



A brand of MINKON

DATA SHEET

## Fortafix High Temperature Adhesives

### Product: Fortafix HT FlueSeal - High Temperature Flue Adhesive Sealant

#### Principal Characteristics

**Fire Protection: Non-combustible adhesive/sealant**

Water based. Ready to use. Cartridge applied. Pre-mixed Ceramic Adhesive paste to +1000°C.

**Will comply with BS 476: Part 4: Non combustibility test for materials & EN13501-1: Fire Test to Building Material - Class A1**

Flue Sealant – High temperature rigid seals for flues, stoves and other heating devices.

Maximum Continuous Service Temperature: +1000°C. Strong adhesive properties at all temperatures.

Specifically designed for use on all types of flues e.g. stainless steel, vitreous enamel coated flue, ceramic flue pipes, concrete & pumice block, etc.

Fortafix HT FlueSeal is water based and does not contain hydrocarbon resins or solvents.

Developed for improved cohesion, adhesion, and strength. Economical in cost and application

Air setting (time related) - to form hard and rigid ceramic mass which is resistant to fire & thermal shock.

Hardens by air drying and operational heat which improves and strengthens seals and joints.

Water resistance will be improved by the application of heat.

Colour - Black

Also suitable for Ceramic, Glass, Metals, Concrete, Stone, Silicate Fibre Materials, High Temperature

Thermal Insulation and many other industrial materials

#### Typical Applications

- Stove & Fire Installations
- Building & Construction
- Thermal Insulation Industries

#### Health and Safety / Environmental Information

- See separate MSDS sheet. (MSDS – Fortafix HT FlueSeal).
- RoHS Compliant.

## Guidelines for Use

### Application

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 as supplied to all 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.

### Curing Schedule

**This product is water based and can be air set** - depending on temperature, humidity, porosity of substrates, joint design, glue line thickness, volume of adhesive and area etc.

A rough guide for typical applications at room temperature and average humidity would be approximately 36-48 hours.

Full curing can be accelerated by the application of gentle and progressive heat.

Under these circumstances - care must be taken when initially raising the temperature through 100°C, as this may lead boiling of residual water in the glue line and product failure.

### Storage

Once opened, seal container, to avoid continuous exposure to air.

Cartridges should be stored in an upright position at all times.

Product should be stored in original packaging between 5 - 30°C.

Protect from freezing – may cause separation of components.

Shelf life – 12 months.



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### Characteristics:

Softening Temperature	<b>1000°C</b>	Melting Temperature	<b>1100°C</b>
Wet Density	<b>2.08 gcm<sup>-3</sup></b>	pH	<b>13</b>
Oxidation Resistance	<b>Excellent</b>	Alkali Resistance	<b>Can be re-dissolved at high pH</b>
Colour	<b>Black</b>	Acid Resistance	<b>Excellent except for hydrofluoric</b>
Packaging	<b>300ml Cartridge.</b>		

### Cartridge Applied Adhesive Sealant Bead Length (300 ml cartridge) Calculation

Bead Diameter mm	Bead Length m. from 300 ml Cartridge
<b>1.00</b>	<b>394.70</b>
<b>2.00</b>	<b>98.68</b>
<b>3.00</b>	<b>43.86</b>
<b>4.00</b>	<b>24.67</b>
<b>5.00</b>	<b>15.79</b>
<b>10.00</b>	<b>3.95</b>

Bead Diameter mm vs Bead Length m.

