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## FORTA A93

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### 1. PRODUCT AND COMPANY INFORMATION

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<b>Trade name:</b>	Forta A93
<b>Category:</b>	Cyanoacrylate adhesive
<b>Company:</b>	FORDEPRO SA de CV
<b>Address:</b>	Blvd. Aristóteles 803 C, Col. La Joya C.P. 37358 – León – Gto. - México
<b>Telephone number:</b>	477) 777-5537
<b>E-mail:</b>	<a href="mailto:info@grupoforta.com.mx">info@grupoforta.com.mx</a>



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### 2. PROPERTIES OF UNCURED MATERIAL

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<b>Appearance:</b>	Clear liquid
<b>Viscosity 77°F (cPs):</b>	90 – 120 (Brookfield LVF, sp1 / 30 rpm) 70 – 110 (Brookfield LVDV, sp31 / 100 rpm)
<b>Set Time (s):</b>	≤ 20
<b>Boiling point (°C):</b>	> 85
<b>Shelf life at 6°C (month):</b>	12
<b>Soluble in:</b>	Mek, Acetone, Nitrometane.

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### 3. PROPERTIES OF CURED MATERIAL

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<b>Appearance:</b>	Clear solid
<b>Operating temperatura range (°C):</b>	-55-82
<b>Max gap fill (mm):</b>	0.1
<b>Shear strenght (kgf/cm2):</b>	> 100 (steel x steel)
<b>Full cure:</b>	24 hours
<b>Soluble in:</b>	Acetone, Nitrometane, DMF.

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### 4. TYPICAL PROPERTIES

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Forta F93 adhesive is a medium viscosity, fast curing, single component cyanoacrylate that provides a strong, long lasting bond.

Curing process starts as soon as cyanoacrylate adhesive get in contact with ambient humidity.

This product from the brand family FORTA is ideal for adhesion of porous materials as wood, paper, leather or even fabric. It is also highly recommended for industrial applications in which high performance is required.

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Date of revision: Jan-05-2021
Version: 03

Date of issue: 3/2011  
 Revision: 01/2021  
 In compliance with: NOM-018-STPS-2015

**5. TYPICAL CURING PERFORMANCE**

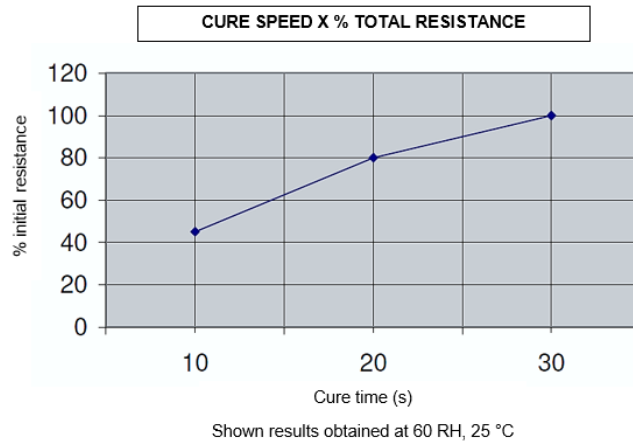
**Cure time (seconds):**

- Wood:** < 15
- Rubber:** < 10
- Plastic:** < 15
- Leather:** < 15

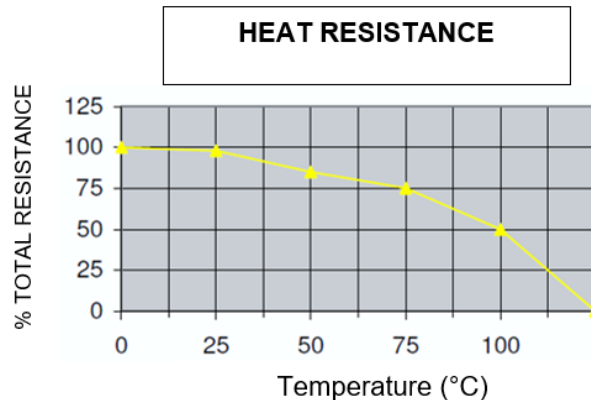
*\* If cure time is taking more time than indicated, due to low humidity or differences in materials to bond, it is recommended to use a FORTA primer before product application. It is important to know that this action could reduce the final shear strenght of the bond.*

At 22°C and relative humidity 50%, it is obtained a 0,1N/mm<sup>2</sup> shear strength, according ASTM D1002.

**Tensile strenght (ASTM - D1002)**  
**Steel- steel <sup>3</sup> 15N/mm<sup>2</sup> (total cure time 24 h)**



**6. HEAT RESISTANCE**



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**7. DIRECTIONS FOR USE**

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1. Protect the work surface against accidental spills, as cyanoacrylates can mark finishes and fabrics.
2. Clean and ensure a close fit on the surfaces to be bonded. Wiping wood with a damp cloth will increase bonding speed.
3. To use the clean and easy self-piercing tube, screw nozzle onto tube clockwise, hold base of nozzle and remove the cap counter-clockwise.
4. Apply the glue to one of the surfaces. Use sparingly, one square inch of surface area requires only one drop of glue.
5. Hold the surfaces to be bonded together for 15 to 30 seconds. No clamping is required, even on wood. **DO NOT REPOSITION THE PARTS.**
6. Replace the cap, and store the glue in a cool spot.
7. Allow the parts to cure overnight.

For product handling, it is recommended to wear personal care equipment. For safety information, please consult the Safety Data Sheet of the product.

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**8. STORAGE**

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For short- term storage, is recommended keep the product in a fresh, dry place between 2°C and 21°C for unopened containers.

For optimum storage stability refrigerate to 5 °C after opening the product.

Non- flammable.

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**9. GENERAL INFORMATION**

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Contact between cyanoacrylate and water produces an exothermic reaction, in which heat is released. Large amounts of the mixture may release toxic and irritating gases, skin and eye damage can occur. Do not inhale vapors of the product.

If spills or leakages occurs, add water from a safe distance, wait for 30 minutes and scrape the place with a metal spatula. Do not clean with absorbent paper or fabric.

The use of the product is not recommended in very humid environments.

**WARRANTY:** FORTA will replace any non- compliant material, according to specifications contained in this technical sheet.

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