

Fortis PA75 is a premium fast drying PU heat reactivated adhesive. PA75 is a medium viscosity solvent based polyurethane adhesive (Isocyanate Free) that gives fast curing bonds to difficult substrates such as vinyl films and various types of rubbers and plastics.

Features and Benefits

- Excellent adhesion
- Excellent green strength
- Excellent sprayability
- Outstanding heat resistance
- Very good plasticizer resistance
- Low Staining
- Wet or heat activated bonding
- Use as 1 part or 2 part adhesive depending on performance requirements

Typical Applications

- Difficult to bond plastics and rubbers
- PVC inflatable boats
- PVC truck sidings
- Footwear
- Where high moisture resistance is required

Properties

- Application temperature: 5-30°C
- Colour: Clear
- Constitution: polyurethane rubber solvent
- Viscosity: 50-120 cps @ 20°C
- Coverage: 3-5 m²/L
- Composition: 1 or 2 Part
- Working Time: less than 5 minutes

Pack Size

20kg, 200kg

Shelf Life

12 months @ 25°C unopened

Safety

- Refer to Safety Data Sheet prior to use
- Good industrial hygiene practices should be observed at all times
- Appropriate PPE should be worn including impervious gloves & eye wear

Storage

Store in cool, dry conditions, out of direct sunlight and in a well-ventilated area. Do not store below 5°C or over 40°C

Surface Preparation

All surfaces to be bonded must be clean, dry and free of and any oils or grease. Smooth or polished surfaces should first be roughed with fine abrasive. If degreasing is necessary, a detergent/water treatment should first be considered. If this is inappropriate, a suitable solvent such as acetone may be used. It is advisable to check the effects of degreasing solvents on plastics, rubber materials and painted surfaces before carrying out the operations.

PVC: Rough lightly or wipe with a solvent.
 LEATHER: Roughen well , removing all pigment
 COATED FABRICS: Rough way synthetic coating or solvent wipe.
 RUBBER: Roughen the surface and wipe with acetone.
 POLYURETHANE: Roughen the surface and double wipe with acetone.

It is recommended that the glue be tested for a suitable bond to the substrate prior to application.

Application

Fortis PA75 may be applied by brush, roller-coater or automatic cementing machine. An even coat of adhesive should be applied to both surfaces and allow to dry for 10-15 minutes. The substrates should be reactivated at a temperature of no less than 55°C and pressed for 60 seconds at 80 PSI. Substrates may be pre-coated and stored for

short periods of time. For higher temperature resistance we recommend the use of Fortis Catalyst PA75 (contains isocyanate) at between 5-15% by weight.

Fortis PA75 may be diluted up to 50% for priming stitch sealing and strengthening ie patch Bonding. Important: dilution of the adhesive by any percentage reduces bond strength.

Clean-Up

While wet, adhesive can be cleaned with xylene or acetone. Cured adhesives can be removed mechanically, or softened with acetone and removed.

Limitations

For further information, including Safety Data Sheets and Technical Bulletins, refer to the Fortis website www.fortisadhesives.com.au.

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