



DATA SHEET

Fortafix High Temperature Adhesives

Application – Fortafix Fiborclad & Fortafix FlameBond Adhesives

- Stir/shake contents of the container prior to use, to ensure product is thoroughly mixed.
- If viscosity adjustment is required “L7 Thinners (FlameBond G1)” may be used.
- Thoroughly clean and degrease all surfaces to be bonded or sealed.
- A light surface abrasion of the material to be bonded will increase the surface area available for adhesion and improve mechanical key.
- Apply the adhesive/sealant as supplied (using a serrated spreader or mastic gun) to surfaces to be bonded and complete tooling within 5-10 minutes.
- Apply moderate pressure to ensure even anchorage and solid contact of the surfaces to be bonded, so that all surfaces are fully wetted.
- Secure components and allow the adhesive to set.
- All application equipment should be cleaned with warm water immediately after application.

Coverage Rate:

- 1 litre of adhesive paste will produce a coating 1 mm thick over an area of 1 sq. meter.
- 4-6 m²/litre: equates to a wet film thickness of 0.18mm-0.25mm per sq. meter of smooth surface.
- However the surface profile & surface adsorption characteristics of materials can vary
 - This will affect the coverage rate & adhesive consumption – typically:
 - High density materials > smooth surface profile + low surface adsorption > higher coverage rate
 - Low density materials > coarse surface profile + higher surface adsorption > lower coverage rate
- Highly porous or adsorptive surfaces can be primed & sealed using a diluted solution of L7 Thinners (FlameBond G1)

Application Conditions & ‘OpenTime’:

- The adhesive film forms, sets & hardens - by water loss to atmosphere & to the material substrate.
- In very warm atmospheres there is a greater tendency for the applied adhesive to dry at its exposed surface & consequently available ‘open time’ for use is reduced.
 - Higher temperature > quicker surface drying > shorter ‘open time’.
 - High density materials > smooth surface profile + low surface adsorption > longer ‘open time’
 - Low density materials > coarse surface profile + higher surface adsorption > shorter ‘open time’
- If necessary this can be retarded by the addition of a small percentage of clean water according to conditions prevailing at the time of application
 - The adhesive hardens by loss of moisture and too much added water may prolong hardening if the temperature reduces.
- The use of a serrated spreader or comb to produce a ‘ribbed’ applied film, which is broken by contact between joined materials – is helpful.