



Technical Data Sheet: FORMOA 055

Product Description

Formoa 055 is a single-component Hybrid Polymer adhesive. It is designed for primerless glass bonding with lower viscosity and increased cure speed.

Key Features

- High-performance mechanical properties
- Combines high-stiffness with very high-bond strength
- High green strength, quick build-up of end strength, high-shear strength after full cure
- Does not contain isocyanates, silicone, solvent
- Can be sanded after full cure
- Flexible elastic rubber - movement accommodation up to 20%
- No bubble formation within sealant (in high temperature and humidity applications)
- Very easy to tool and finish
- Colour stability and UV resistance
- Withstands all climatic conditions
- Minimal health and safety considerations



Applications

- For use in glass bonding applications in the car, coach, caravan, marine, train, aerospace industries, where a tough and flexible bond is required
- Structural elastic bonding between metal surfaces, coated surfaces and many plastics (not PE, PP, Teflon). • Structural bonding in vibrating constructions
- Backfilling / seaming between glass and body side

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Technical Characteristics

Formoa 055	Properties	Formoa 055
	Base Material	Hybrid Polymer
	Consistency	Stable Paste
	Curing System	Moisture
	Through Cure Rate (mm/24hrs)	3
	Density (g/ml)	1.43
	Elasticity Modulus at 100% (N/mm2) ISO 37	1.2
	Elongation at Break (%) ISO 37	>450
	Tensile Strength (N/mm2) ISO 37	>3.3
	Max Open Time (mins)	15
	Shear Strength (N/mm2) ASTM D1002 - rate 6mm/min	>2.5
	Shore A Hardness ±5	60
	Skin Over Time (mins)	14
	Viscosity C&P @ 0.6s (Pa.s)	3000
	Volume Alteration (%)	<1
	Colour Stability UV Exposure ASTM G154 (CIELab- AE)	<1

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

Substrates

Nature
Clean glass and body side frame using Formoa® Surface Activator. Allow 10 minutes to flash off and activate. A ‘milky’ white residue left on the glass is correct.

Priming
Non-fritted glass needs to be primed with Formoa® Primer PG (see TDS for Formoa® PG for application). We recommend preliminary compatibility tests previous to application.

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Colours

Black



Shelf Life

12 months in unopened packaging, in a cool and dry storage place at temperatures between +5°C and +25°C.

Application Instructions

Method	Manual or pneumatic applicator.
Application Temp	+5°C until +30°C
Cleaning	White Spirit or Formoa® Surface Cleaner immediately after application and before curing
Tooling	Soapy solution before skin formation
Repair with	Formoa® 055

Volumes Available.

Foil

600ml

200L

on request



Resistance to Chemicals

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® 055 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® 055 can be painted immediately after application “wet on wet” with water-based industrial paints in paint ovens at temperatures of up to 200°C for up to 45 minutes. Formoa® 055 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 to manufacturer, we recommend preliminary compatibility tests. See specific application instruction, available on request.

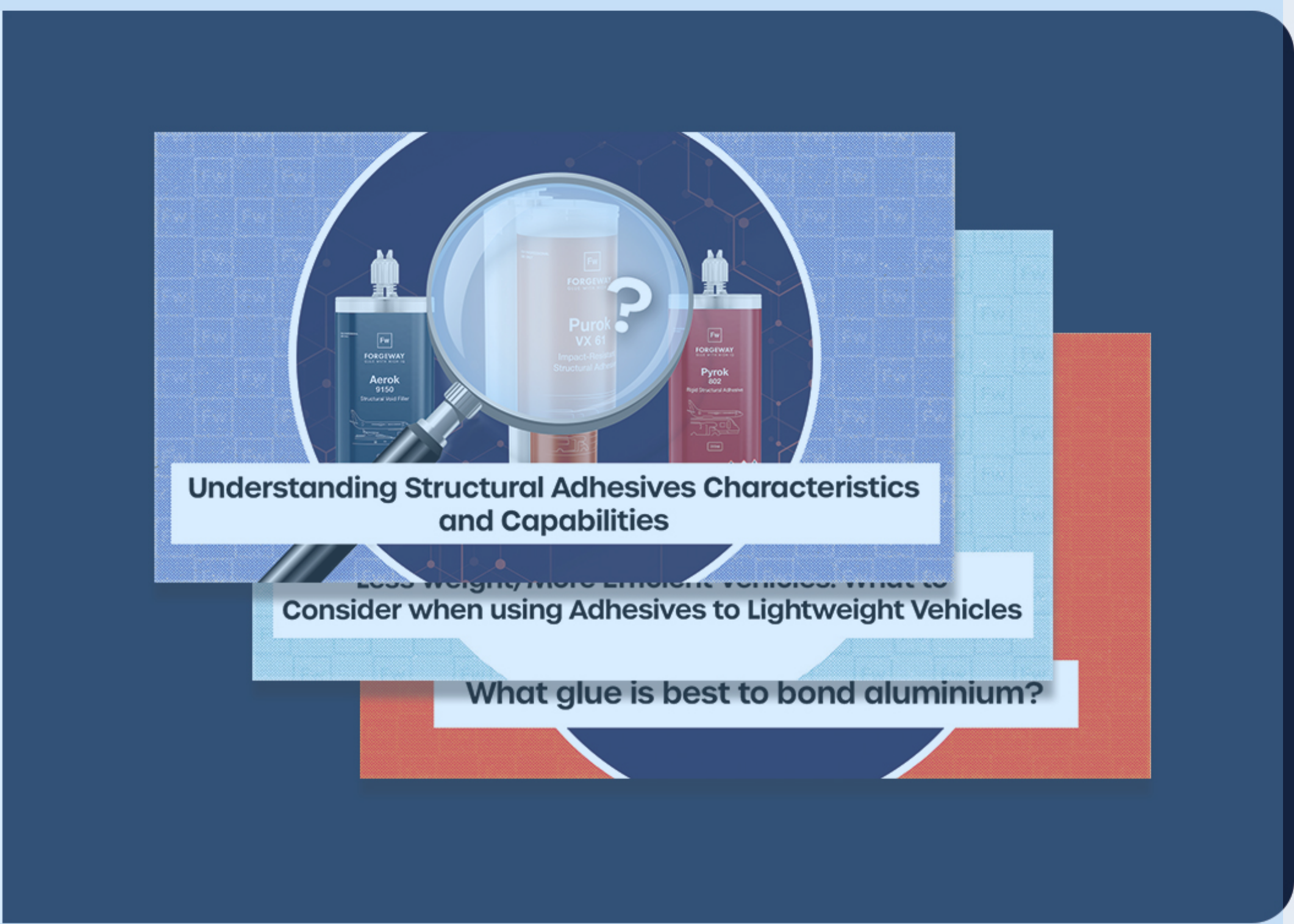
Disclaimer - The variability of materials, substrates and conditions of use is such that no warranty of their functionality for a specific application can be deducted from this information, written recommendation or any other type of suggestion offered. Each user has the responsibility to complete adequate 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 January 2021

Online Knowledge Centre

Our online knowledge centre has a large range of articles and product reviews to educate



Fundamentals of Adhesive eBook

Forgeways book "The Fundamentals of Adhesive" has over 200 pages full of in-depth adhesive and bonding knowledge.



Online Product Review

Watch our product review video for an easily digestible overview of the product and it's features.

