FortaFix

A brand of MINKON

DATA SHEET

Fortafix High Temperature Adhesives

Product: FORTAFIX CHROMIX: 2-PART CHEMICAL SETTING ADHESIVE (Filler + Binder)

Principal Characteristics

Two Part Chemical Setting Adhesive Cement. (Filler + Binder system)

Water based. Ceramic Adhesive paste to +1400°C.

Chemical setting action - Sets to form hard and rigid ceramic mass.

Improved water resistance when compared to pre-mixed products.

Higher tensile and compressive strength than other 2-part adhesive/cements.

Suitable for Bonding, Thin Films/Coatings, Thick Sections and Potting/Encapsulation.

Excellent adhesive, thermal and mechanical properties.

Comparatively good abrasion and impact resistance.

High temperature gas tight seal.

Resistant to thermal shock.

Mixing ratio	2 part by weight Filler 1 part by weight Binder	**Pot Life @ 20°C**	15-20 minutes
Softening Temperature	1300°C	**Melting Temperature**	1400°C
Oxidation Resistance	Excellent	**Acid Resistance**	Excellent, except Hydrofluoric
pH	13	**Alkali Resistance**	Good
Colour	Grey/Brown	**Packaging**	1 litre - Binder 1 kg - Filler

Typical Applications

- **Foundries**
- **Molten metals industries**
- **Repairs to castings & mouldings**
- **Wear surface installations**

Minkon Ltd, Tofts Farm Industrial Estate, Brenda Road, Hartlepool. U.K. TS25 2BS
Tel: +44 (0)1429 273252 Fax: +44 (0) 1429 232611 e-mail: fortafix@minkon.co.uk
Web: www.minkon.co.uk www.fortafix.com

Health and Safety / Environmental Information

- See separate MSDS sheets. (MSDS – Fortafix Chromix Filler – Fortafix Chromix Binder).
- RoHS Compliant.

Guidelines for Use

Mixing Instructions

Mix binder and filler in a **ratio of 2 parts (by weight) filler: 1 part (by weight) binder.**

Weigh quantities precisely.

Add powder filler to liquid binder and **mix for 3-5 minutes** until a smooth homogeneous paste is formed.

Mixing equipment should be washed out immediately after use with water before adhesive hardens.

Note – The above consistency should provide a mix satisfactory for most applications. If required the binder content may be increased by up to 20% to meet special requirements, however, additional binder will increase setting time & drying shrinkage and may slightly reduce maximum service temperature.

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 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.

Curing Schedule

This product is water based, it is necessary to fully dry and dehydrate the adhesive for use at high temperatures.

Initial curing of this product may vary depending on temperature, humidity, porosity of substrates, 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 is achieved by the application of gentle and progressive heat.

Care must be taken when raising the temperature through 100°C during first curing as this may lead boiling of residual water in the glue line and product failure.

Partially cured product may be removed using warm water.

FortaFix

A brand of MINKON

DATA SHEET

Fortafix High Temperature Adhesives

Storage

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

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

Protect 'Binder' solution from freezing – may cause separation of components.

Shelf life – 12 months.

Minkon Ltd, Tofts Farm Industrial Estate, Brenda Road, Hartlepool. U.K. TS25 2BS
Tel: +44 (0)1429 273252 Fax: +44 (0) 1429 232611 e-mail: fortafix@minkon.co.uk
Web: www.minkon.co.uk www.fortafix.com