

**Fortis PA75** is a premium fast drying heat reactivated PU adhesive. **Fortis PA75** is an isocyanate free medium viscosity solvent based polyurethane adhesive that provides 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 single part or 2 part (+PA75 Catalyst) adhesive system 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 m<sup>2</sup>/L
- Composition: 1 or 2 Part
- Working Time: less than 5 minutes

**Pack Size**

20kg, 200kg

**Shelf Life**

12 months @ 25°C unopened

**Safety**

- Fortis PA75 Catalyst contains isocyanates
- 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. Recommended treatment of some surfaces as follows:

- PVC: Rough lightly or wipe with a solvent
- Leather: Roughen well, removing all pigment
- Coated Fabrics: Roughen 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 adhesive 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 then 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, use of **Fortis PA75 Catalyst** at between 5-15% by weight.

**Fortis PA75** may be diluted up to 50% for priming stitch sealing and strengthening ie patch bonding.

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### Clean-Up

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

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### Limitations

Dilution of the adhesive by any percentage reduces bond strength.

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For further information, including Safety Data Sheets and Technical Bulletins, refer to the Fortis website [www.fortisadhesives.com.au](http://www.fortisadhesives.com.au).

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### Fortis Adhesives & Coatings Pty Ltd

ABN 65 1333 915 732  
14 Commercial Drive  
Dandenong South  
Victoria, Australia, 3175  
[www.fortisadhesives.com.au](http://www.fortisadhesives.com.au)  
+61 3 9706 5448

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