

## PRODUCT

Formoa® 063 is a high quality, solvent free, single component joint sealant with high adhesive strength, developed for sealing and bonding applications in commercial vehicle and mass transportation industries. It is easy to extrude and tool up, has high specific adhesion, does not shrink on cure and has high UV resistance.

**063**  
**Formoa**



### Characteristics

- High bond strength.
- Excellent adhesion.
- High performance mechanical properties.
- Straightforward application even in adverse conditions.
- No bubble formation within sealant.
- Primerless adhesion.
- Very easy to tool and finish.
- Good extrudability.
- Ecological advantages - free of isocyanates, solvents, halogens and acids.
- Minimal health and safety considerations.
- Resistance to many chemicals.
- No staining of porous materials such as natural stone, granite, marble, etc.
- High UV performance.

### Applications

- Internal / external sealing and bonding applications in the automotive, mass transportation, commercial vehicle, caravan, marine, rail and aerospace industries.
- Sealing where a tough / flexible, anti-pick joint is required.
- Bonding of interior / exterior mouldings and sheet material.

### Technical characteristics

Base Material	Hybrid Polymer
Consistency	Stable Paste
Curing System	Moisture
Through Cure Rate (mm/24hrs)	3.5
Density (Kg/l)	1.58
Elasticity Modulus at 100% (N/mm <sup>2</sup> ) ISO 37	1.2
Elongation at Break (%) ISO 37	>480
Tensile Strength (N/mm <sup>2</sup> ) ISO 37	3
Max Open Time (mins)	30
Shear Strength (N/mm <sup>2</sup> ) ASTM D1002 - rate - 6mm/min	2
Shore A Hardness ±5	60
Skin Over Time (mins)	16
Viscosity C&P @ 0.6 s <sup>-1</sup> (Pa.s)	1500
Volume Alteration (%)	<1
Colour Stability UV Exposure ASTM G154 (CIELab - ΔE)	<1

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

## Packaging

<b>Colour</b>	White, black, grey and other colours on request.
<b>Contents</b>	290ml cartridge, 600ml foil pack, 200L on request.
<b>Shelf life</b>	12 months in unopened packaging, in a cool and dry storage place at temperatures between +5°C and +25°C.

## Substrates

<b>Nature</b>	Clean, dry, free of dust and grease.
<b>Priming</b>	When bonding, Formoa® Surface Activator may be used on non-porous surfaces. We recommend preliminary compatibility tests previous to application.

## Application

<b>Method</b>	Manual or pneumatic caulking gun.
<b>Application temperature</b>	+10°C until +30°C.
<b>Cleaning</b>	White Spirit or Formoa® Surface Cleaner immediately after application and before curing.
<b>Tooling</b>	Soapy solution before skin formation.
<b>Repair with</b>	Formoa® 063.

## Resistance to chemical agents

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

**Remarks** - Formoa® 063 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 alkyd resin based paints may increase. Formoa® 063 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® 063 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.

**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 November 2018

