb./in.

5. APPLICATION METHOD

1. Surfaces must be clean, dry, free of grease and dust. A better result is achieved if you sand lightly before applying the adhesive on the surfaces to be glued.
2. Prepare enough product to fill or glue the pieces by pressing the two components (A + B) in the same ratio (1:1) on a tray*, Mix for about 15 seconds until you get a uniform color and mixture.
3. Apply the product on the piece to be repaired or on one of the parts to be joined and press lightly for a few seconds. Remove excess product.

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4. Wait 5 minutes until the adhesive reaches its initial curing, thus allowing the adhesive to take strength before making any movement or effort on the joined parts. Total cure is achieved within 24 hours.

* To prepare the mixture it is recommended to use a plastic base (polyethylene or polypropylene). The use of aluminum or copper material is not recommended to mix the product.

6. STORAGE AND SHELF LIFE

- Continuous storage at temperatures between 12°C and 24°C is recommended for a maximum shelf life of 8 months.
- Prolonged exposure above 24 °C will reduce the shelf life of this material.
- Prolonged exposure of activators, including cartridges containing activators, above 37 °C rapidly decreases product reactivity and should be avoided.
- Shelf life can be extended by storing at temperature from 7°C to 12.77°C.
- **These products should never be frozen.**
- Once mixed, do not return the unused material to the container, as it contaminates the remaining contents.

7. PRECAUTION

- High-strength Forta 802 adhesive has a methacrylate ester base and should be applied in a ventilated area, since mixing the adhesive Forta 802 A and B produces an exothermic reaction (with heat release) and in large quantities toxic and irritating gases are formed.
- This product is irritating for eyes and skin. In case of contact with the skin, rinse with water. In case of contact with eyes, rinse with water and seek for medical attention.
- Keep out of reach of children.
- Do not inhale methacrylate adhesive, as it is an irritating substance. Keep the container closed when not in use.

8. GENERAL INFORMATION

Product available in 400 mL presentation and 25 mL syringe.

For complete safety and handling information, please refer to the appropriate Material Safety Data Sheets before using this product.

WARRANTY: Six months. FORTA will replace any non-compliant material, according to specifications contained in this technical sheet. (To replace it is required the purchase invoice and that the product has the visible lot number)

Since the handling, storage and application of this material is beyond our control, we cannot accept any responsibility for the results obtained.