



ForzaTM

BOND | A FORCE TO BE RECKONED WITH

Industrial

R221



Modified Epoxy Adhesive



ForzaBOND® R221 is a two-part modified epoxy adhesive with moderate cure and a wide range of purposes.

Benefits

- 1:1 ratio, easy mixing/dispensing
- Minimal surface preparation required
- -75°F to 400°F service temp
- Retains flexible bond line, out performs most "brittle" two part adhesives
- Light stable and UV resistant
- Paintable
- 0 VOC
- Generates no heat
- 100% solids no shrinking

Product Application

- **ForzaBOND® R221** is a two-part 1:1 mix ratio that is available in dual cartridges or bulk.
- For cartridges: ensure flow from both sides of the cartridge. Attach static mixer and gun out material.
- Apply mixed adhesive to one surface to be bonded then mate second surface.
- Surfaces should be clean and dry and in most cases no abrasion or solvent wipe is necessary.
- Note: The B side will stiffen at temperatures below 32°F/0°C. The material may have to be heated to return to usable viscosity.
- For bulk: Ensure flow from both drums and in both hoses. Attach static mixer and gun out adhesive as desired.
- Apply to one surface to be bonded, then mate the second surface.
- Surfaces should be clean and dry.
- Use abrasive or solvent wipe only if necessary.
- Clean up with mineral spirits/wet rag.

Applications

ForzaBOND® R221 is ideal for the structural bonding of metals and other various materials in panel assembly. It is also suitable for the structural bonding of wood, ceramics, composites, concrete, and FRP, as well as combinations of these materials where a flexible bond line is desired.

Technical Data

Appearance:	Gray
Cure Time:	5 mins in mixer nizzle, allow 30 mins to handle
Elongation:	100%
Lap shear:	750 psi
Mixed Ratio:	1:1 by volume; 1:1.2 by weight
Solids:	100% reactive
Tensile Strenth:	825 psi
Viscosity:	Mixed gray approximately 260,000cps

Sizes

400ml Cartridge	52 Gallon Drum
5 Gallon Pail	

CREATING INDUSTRIAL ADHESIVE, TAPE, AND SEALANT SOLUTIONS THAT OUTPERFORM

402.731.9300
info@forzabuilt.com
www.forzabuilt.com



3211 Nebraska Ave, Suite 300
Council Bluffs, Iowa 51501